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3. AWLGRIP PAINT SYSTEM FOR ALUMINUM SUBSTRATES (WITH 545 PRIMER)

SURFACE ABOVE THE WATERLINE

3.1. Thoroughly clean and degrease the surface using **Surface Cleaner T340**.

Grind with 36 grit sandpaper or sandblast to bare aluminum.

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 :

3.2. 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.

3.3. 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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- 3.4. Apply one layer of **Ultra-Build Epoxy Primer** in 2 or 3 coats with a drying time in between the coats of minimum 2 hours and maximum 12 hours at a temperature of 20°C.

Base White	: D8008
Converter	: D3018
Mixing ratio	: 1:1 in volume
Reducer	: 5-10% with T0073
Induction time	: 15 minutes after mixing
Recommended film thickness	: 625 - 750 micron wet = 375 - 500 micron dry

After drying sand the surface with grit 120. Remove all sanding residue with clean dry compressed air thoroughly and use **Surface Cleaner T340** and in case of high humidity / dew point **Awl-Prep T0008** to clean the surface. Use the two cloth method. Make sure no oily type of contamination is present.

- 3.5. Apply one coat of **Awlgrip 545 Anti-Corrosive Epoxy Primer** Gray or White.

Base	: White D8001 Gray D1001
Converter	: D3001
Reducer	: up to 25% T0006 (min. 10 % T0006)
Induction time	: 15 min.
Recommended film thickness	: 175 - 250 micron wet = 50 - 75 micron dry (calculated for mixed base and converter reduced 25%)

If necessary in order to cover sanding scratches, more coats can be applied. Allow a drying time of minimum 8 hours and maximum 24 hours at 20°C. in between the coats.

Sand the 545 Primer with 220-400 grit paper. This is necessary to provide a smooth surface for topcoat application.

Remove all sanding residue with clean dry compressed air and use **Surface Cleaner T340** and in case of high humidity / dew point **Awl-Prep T0008** to clean the surface. Use the two cloth method. Use **Awlgrip 73009 Premium Tack-Rags** prior to topcoating. Check the cleaned surface.

- 3.6. To obtain gloss, depth, and complete coverage apply **Awlgrip Topcoat** as follows:

Using recommended spray equipment, apply a light, smooth, slightly wet tack coat to the surface. Allow tack coat to 'flash off' 30 to 45 minutes. Then apply a full coat to achieve color coverage (i.e. hide) and film thickness requirements. If preferred, three coats may be used.

Allow the second coat to 'flash off' 30 to 45 minutes until only slightly tacky before applying third coat.



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Topcoating cannot be done in one coat!

Base	: see color card
Converter	: G3010
Mixing ratio	: 1/1 by volume
Reducer	: \pm 25% T0001 below 21°C. \pm 25% T0003 above 21°C.
Induction time	: none
Recommended film thickness	: 150 - 200 micron wet = 50 - 75 micron dry

For application of **Awlgrip Topcoat** by brush :

Base	: see color card
Converter	: H3002
Mixing ratio	: 2/1 by volume
Reducer	: 10-20% T0031
Induction time	: 15 minutes
Recommended filmthickness:	wet 100 - 150 micron = 50 - 75 micron dry

Do not paint below a temperature of 18° C !

- **Note** : Some colors may require more than 75 micron of dry film to achieve full hide or opacity, extra coats may be needed to achieve a dry film thickness greater than 75 micron.