

PRODUCT DATA SHEET

AWLCRAFT® 2000 VOC ACRYLIC URETHANE TOPCOAT

(Code numbers can be found on Suggested List Price Schedule or Color Card)



Features & Uses

VOC Compliant Awlcraft 2000 is a two component, fast drying acrylic urethane coating with long lasting gloss and color retention that is formulated to yield a great finish yet only has a VOC 420g/l (US only, when used with Awlcat #4-G3038 Spray Converter). When used with Awlcat #5-G3039 spray converter, VOC levels will vary by colour. To ensure VOC compliance please refer to the Awlcraft 2000 VOC compliance chart or check with your local Technical Service Representative. Provides an easy to apply, buffable finish. Spray application only. Do not use below the waterline. Awlcraft 2000 is also available in a range of metallic colors (refer to separate datasheet).

Awlcraft 2000 VOC Topcoat has an 85% gloss or higher on a 60 degree meter as specified by ASTM Test Method D-523-08.

Specification Data

Type: Two Component Acrylic Urethane

Color: See Color Card and/or your Awlmix distributor.

Packaging: Available in 1 gallon and 1 quart containers

Theoretical Coverage Sq. Ft./Gallon: 573 Sq. Feet (53m²) at one mil dry (25 microns); 230 Sq. Feet (21m²) at recommended dry film thickness

Calculated for mixed base and converter, reduced 25%.

Coverage calculations are based on theoretical transfer efficiency of 100%. Actual coverage rate obtained will vary according to equipment choice, application techniques, part size, and application environment.

Recommended Wet Film Thickness: 6-9 mils (150-225 microns) total of 2 or more coats.

Recommended Dry Film Thickness: 2-3 mils (50-75 microns) total of 2 or more coats.

Anticipated Cure Time at 77°F, 50% R.H.: 24 Hours to tape free; 3 days to light service; 14 days for full cure.

Recoatibility: Typical spray applications consist of two - three coats applied over 1-4 hours. Exact time will vary with temperature, project size, and film thickness applied. AWLCRAFT 2000 topcoats which have been allowed to cure more than 24 hours must be sanded before recoating.

VOC: Base: 472.5 g/lit or 3.9 lbs/gallon

Spray Converter (G3038) 71.6g/lit or 0.6 lbs/gallon

Spray Converter (G3039) 234g/lit or 1.95 lbs/gallon (VOC compliant on most colours, check with TSR)

Product Components, Reducers, Additives and Auxiliary Components

AWLCRAFT 2000 Topcoat Base	(Number from the Color Card)
High Gloss Clear	F3029
AWLCAT #4 Spray Converter	G3038
NEW: AWLCAT #5 Spray Converter (US Only).....	G3039
Standard Reducer-Spray	T0167
Fast Evaporating Reducer-Spray	T0163
Hot Weather Reducer-Spray	T0168
PRO-CURE Accelerator X-9873014
PRO-CURE Accelerator X-138.....	.73015
CRATER-X	M1017
GRIPTEX Non-Skid Particles-Fine73012
GRIPTEX Non-Skid Particles-Coarse73013
Flattening Agent	G3013
Equipment Cleaning	T0163, T0167 or T0168 Reducers or M.E.K.

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Application Equipment

Conventional air atomized spray or HVLP spray.

SPRAY EQUIPMENT:

Pressure Pot System:

Devilbiss or equivalent:
Spray Gun: JGA type
Fluid Nozzle: AV-645-FX
Fluid Needle Size: 1.1
Fluid Flow Rate: 170 - 270 ml/min
Air Nozzle: AV-4239-43
GUN PSI: 2.5 – 3.5 bar (36-51 psi)

Cup Gun System:

Devilbiss or equivalent:
Spray Gun: JGA type
Fluid Nozzle: AV-4239-43
Fluid Needle Size: 1.1
Air Nozzle: AV-4239-43
GUN PSI: 2.0 – 3.0 bar (29-44 psi)

Surface Preparation

Best results are achieved when sprayed over properly prepared 545 Epoxy Primer. May be applied directly over some existing finishes. The existing finish must be sound, tightly adhered to the substrate, and chemically compatible with Awlcraft 2000.

Mixing and Reduction

Spray: Mix by volume two parts Awlcraft 2000 Topcoat Base Component with one part Awlcat #4/G3038 Spray Converter or Awlcat #5/G3039 (US only) Spray Converter to a smooth, homogenous mixture. Using Awlcat #5/G3039 Spray Converter will give a superior gloss, flow and finish (US only, VOC compliant on most colours, check with TSR). Reducer addition level required to achieve 14 seconds viscosity (DIN4 or equivalent) varies color to color. For standard conventional spray application this can be attained by adding up to 25% reducer using the correct spray reducer(s) appropriate for conditions. For example, if a 25% reduction is used, overall mix is 2:1:¼ by volume (8 oz. Base, 4 oz. G3038, 3 oz. Reducer).

Clear coats and painting in high temperature conditions may require additional reduction.

Application Instructions

General: The primed surface must be clean and dry. Achieving maximum gloss and distinction of image requires the primer be smooth sanded with 320 grit paper before topcoat application. Using a contrasting mist coat of lacquer primer as a “guide coat” is recommended. Smooth sanding until all the “guide coat” is removed indicates a texture free surface. Two coats are recommended for spray applications.

Spray application: Apply a smooth, wet coat to the surface. Allow coat to “flash off” 15- 45 minutes. Allow the second coat to “flash off” 30-45 minutes until only slightly tacky before applying the third coat. More than 2 coats may be required to achieve full hide (opacity) or color coverage depending on color.

Ideal set up would be :1.1 tip for pressure pot with 10-12 ounce per minute fluid rate. 1.2 tip for gravity, pressure will depend of the gun.

Warning: Do not apply paint materials to surfaces less than 5° F (3°C) above dew point, or to surfaces warmer than 105°F (41°C). Ambient temperature should be minimum 55°F (13°C) and maximum 105°F (41°C).

The information in this Product Data 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 Product Data Sheet is liable to modification from time to time in the light of experience and our policy of continuous product development.