

## Supreme PLUS Acrylic 2K Single Stage U.S. National Rule VOC

**Description:**

Limco Supreme PLUS U.S. National Rule Topcoat is a specially formulated Acrylic 2K Single Stage system designed to meet the rigorous demands of Refinish, Commercial Vehicle, Agricultural and Fleet markets. Limco Supreme PLUS U.S. National Rule Acrylic 2K Single Stage Topcoat dries quickly to a dust-free surface with excellent flow and leveling, good hiding and mirror-like gloss. The Supreme PLUS U.S. National Rule Acrylic 2K Single Stage Topcoat film is also chemically resistant and has superior hardness.

**Materials:**

Supreme Bases:	LA & LIB Bases
Supreme Grab & Go Colors:	G Bases
Acrylic 2K Mixing Clear:	LA3899
Hardeners:	LHF
	LHM
	LHS
Reducers:	LR10
	LR11
	LR12
	LR13
	LR15

**Substrates prepared for topcoating:**

**Finish Sanding**

Well cured old paint work	P500 grit
Primer Surfacer 800K	P320 - P500 grit
Primer Surfacer 846	P320 - P500 grit
Primer Surfacer LP20	P320 - P500 grit
Primer Surfacer LP620	P320 - P500 grit
Primer Sealer LP20	Sanding not required
Primer Sealer LP620	Sanding not required
Primer Sealer LS56	Sanding not required
Primer Sealer LS800	Sanding not required
Primer Sealer PS21NR	Sanding not required

**Remarks:**











Always check local VOC laws to ensure that the use of these Limco products is compliant in your area.

To retrieve color information from BASF color retrieval software, use paint line SA2K.

For custom Supreme PLUS Acrylic 2K (600 gms/liter) colors, the color (LA, LIB, G bases) must be mixed 1 part to 1 part of LA3899 by volume prior to addition of hardener and reducer.

# TECHNICAL DATA

## Supreme PLUS Acrylic 2K Single Stage U.S. National Rule VOC

	<b>Mixing ratio:</b>	8:1:1
	<b>Color</b>	8 parts Color
	<b>Hardener</b>	1 part LHF, LHM or LHS
	<b>Reducer</b>	1 part LR10, LR11, LR12, LR13 or LR15
	<b>Potlife at 68°F/20°C</b>	2 - 4 hours
	<b>Spray viscosity Ford #4 @ 68°F/20°C</b>	14 - 16 seconds
	<b>Gravity gun nozzle HVLP</b>	1.3 - 1.7 mm
	<b>Spray pressure HVLP at the cap</b>	6 - 10 psi
	<b>Application</b>	2 - 3 wet coats
	<b>Flash-off time @ 68°F/20°C</b>	5 minutes between coats
	<b>Film build</b>	2.0 - 3.0 mils
	<b>Coverage</b>	634 - 658 sq. ft./gal @ 1.0 mils
	<b>Drying:</b>	
	<b>68°F/20°C</b>	30 - 45 minutes dust free; 4 - 6 hours tack free
	<b>140°F/60°C</b>	30 minutes
	<b>Infra red short wave</b>	N/A
	<b>Infra red medium wave</b>	N/A
	<b>Sanding:</b>	
	<b>Wet by Hand</b>	N/A
	<b>Dry by Hand</b>	N/A
	<b>Dry by Machine</b>	N/A
	<b>VOC as applied</b>	≤ 600 gms/liter (≤ 5.0 lbs/gal)
	<b>Comments</b>	Shake new tinting bases for 15 minutes using a mechanical paint shaker before placing on a mixing machine.  Tinting bases on a mixing machine need to be agitated for 15 minutes at the start of the work day and every 4 hours during the day to ensure good color matching.