



Topcoat (See Stock List for Code Numbers)
K3002 AWL-CAT[®] # 85 Converter
A0003 Slow Activator
A0001 Fast Activator

A0006 Cold Weather Activator
A0031 Brushing Activator

Suggested Surface Preparation:

Best results are achieved when topcoat is applied over a properly applied and prepared Awlgrip Primer. Refer to the Product Data Sheets for the primers for information about their application.

Theoretical Coverage:

846 Square Feet (79 Square Meters) at 1 mil (25 microns) DFT. Actual coverage is 282-423 Square Feet (26-39 Square Meters) per Gallon at 2-3 mils (50-75 microns) DFT. These values are calculated for mixed base, converter, and recommended activators at the standard mix ratio. Coverage calculations are based on theoretical 100% transfer efficiency. Actual coverage rate may vary according to color, equipment choice, applicator techniques, part size, and application environment.

Mixing Instructions:

For best results, measure out the base component and add the proper amount of the converter component to the base. After obtaining a homogenous mixture of the base and converter, add the activator.

For spray application: Combine components in the following ratio: The standard mix ratio by volume is 2 parts color base to 1 part K3002 Converter to 1 part spray activator, either A0001, A0003, or A0006. Overall ratio by volume is 2:1:1.

Example: 2 gallons color base, 1 gallon K3002, and 1 gallon activator, would yield 4 gallons of mixed, ready to apply material.

Use this chart as a guide to selecting the appropriate spray activator for your conditions:
80°F+.....A0003
70-85°F.....A0001
60-80°F.....A0006

Dry and cure conditions are affected by humidity and air flow as well as temperature. In high humidity conditions and/or with high rates of air flow, using the next slower activator (for higher temperatures) is advised. Any of the spray activators can be blended with each other to speed up or slow down the cure rates.

For brush application: Combine components in the following ratio: The standard mix by volume 2 parts color base to 1 part converter K3002 to 1 part A0031.

Example: 2 gallons color base, 1 gallon K3002 and 1 gallon A0031, would yield 4 gallons of mixed, ready to apply material.

V.O.C. Limits

VOC regulations vary in different areas. The standard mix ratio of 2:1:1 will yield a VOC of 3.5 lbs/gal (420 gr/liter) for the spray and brush mix. A mix ratio of 2:1:1½ will yield a VOC of 4 lbs/gal (490 gr/liter). AWLGRIP[®] 2 is designed to provide a fine finish when applied at these mix ratios. Some applicators prefer a lower viscosity material. In many areas, this is the maximum amount of VOC content for these types of coatings in marine applications.

California's South Coast Air Quality Management District and some other areas allow higher levels of VOC in certain marine applications. SCAQMD's Rule 1106.1 allow a VOC of up to 4.0 lbs/gal (490 gr/l). The following mix ration meets those limits; 2

parts color base by volume to 1 part K3002 to 1½ parts activator. An example would be 2 gallons color base, 1 gallon K3002, 1½ gallons activator yielding 4½ gallons mixed ready to use material.

If local regulations allow it, applicators who prefer a lower viscosity product can add more activator to the mix than what is in the standard mix instructions. The additional activator will not affect the overall performance of the coating.

Check with your local air quality board to verify if you are in compliance.

Packaging:

Topcoat is supplied in gallons. Converter in supplied in gallons. Activators are available in pints and gallons.

Application/Spray:

Apply a medium, full flow coat of 2 mils (50 microns) wet film. Allow to dry a minimum of 30-40 minutes at 77°F (25°C)/50% R.H. until nearly tack free, and apply a smooth, wet, coverage coat of 2.5-4.0 mils (63-100 microns). This will yield a total dry film thickness of 2-3 mils (50-75 microns).

If preferred, 3 coats may be applied. Allow the second coat to dry 40-60 minutes at 77°F (25°C)/ 50% R.H. Make sure second coat is dry enough to support the weight of the third coat.

