



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 Reducer
- X02 Medium Exempt Reducer
- 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 Exempt Reducers 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 Exempt Reducers 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

RTS REGULATORY DATA	1:1:0-25%		1:1:0-25%	
	(170, LIC Reducer Lines)		(Exempt Reducer Line)	
	LBS./GAL.	g/L	LBS./GAL.	g/L
Actual VOC	5.0 Max.	600 Max.	3.15 Max.	378 Max.
Regulatory VOC (less water and exempt solvents)	5.0 Max.	600 Max.	3.5 Max.	420 Max.
Density	8 - 12	960 - 1440	8 - 12	960 - 1440
	WT. %	VOL. %	WT. %	VOL. %
Total Volatile Content	40 - 60	50 - 65	35 - 60	45 - 65
Water Content	0	0	0	0
Exempt Compound Content	0 - 5	0 - 5	10 - 30	10 - 30
Coating Category	Single-Stage Coating			

If used as instructed, this product is designed to comply with the US National Volatile Organic Compound (VOC) Emission Standard for Automobile Refinish Coatings. Confirm compliance with state and local air quality rules before use. The data on this sheet represent typical values. Since application variables are a major factor in product performance, this information should serve only as a general guide. Valspar assumes no obligation or liability for use of this information. **UNLESS VALSPAR AGREES OTHERWISE IN WRITING, VALSPAR MAKES NO WARRANTIES, EXPRESS OR IMPLIED, AND DISCLAIMS ALL IMPLIED WARRANTIES INCLUDING WARRANTIES OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR USE OR FREEDOM FROM PATENT INFRINGEMENT. VALSPAR WILL NOT BE LIABLE FOR ANY SPECIAL, INCIDENTAL OR CONSEQUENTIAL DAMAGES.** Your only remedy for any defect in this product is the replacement of the defective product, or a refund of its purchase price, at our option.