



Bouwvelven 1
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13. AWLGRIP SYSTEM FOR BARE / NEW WOOD (ECONOMY SYSTEM)

SURFACE BELOW THE WATERLINE

13.1. 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.

13.2. Seal the wood with **Awlgrip 545 Anti-Corrosive Epoxy Primer White**.

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 %)

Allow the seal to cure for minimum 8 hours and maximum 24 hours at 20°C. before proceeding with the application of Hull-Gard ER Epoxy Primer. 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.

13.2. Apply **Hull-Gard ER Epoxy Primer** in multiple coats up to a total dry film thickness of 300 micron. Allow a drying time of minimum 3 hours at 20°C. in between coats. 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	
per coat	: 150 micron wet = 75 micron dry
Color	: yellow

Total dry film thickness must be 300 micron minimum !



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13.3. Apply **Awl-Star Gold Label Anti-Fouling** as soon as the last coat of **Hull-Gard ER** 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.