

### Features & Uses

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

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 (solid, 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.

Notes:- Awlcraft SE topcoats must be applied over the appropriate Awlgrip primer or Awlgrip/Awlcraft 2000 topcoat that has cured 12-24 hours and has been sanded until all gloss is removed.

### Specification Data

**Type:** Two Component Basecoat Finish.

**Color:** See color card and/or your Awlgrip Technical Sales Representative.

**Packaging:** Available in 1 Gallon and 1 Quart containers.

**Theoretical Coverage:** 8.8m<sup>2</sup>/l. Calculated for mixed base, reducer and converter.  
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:** 2-4 mils (50-100 microns) total of 2 or more coats.

**Recommended Dry Film Thickness:** 1-2 mils (25-50 microns) total of 2 or more coats.

**Anticipated Cure Time at 77°F, 50% R.H:** 1 hours to tape free; 1 day to light service; 7 days for full cure.

**Number of coats:** Spray applications consist of 2 coats applied with 10-20 minutes ambient flash off time. Exact time will vary with temperature, project size, and film thickness applied.

**Recoatibility:** Awlcraft 2000 clear coat can be applied after 1 hour at 77°F (25°C) but before 24 hours of cure. The last coat of basecoat should be completely matt before clearcoating. If sanding is desired, apply 2 coats of Awlcraft 2000 Clear (F3029) and allow curing over night before sanding. Awlcraft SE which has been allowed to cure more than 24 hours must be sanded and recoated with Awlcraft SE before recoating with F3029 clear coat.

**VOC:** Base (e.g. E4161): 700 g/ltr or 5.8 lbs/gallon  
Converter (G3010): 591 g/ltr or 4.9 lbs/gallon

### Product Components, Reducers, Additives and Auxiliary Components

Awlcraft SE Solid Basecoat .....	L-Code
Awlcraft SE Metallic Basecoat .....	E-Code
Awlcraft SE Pearlescent Basecoat .....	P-Code
Awlcraft #2 Spray Converter .....	G3010
Fast Evaporating Reducer-Spray .....	T0001
Standard Evaporating Reducer-Spray .....	T0003
Hot Weather Reducer-Spray .....	T0005
Awlcraft 2000 Gloss Clear .....	F3029
Equipment Cleaning .....	T0001, T0002, T0003 or M.E.K.

### Application Equipment

Conventional air atomized spray or HVLP spray. Awlcraft SE is spray only.

#### SPRAY EQUIPMENT

##### Crosscoat Application

<b>Gun Type:</b>	Conventional/Compliant
<b>Tip Size:</b>	
Gravity feed	0.047-0.055" (1.2-1.4mm)
Pressure pot	0.031-0.043" (0.8-1.1mm)
<b>Fluid Flow Rate:</b>	225-250cc/min
<b>Atomising Air Pressure:</b>	
Compliant/Conventional	As per manufacturer
<b>Gun to Substrate Distance:</b>	9-12" (23-31cm)

##### Dropcoat / Mistcoat Application

<b>Gun Type:</b>	Conventional/Compliant
<b>Tip Size:</b>	
Gravity feed	0.047-0.055" (1.2-1.4mm)
Pressure pot	0.031-0.043" (0.8-1.1mm)
<b>Fluid Flow Rate:</b>	225-250cc/min
<b>Atomising Air Pressure:</b>	
Compliant/Conventional	As per manufacturer
<b>Gun to Substrate Distance:</b>	23-31" (60-80cm)

### Surface Preparation

Awlcraft® SE basecoats should be applied over the appropriate Awlgrip primer or previous Awlgrip / Awlcraft topcoat. The primed surface must be clean and dry. Wipe with surface cleaner T0170 (US) or T0340 (EU) using the two cloth wipe down method. Achieving maximum gloss and distinction of image requires the primer be smooth sanded with P400 grit paper before application.

### Mixing and Reduction

#### Awlcraft SE is Spray Only

##### MIXING RATIOS (BY VOLUME)

Awlcraft SE Base	100 parts
Reducer (T0001, T0003 or T0005)	50 parts
Awlcat #2 (G3010)	15 parts

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

Application Viscosity	14-15 secs (Din 4)
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Mix to a smooth, homogenous mixture. Awlcraft SE basecoats are designed for spray application only and have a significantly shorter pot life than regular topcoats. **Do not** add accelerators to Awlcraft SE.

### Application Instructions

Apply first crosscoat using a smooth, even and fluid spray application technique in order to achieve a uniform, consistent finish. 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. Allow to flash off until surface is matt (~10mins at 77°F/25°C).

Apply second crosscoat in the same way as the first.

When applying a metallic or a 2-stage pearlescent color, an optional dropcoat (mistcoat) can be applied prior to clear coating. This may be necessary to ensure consistency in metallic flake orientation and can be applied whilst previous crosscoat is wet or once surface is matt. The dropcoat will help to achieve a consistent finish and avoid shade variations and/or clouding.

When applying a 3-stage pearlescent color, it is important to achieve opacity with the solid basecoat. This is normally achieved in 2-3 coats. Once opacity has been achieved, the pearl mid-coat can be applied in 1-2 coats. Care must be taken to ensure an even film of mid-coat is applied as overlaps, or additional coats, can alter the final shade of the topcoat

For solid color basecoats, apply smooth wet coats until opacity has been achieved. Most colors require 1-2 coats; however some colors may require additional coats.

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Once the surface has gone completely matt apply 2 full coats of Awlcraft 2000 Clear. After applying the specified basecoat color, allow the coating to cure a minimum of 1 hour at 77°F (25°C) but not more than 24 hours before clear applications. Seal the Awlcraft SE basecoat with Awlcraft 2000 Gloss Clear (F3029/G3010). Mix by volume two parts F3029 Awlcraft 2000 Clear with one part Awlcat #2 (G3010) Spray Converter to a smooth, homogenous mixture. Reduce 25-33% with T0001, T0003 or T0005 Reducers. Overall mix is 2:1:1 by volume for example: 8 oz. Base, 4 oz. G3010, 4 oz. Reducer.

Awlcraft SE must be clear coated.

### **Warning:**

Temperature Range: Optimal Surface/Ambient Temperature range is 70-90°F (23-32°C). Proper application results may be more difficult to achieve when conditions are outside this range.

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 50°F (10°C) and maximum 105°F (41°C).

Do not use accelerators in Awlcraft SE.

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.