



Bouwvelven 1
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15. AWLGRIP PAINT SYSTEM FOR COMPOSITE PEEL-PLY SUBSTRATES

SURFACE BELOW THE WATERLINE

15.1. Immediately after removal of the Peel-Ply, **Hull-Gard ER Epoxy Primer** has to be applied.

It is important to apply the **Hull-Gard ER** directly after removal of the Peel-Ply as it is nearly impossible to degrease the surface with the two-cloth method prior to sanding. Reason for this is that the composite surface is too rough to allow this. Please contact your nearest **Awlgrip** distributor or U.S. Paint head office in case of difficulties or advise on the above matter !

As composite substrates vary in composition and in order to be sure that the underneath described Awlgrip paintsystem is suitable for the Peel-Ply substrate at issue, it is highly recommended to perform an adhesion tests with **Hull-Gard ER Epoxy Primer** prior to the application of the Awlgrip system !

15.2. Apply 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 / 8 weeks at 20°C before proceeding. If 8 weeks are exceeded, please contact your U.S. Paint representative.

Allow a drying time of minimum 3 hours at 20° C before proceeding.

15.3. 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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15.4. 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 / 8 weeks at 20°C before proceeding. If 8 weeks are exceeded, please contact your U.S. Paint representative.

Allow a drying time of minimum 3 hours at 20° C before proceeding.

15.5. 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 !

15.6. Apply **Awl-Star Gold Label Anti-Fouling** as soon as the last coat of **Hull-Gard WB** is barely tackfree (i.e. approximately 4 hours) but still soft enough to allow indentation with a fingernail. If one is not able to apply Awl-Star Gold Label when the Hull-Gard WB is barely tack free, apply a light coat of Hull-Gard ER within 24 hours of the last coat of Hull-Gard WB. Awl-Star Anti-Fouling should be applied when this last coat of Hull-Gard ER is barely tack free.

Gold Label Anti-Fouling can be applied by brush, roller, conventional- or airless spray.

Code	: BP201 Charcoal Black BP401 Medium Green BP501 Light Blue BP502 Deep Blue BP701 Red BP802 White Lightning
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Recommended film thickness	: 200 - 250 micron wet = 100 - 125 micron dry
Total recommended film thickness	: 250 - 300 micron dry



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In between the different coats of **Awl-Star Gold Label Anti-Fouling** a drying time of minimum 5 hours at 20°C must be respected.

Allow overnight drying time at a temperature of 21°C before launching.

Note : In case no fairing is required, after step 15.2. (application of Hull-Gard ER), one can proceed with step 15.5. (application of Hull-Gard WB).