Application/Brush:

AWLGRIP[®] 2 can be brushed by using A0031 Brushing Activator. Refer to section on Mixing Instructions. Two to three thin coats should be applied to achieve an optimum finish. Dry time between coats is overnight. Lightly sand between coats with 280-400 grit paper before recoating. For best results, apply AWLGRIP[®] 2 with a solvent resistant roller to an area no larger than 2 feet by 2 feet and tip off immediately with a high quality bristle brush.

Accelerators:

PRO-CURE[®] X-138 (73015) is the preferred accelerator for temperatures above 70°F (21°C).

PRO-CURE[®] X-98 (73014) should only be used below 70°F (21°C).

The maximum addition of PRO-CURE[®] X-138 is one liquid ounce (30cc) per gallon of AWLGRIP[®] 2 Color Base in the mix.

The maximum addition of PRO-CURE[®] X-98 is ½ liquid ounce (30cc) per gallon of AWLGRIP[®] 2 Color Base in the mix.

Do not use accelerators above 85°F (29°C).

Induction Time after Mixing:

None is required.

Anticipated Pot Life at Standard Conditions:

At 77°F (25°C)/50% R.H. pot life will be 3-4 hours. Pot life will vary depending on color, activator choice, and temperature. Mix amounts which can be used in 2-3 hours or less. Pot life is shorter at higher temperatures.

Cure Schedule:

At 77°F (25°C)/50% R.H.

Dry to Tape: Using A0001, 8 to 11 hours.
Using A0003, 18 to 24 hours.

Light Service: 24 to 36 hours;
72 hours is preferred.

Full Cure: 14 days.

Recoatibility:

At 77°F (25°C)/50% R.H. AWLGRIP[®] 2 may be recoated with itself in 24 hours without sanding. Sanding between applications with 280-320 grit paper will provide a smoother finish. Sanding between applications is preferred.

If AWLGRIP[®] 2 has cured more than 24 hours, it must be thoroughly sanded with 280-320 grit paper before recoating.

Equipment:

AWLGRIP[®] 2 can be applied with Air Atomized or HVLP Spray Equipment; Electrostatic Spray Equipment, Brushes and/or Rollers.

Conventional Air Atomized

Pressure Pot System:

Binks[®]

Spray Gun#95
Fluid Nozzle#63ASS (.040" Orifice Size)
Fluid Needle.....#663A
Air Nozzle.....#63PW

Pressure pot gauge should read 8 to 12 lbs. with 50 to 60 lbs. atomization.

Siphon or Cup Gun System:

Binks[®]

Spray Gun#95
Fluid Nozzle#66SS (.070" Orifice Size)
Fluid Needle.....#665
Air Nozzle.....#66SK

Atomization pressure should be 50 to 60 lbs. at the gun. The above set up works well on a pressure pot when applying GRIPTEX[®] Non-Skid.

HVLP: (Use Binks or Equivalent)

Binks[®]

Mach 1 Spray Gun
Fluid Nozzle.....#91 (.040" Orifice Size)
or#92 (.046" Orifice Size)
Fluid Needle#54-4382
Air Nozzle#93P

Electrostatic Spray Gun:

Graco AA Pro 4500 Air Assist Airless Spray Gun
Tip Size: #511 or #509 (10 in. Fan/.011 or .009 Orifice)

Pump Pressure: 2000 PSI
Atomizing Air Pressure: 60 PSI

Brushes and Roller Covers:

Brushes must be recommended for use with solvent containing epoxy or urethane coatings. Natural bristle brushes work best. Do not use products recommended for water based coatings.

Roller covers have similar requirements. They can be either foam or conventional mohair type, but must be solvent resistant.

Corona Brushes (813-882-9810) and Redtree Industries (973-481-0941) are good sources for brushes and roller covers.

Equipment Cleaner:

T0002, Acetone, Acrylic Lacquer Thinner, M.E.K.

FOR ABOVE WATERLINE USE ONLY!