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#### 4. **AWLGRIP PAINT SYSTEM FOR ALUMINUM SUBSTRATES (WITH 545 PRIMER)**

##### **SURFACE BELOW THE WATERLINE:**

- 4.1. Thoroughly degrease the surface using **Surface Cleaner T-340**.  
Grind with 36 grit sandpaper or sandblast to bare aluminium.  
If necessary acid wash the surface with **Deoxidine**.  
Wash in sections starting from the lower sections and working upwards.  
Do not let the Deoxidine dry and rinse thoroughly with water.  
This is most important !  
When the substrate is completely dry proceed.
- 4.2. Prime immediately with **Awlgrip 545 Anti-Corrosive Epoxy Primer Gray**. Allow 2 hours minimum between coats at 20°C. Allow to cure 12 - 14 hours.

Base	: Gray D1001
Converter	: D3001
Reducer	: up to 25 % T0006 (min. 10 % T0006)
Induction time	: 15 minutes
Recommended film thickness	: ± 250 micron wet = 75 micron dry (calculated for mixed base and converter reduced 25 %)

Sand with 80 - 120 grit paper. Do not break through to bare metal! Should you break through, reprime these areas immediately with Awlgrip 545 Gray Primer.

- 4.3. Apply by trowel, as necessary, **Awlfair Trowelable Fairing Compound Light Weight:**

Base	: D8020 White
Converter	: D7007 Red
Mixing ratio	: <u>1/1 by volume</u>
Color	: pink
Induction time	: no induction period needed
Potlife	: 30 - 45 minutes

Mix by volume 1 part D8020 with 1 part D7007 converter. Mix well until a uniform pink color is obtained. Mixing must be thorough to insure a good cure. Awlfair can be sanded after a drying period of 24 hours at 20°C. Blocksand the Fairing Compound with grit 40, 60 or 80 in between the coats and before each next step. Remove all sanding residue with clean dry compressed air before each next step.

Before proceeding to next coat, make sure no surface contamination is present.

***Do not add thinners or reducers to the Awlfair Fairing Compound !***



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- 4.4. Cover the fairing system with one coat of **Awlgrip Hull-Gard ER Epoxy Primer**. Hull-Gard ER can be applied by roller or spray:

Base plus Converter	: 73057
Mixing ratio	: 9/1 by volume
Reducer	: not necessary - however if wanted <u>not more</u> than 10% T0006 in volume.
Induction time	: 30 minutes
Recommended film thickness	: 150 micron wet = 75 micron dry
Color	: yellow

Roller application requires at least 2 coats. Allow a drying time of 3 hours at 20°C in between coats.

Allow a drying time of minimum 3 hours / maximum 8 weeks at 20° C before proceeding. If 8 weeks are exceeded, please contact your U.S. Paint representative.

- 4.5. Apply **Hull-Gard WB** in multiple coats up to a total dry film thickness of 400 micron. 2 to 4 coats may be required depending upon reduction and method of application. Allow a minimum of 5 hours and maximum of 24 hours at 20°C. between coats.

Base plus Converter	: Black 73152 White 73128
Mixing ratio	: 4/1 by volume
Reducer	: not necessary - however if wanted <u>not more</u> than 20% T0006 in volume
Induction time	: 15 minutes
Recommended film thickness	: 200 micron wet = 150 micron dry.

***The total thickness of Hull-Gard WB should be minimum 300 micron dry !***

- 4.6. Apply Anti-Fouling according to the directions of the manufacturer.

**Note :** In case no fairing is required, after step 4.2. (application of 545 Primer), one can proceed with step 4.4. (application of Hull-Gard ER). In between 545 Primer and Hull-Gard ER allow overcoating time of 12 hours minimum and 24 hours maximum at 20°C. If the overcoating time of 24 hours is exceeded the 545 Primer needs to be sanded with grit 100-150 prior to the application of the Hull-Gard ER.