



Bouwelven 1  
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## 2. AWLGRIP PAINT SYSTEM FOR STEEL SUBSTRATES

### SURFACE BELOW THE WATERLINE:

- 2.1. Thoroughly clean and degrease the surface prior to sandblasting using **Surface Cleaner T340**. Use the two cloth method. Sandblast to clean white steel in accordance to SIS standard SA 2½, with a surface profile of 50-60 micron. Remove all dust with clean dry compressed air. Prime immediately with **Hullgard ER Epoxy Primer** to prevent fly rust.
- 2.2. 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 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.

- 2.3. 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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- 2.4. 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.

- 2.5. 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 !***

- 2.6. 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

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 a temperature of 21°C before launching.***

**Note :** In case no fairing is required, after step 2.2 (application of Hull-Gard ER), one can proceed with step 2.5.(application of Hull-Gard WB).