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9. AWLGRIP SYSTEM FOR OLD & NEW POLYESTER BOATS

(MAXIMUM BARRIER SYSTEM)

SURFACE BELOW THE WATERLINE

- 9.1. **New boats:** Degrease the gelcoat very thoroughly with **Surface Cleaner T340** and in case of high humidity / dew point with **Awl-Prep T0008**. Use the two cloth method.

Degreasing of a new boat is very important because the presence of an unmolding agent can cause disengagement of the paint system. Sand the gelcoat flat with sandpaper grit 100-150.

After sanding clean the surface once again with **Surface Cleaner T340** and in case of high humidity / dew point with **Awl-Prep T0008**. Use the two cloth method.

Old boats: Remove all existing paint layers to obtain a bare gelcoat. Degrease the gelcoat very thoroughly with **Surface Cleaner T340** and in case of high humidity / dew point with **Awl-Prep T0008**. Use the two cloth method.

It is recommended to apply one coat of Awlgrip 545 Epoxy Primer by roller to fill in any porosity on the surface.

- 9.2. 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 D8001
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 fiberglass substrate ! Should you break through, reprime these areas with Awlgrip 545 Primer Gray or White.

- 9.3. 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



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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 !

- 9.4. 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 ./ maximum 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.

- 9.5. 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 !



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- 9.6. 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

Recommended film thickness : 200 - 250 micron wet = 100 - 125 micron dry
Total recommended
film thickness : 250 - 300 micron dry

In between the different coats of **Awl-Star Gold Label Anti-Fouling** a drying time of minimum 5 hours at 21°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 9.2.(application of 545 Epoxy Primer), one can proceed with step 9.4. (application of Hull-Gard ER Epoxy Primer). In between 545 Primer and Hull-Gard ER allow an overcoating time of min. 8 hours and max. 24 hours 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.