



Bouwvelven 1  
B - 2280 Grobbendonk  
Belgium

Tel. +32 14 230001  
Fax +32 14 230880

## 7. AWLGRIP PAINT SYSTEM FOR NON-ANODIZED ALUMINUM MASTS

- 7.1. Thoroughly clean and degrease the surface using **Surface Cleaner T340**.  
Sand the surface by using Scotchbrite together with **Deoxidine**.  
After maximum 4 minutes rinse the surface thoroughly with water.  
Do not let the Deoxidine dry !  
This is very important !

### **Caution :**

Allow the mast to dry thoroughly. Remove all dust from seams, joints, etc. with compressed air prior to proceed subsequent painting job.

- 7.2. Prime immediately with **30-Y-94 Non-Sanding Mil-Spec Anti-Corrosive Epoxy Primer**.

Base	: S9001
Converter	: S3001
Mixing ratio	: 1/1 by volume
Reducer	: 50 % T0006
Induction time	: 15 minutes
Recommended film thickness	: 75 micron wet = 20 micron dry.

Allow the 30-Y-94 primer to dry for a minimum of 3 hours at 20°C. **Mil-Spec 30-Y-94 Primer** must be overcoated within 3 - 6 hours of application. Do not sand the **Mil-Spec 30-Y-94 Primer** !

- 7.3. Apply **Awlgrip 545 Anti-Corrosive Epoxy Primer** Gray or White. Allow 2 hours minimum between coats at 20°C. Allow to cure 12 - 14 hours.

Base	: Gray D1001 White D8020
Converter	: D3001
Reducer	: up to 25 % T0006 (min. 10 % T0006)
Induction time	: 15 minutes
Recommended film thickness:	175 - 250 micron wet = 50 - 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.



Bouwvelven 1  
B - 2280 Grobbendonk  
Belgium

Tel. +32 14 230001  
Fax +32 14 230880

7.4. Apply by trowel, as necessary, **Awlfair Trowelable Light Weight Fairing Compound.**

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

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

7.5. 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)
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 coats.

Sand the 545 with 220 - 400 gritpaper. 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**. Check the cleaned surface.

7.6. 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.

***Topcoating can not be done in one coat !***



Bouwvelven 1  
B - 2280 Grobbendonk  
Belgium

Tel. +32 14 230001  
Fax +32 14 230880

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: 100 - 150 micron = 50 - 75 micron dry

***Do not paint below a temperature of 18 °C !***

**SPECIAL NOTE :**

**Anodized aluminum**

De-anodize the aluminum surface with a solution of 33 % Natrium Hydroxyde.  
Treat the surface by washing the aluminum with the Natrium Hydroxyde for  $\pm 10$  min.  
Do not let the Natrium Hydroxyde solution dry on the surface !! Rinse thoroughly with plenty of fresh tapwater !

**After this chemical treatment follow step 7.1**

**\* Notes :**

- 1) Some colors may require more than 75 micron of dry film to achieve full hide or opacity.  
Please note, extra coats may be needed to achieve a dry film thickness greater than 75 micron.
- 2) In case no fairing is required, after step 7.3 (the application of the 545 Primer), one can proceed with step 7.6. (the application of the Awlgrip Topcoat).