

Product Data Sheet

Awlcraft 2000



Intended Uses

Awlcraft 2000 is a two component, premium polyurethane finish that is easy to apply and delivers a high gloss finish in a wide range of colors with enhanced color and gloss retention.

- * Provides a buffable, high gloss finish
- * Fast drying and easy to apply
- * Can be used with a wide range of reducers for a flexible application

Spray application only. Do not use below the waterline.

Specification Data

Volume Solids	44.5% (average, unthinned)
Specific Gravity	1.09 (average, unthinned)
Available Packs	1 US Gallon, 1 US Quart
Base	Awlcraft 2000 (range of colors)
Converter	Awlcat #2 (G3010)
Reducer	T0001 - Fast Evaporating Reducer-Spray T0002 - Very Fast Evaporating Reducer-Spray T0003 - Standard Reducer-Spray T0005 - Hot Weather Reducer - Spray
Equipment Cleaning	OT0001, OT0002, OT0003

Theoretical Coverage

Application Methods	Number of Coats	Recommended Per Coat			Theoretical Coverage Per Coat (at recommended DFT)
		WFT	DFT	Max DFT	
Air Atomized	3	56 µm 2.2 mil	25 µm 1 mil	35 µm 1.4 mil	17.8 m ² /lt 725.2 ft ² /Gal

Calculated for mixed base and converter, unthinned.

Coverage calculations are based on theoretical transfer efficiency of 100%. Actual coverage rate obtained will vary according to equipment choice, thinning, application techniques, part size and application environment.



VOC

All VOC information contained herein is theoretical (unless otherwise stated). Actual VOC content may vary by batch from one color to another and when tested via standard test methodology.

Typical VOC for Awlcraft 2000 Bases range between 413 and 486 g/L. VOC for mixed, unthinned product range between 472 and 520 g/L.

Product	As Supplied (without reducer)			
	g/L	lb/gal	g/Kg	lb/lb
OG3010	589	4.92	593	0.59
Awlcraft 2000	496	4.14	453	0.45



Surface Preparation

The surface preparation advice provided, and equipment suggestions, can be used as a guide. Preparation techniques and results will vary according to individual conditions, equipment choice/condition and other factors. Testing on a non-critical area should be carried out prior to full-scale preparation.

Best results are achieved when sprayed over properly prepared 545 Epoxy Primer, Quick Build or 321 HS Undercoat. May be applied directly over some existing finishes. The existing finish must be sound, tightly adhered to the substrate, and chemically compatible with Awlcraft 2000.



Mixing & Reduction

Mixing and reduction requirements will vary according to individual conditions, climate, equipment choice/condition and other factors. Mixing and application of a small sample before full-scale application is recommended.

Application Methods	Mix Ratio (Base:Converter)	Reducer	Recommended Thinning	Spraying Viscosity
Air Atomized	2:1 by volume	T0001	0 - 33 %	11 - 14 seconds DIN 4 cup
Air Atomized	2:1 by volume	T0003	0 - 33 %	11 - 14 seconds DIN 4 cup
Air Atomized	2:1 by volume	T0002	0 - 33 %	11 - 14 seconds DIN 4 cup
Air Atomized	2:1 by volume	T0005	0 - 33 %	11 - 14 seconds DIN 4 cup

Mix by volume two parts Awlcraft 2000 Base with one part Awlcat #2 (G3010) Spray Converter to a smooth, homogenous mixture.

Reducer addition level required to achieve 11-14 seconds viscosity DIN4 or equivalent (16-18 seconds viscosity Zahn 2) varies color to color.

For standard air atomized application this can be attained by adding up to 33% reducer, using the correct spray reducer appropriate for conditions. Clear coats and painting in high temperature conditions may require additional reduction.

For example, if a 25% reduction is used, overall mix is 2:1:¼ by volume (8 oz. Base, 4 oz. G3010, 3 oz. Reducer or 2L Base, 1L G3010, 0.75L Reducer).

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Application

Application equipment and parameters are given as a guide. Actual equipment choices will vary according to application conditions, equipment condition and other factors. Testing on a non-critical area should be carried out prior to full-scale application. Contact your local technical service representative for further advice if necessary.

General: The primed surface must be clean and dry. Achieving maximum gloss and distinction of image requires the primer be smooth sanded with 320 grit paper before topcoat application. Smooth sanding until all the "guide coat" is removed indicates a texture free surface.

Apply a smooth, wet coat to the surface. Allow coat to "flash off" 15–45 minutes. Then apply a full, wet coat to achieve color coverage and film thickness requirements. Allow the second coat to "flash off" 30–45 minutes until only slightly tacky before applying a third coat. For best results, coats two and three should be applied wet for the paint film to fully coalesce and level. However, take care not to overapply which could lead to sagging of the topcoat.

Typically three coats are recommended for spray applications. Spray applying certain colors may require 4 or more coats to obtain full hide (opacity) or color coverage.

Application Methods	Fluid Tip	Fluid Pressure	Fluid Flow Rate	Air Pressure
Air Atomized	1.00 - 1.20 mm 39 - 47 thou	-	200 - 300 cc/min	2 - 2.5 bar 29 - 36 psi

For specific equipment setups, please contact your local technical sales representative, the equipment manufacturer or your distributor.



Recoatibility & Drying Times

The data given for recoatability is not exhaustive. Actual recoatability can vary according to individual conditions, climate and surroundings. If unsure, consult your local technical service representative before proceeding.

Typical spray applications consist of three coats applied over 1-4 hours. Exact time will vary with temperature, project size, and film thickness applied. Awlcraft 2000 topcoats which have been allowed to cure more than 24 hours must be sanded before recoating.

Drying	15°C (59°F)	25°C (77°F)	35°C (95°F)
Tape Free		24 Hours	
Hard Dry		24 Hours	
Light Service		3 Days	
Cure Time		14 Days	
Pot Life		7 Hours	

Overcoated By	15°C (59°F)		25°C (77°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max
Awlcraft 2000	1 Hours	24 Hours	30 Minutes	24 Hours	30 Minutes	24 Hours



Warning Notes

Do not apply paint materials to surfaces less than 5°F (3°C) above dew point, or to surfaces warmer than 105°F (41°C). Ambient temperature should be minimum 55°F (13°C) and maximum 105°F (41°C).

The information in this Product Data Sheet is not intended to be exhaustive. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk and, to the extent permitted by law, we can accept no responsibility for the performance of the product or for any loss or damage arising out of such use. The information contained in this Product Data Sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

Please refer to your local representative or visit www.international-yachtpaint.com for further information.

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