

# AWLCRAFT® SE

## FAST DRY EFFECT SYSTEM

APPLICATION GUIDANCE

WWW.AWLGRIP.COM

**Awlcraft SE** is a revolutionary new topcoat encompassing metallics, pearls and effect pigments and fast drying with excellent opacity.

### HOW DOES THIS SYSTEM WORK?

Awlcraft SE is designed to work as one layer of a multi-part system. The Awlcraft SE imparts the colour and effect and is then topcoated with a clear high gloss finish topcoat to give gloss and protection. This combination forms a high performance, high gloss robust topcoat system.

Awlcraft SE provides coverage, effect finish (metallic, pearl or effect) and is applied to the primer or previous Awlgrip/Awlcraft topcoat finish. Its fast drying formulation allows multiple coats to be applied within a day reducing working time overall.

In order to achieve that ultimate Awlgrip look we have provided a simple, easy-to-follow, step-by-step guide on how to apply Awlcraft SE and some advice on optimal gun settings. Further information is available on [www.awlgrip.com](http://www.awlgrip.com) or contact your local Technical Representative for advice.



### MIXING RATIOS (BY VOLUME)

Awlcraft SE Base	100 parts
Reducer (T0001, T0003 or T0005)	50 parts
Awlcraft #2 (G3010)	15 parts
Application Viscosity	14-15 secs (Din 4)

e.g. 10.6oz (300ml) base : 5.3oz (150ml) reducer : 1.6oz (45ml) Awlcraft #2

**NOTE:** Do not add accelerator to this product.



### GUN SETUP

<b>Gun Type:</b>	Conventional/Compliant
<b>Tip size:</b>	
Gravity feed	.047-.055" (1.2-1.4mm)
Pressure Pot	.031-.043" (0.8-1.1mm)
<b>Fluid Flow Rate:</b>	225-250cc/min
<b>Atomising Air Pressure:</b>	
Compliant/Conventional	As per manufacturers recommendation

### APPLICATION INSTRUCTIONS



#### Substrate:

545 Epoxy Primer, Awlquik or previous Awlgrip/Awlcraft topcoat.

#### Method:

1. Sand with P400 paper.
2. Clean and degrease, using the two-cloth method, using Awlprep Surface Cleaner, T0170. Further information on the correct procedure can be found in the Awlgrip Application Guide or online at [www.awlgrip.com](http://www.awlgrip.com)
3. Apply 1st crosscoat of Awlcraft SE @ 1-2mils (25-50µm) wet film thickness. (See overleaf for guidance on applying crosscoats) Allow to flash off until surface is matt (~10mins at 73°F/23°C).
4. Apply 2nd crosscoat of Awlcraft SE @ 1-2mils (25-50µm) wet film thickness. If necessary a mistcoat can be applied prior to clear coating. This can be applied whilst previous crosscoat is wet or once surface is matt.
5. Apply dropcoat (mistcoat) of Awlcraft SE. (See overleaf for guidance on applying dropcoats). Allow finish to go completely matt.\*
6. Apply 2 full coats of Awlcraft 2000 Clear. Allow to cure fully.

*\*Inspect the surface for dry spray prior to clearcoat application. If necessary, for example on large horizontal surfaces, tack the surface using **Deluxe Tack Rags #73009**. Always take care to avoid excess pressure or excessive usage when using tack rags. Both may result in a compromised finish.*

#### If desired:

1. Sand with P400 paper.
2. Clean and degrease, using the two-cloth method, using Awlprep Surface Cleaner, T0170. Further information on the correct procedure can be found in the Awlgrip Application Guide or online at [www.awlgrip.com](http://www.awlgrip.com)
3. Apply 1 or 2 full coats of Awlcraft 2000 Clear. (2 coats only required if required film thickness not achieved on first coat)

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## CROSSCOAT APPLICATION



### GUN SETUP

<b>Gun Type:</b>	Conventional/Compliant
<b>Tip size:</b>	
Gravity feed	.047-.055" (1.2-1.4mm)
Pressure Pot	.031-.043" (0.8-1.1mm)
<b>Fluid Flow Rate:</b>	225-250cc/min
<b>Atomising Air Pressure:</b>	
Compliant/Conventional	<i>As per manufacturers recommendation</i>



**Gun to substrate distance:**  
Recommended – 9-12" (23-31cm)

- Apply no more than 10-14" (25-35cm) width areas at a time.
- Constant air pressure is necessary during application to ensure evenness of finish.

In order to achieve a uniform, consistent finish, crosscoats should be applied using a smooth, even fluid application technique.

## DROPCOAT / MISTCOAT APPLICATION



### GUN SETUP

<b>Gun Type:</b>	Conventional/Compliant
<b>Tip size:</b>	
Gravity feed	.047-.055" (1.2-1.4mm)
Pressure Pot	.031-.043" (0.8-1.1mm)
<b>Fluid Flow Rate:</b>	225-250cc/min
<b>Atomising Air Pressure:</b>	
Compliant/Conventional	<i>As per manufacturers recommendation</i>



**Gun to substrate distance:**  
Recommended – 23-31" (60-80cm)

- Apply no more than 10-14" (25-35cm) width areas at a time.
- Constant air pressure is necessary during application to ensure evenness of finish.

Mistcoat can be applied immediately after 2nd crosscoat if necessary.



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Visit us at [www.awlgrip.com](http://www.awlgrip.com) for further information.

The information given in this sheet is not intended to be exhaustive. Any person using the product without first making further enquiries as to the suitability of the product for the intended purpose does so at their own risk and, to the extent permitted by law, we can accept no responsibility for the performance of the product or for any loss or damage arising out of such use. The information contained in this sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.

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