



Bouwvelven 1
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12. AWLGRIP SYSTEM FOR BARE / NEW WOOD (MAXIMUM BARRIER SYSTEM)

SURFACE BELOW THE WATERLINE

- 12.1. Thoroughly sand the wood with 80-120 grit sandpaper. Blow off sanding dust and residue with clean, dry compressed air. Clean the surface using **Surface Cleaner T340** and in case of high humidity / dew point **Awl-Prep T0008**. Use the two cloth method. Make sure no oily type of contamination is present.
- 12.2. Seal the wood with **Awlgrip 545 Anti-Corrosive Epoxy Primer White**. Allow the seal to cure 8-12 hours at 20°C. before recoating. If more than 24 hours elapse, the seal coat must lightly be sanded with grit 180-220 grit paper before proceeding. Sealcoat of 545 Primer can be applied by brush, roller or spray method.

Base	: White D8001
Converter	: D3001
Reducer	: Spray application : 40 % with T0006 Brush application : 40% with T0031
Induction time	: 15 minutes
Recommended film thickness	: 175 - 250 micron wet = 50 - 75 micron dry (calculated for mixed base and converter reduced 25 %)

- 12.3. 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 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 bare wood! Should you break through, reprime these areas immediately with Awlgrip 545 Gray Primer.



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12.4. 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 !

12.5. 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 4 hours at 20° C before proceeding.



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- 12.6. 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 !

- 12.7. Apply **Awl-Star Gold Label Anti-Fouling** as soon as the last coat of **Hull-Gard WB** is barely tackfree (i.e. approximately 3-4 hours at 20°C.) but still soft enough to allow indentation with a fingernail. If the Hull-Gard ER is allowed to cure past this point, renew the surface with a fresh coat of Hull-Gard ER and then apply the first coat of Awl-Star Gold Label Anti-Fouling.

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 12.3. (application of 545 Primer), one can proceed with step 12.5. (application of Hull-Gard ER). In between 545 Primer and Hull-Gard ER allow overcoating time of 12 hours minimum and 24 hours maximum 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.