



GENERAL INFORMATION

LIC 20 is a general purpose epoxy enamel formulated to give outstanding gloss, chemical resistance, and adhesion over a variety of substrates. LIC20 is not recommended for applications requiring extended exterior exposure.



1. COMPONENTS

- LIC20 Epoxy Enamel Color
- EK20 Epoxy LIC Activator
- X01 Fast Exempt Uni-Solvent LV
- X02 Medium Exempt Uni-Solvent LV
- 171 Fast Uni-Solvent up to 75°F (24°C)
- 172 Medium Uni-Solvent 75°-85°F (24°-29°C)
- 173 Slow Uni-Solvent 85°-95°F (29°-35°C)
- 174 Very Slow Uni-Solvent 95°F (35°C) and over
- LICR70 Multi Purpose Reducer - Fast
- LICR80 Multi Purpose Reducer - Medium
- LICR90 Multi Purpose Reducer - Slow



2. MIXING RATIO

LIC20 Epoxy Enamel must be activated. Mix 1 part LIC20 Base Color to one (1) part EK20 Activator. Use unreduced for brush, roll, or airless spray. For air spray, reduce 25% with solvents or reducers listed above.

USA VOC compliant rules:

For VOC 3.5 compliant use Uni-Solvent LV X01 or X02.
For VOC national rule use solvents or reducers listed above.



3. POT LIFE @ 77°F (25°C)

6 hours



4. CLEAN UP

Uni-Solvent 171-174 or Uni-Solvent LV X01, X02 (check local regulations).



5. SURFACE PREPARATION

USE RECOMMENDED UNDERCOAT SYSTEM FOLLOWING RECOMMENDED PROCEDURES.



- Abrade with 240 grit dry sandpaper or equivalent.
- Wipe with AquaClean 170.
- For best results apply anti-corrosive primer such as LIC P Series epoxy primer.



6. SUBSTRATES

- LIC Epoxy Primer
- Non-reversible existing finishes in good condition
- Properly Prepared Steel and Aluminum



7. APPLICATION

May be applied by brush, roll, or spray. Brushing or rolling recommended only on small areas. Use unreduced for brush, roll, and airless spray. Apply with a foam or cigar roller. Load roller with paint and apply with a gentle surface pressure. (Do not press the roller firmly on the surface.) Use airless spray tips between .013" and .017" in diameter, depending on spray pressure and job conditions.

For Air Spray:

- Spray 2 - 3 medium wet coats
- Allow 10 -15 minutes flash time between coats



8. FLASH / DRY TIMES

AIR DRY @ 77°F AND 85% R.H.

Tack Free	2 Hours
To Tape	6 Hours
To Recoat	16 Hours



9. GUN SET UP

CONVENTIONAL

Gravity Feed 1.5 mm - 1.8 mm

Siphon Feed 1.6 mm - 1.8 mm



HVLP

Gravity Feed 1.3 mm - 1.5 mm

AIR PRESSURES

Gravity Feed 35-40 psi (2.5-2.8 bar)

Siphon Feed 35-45 psi (2.5-3.1 bar)

HVLP Inlet Air 30 psi (2.0 bar)

See spray gun manufacturer info



10. PHYSICAL DATA

VOC (Volatile Organic Content)	3.5 lbs/gal (420 g/L) max
Volume Solids	52% Average
Flash Point	55° F / 13°C
Theoretical Coverage	833 sq. ft. per mil/25 µm per gallon