

Features & Uses

A high solids, low VOC polyurethane coating designed to provide premium gloss and distinctness of image. Awlgrip® HS has a balanced formulation to provide superior resistance to stains and chemicals. The hard wearing resin technology offers excellent durability and gloss hold-out. When used with selected Awlgrip primers, Awlgrip HS provides a long lasting, protective and decorative finish.

Specification Data

Type: Three Component Polyester Polyurethane.

Color: 60 colors from Awlgrip color card & custom colors are available. Contact your local Awlgrip representative for code numbers.

Packaging: Available in 1 gallon containers (base and converter). Activator in pint units.

Theoretical Coverage - Sq. Feet/Gallon (m² / litre) :802 Sq. Feet (20m²/litre) at 1 mil (25 microns) dry film thickness; 267-401 Sq. Feet (6.6-10 m² / litre) at recommended dry film thickness.

Recommended Wet Film Thickness: 4-6 mils (100-150 microns), total of 2-3 coats.

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

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 obtained will vary according to equipment choice, application techniques, part size, and color.

Anticipated Cure Time at 77°F/50% R.H: Dry to tape: 14-16 hours with AN200 and AN210 activators; 1-2 hours with AN220.

Recoatibility: Spray applications consist of two to three coats applied over 30 min -2 hours. Exact time will vary with temperature, project size, and film thickness applied and activator used. AWLGRIP® HS topcoats which have been allowed to cure more than 24 hours must be sanded before recoating.

VOC: Mixed Base, Converter and activator: 420 g/lit or 3.5 lbs/gallon. Per component:

N-line base : 408g/lit (3.4 lb/gl). N3242 converter: 369 g/lit (3.08 lb/gl). AN200 : 957 g/lit (7.98 lb/gl). AN210: 971 g/lit (8.10 lb/gl). AN220: 861 g/lit (7.19 lb/gl).

Product Components, Reducers, Additives, and Auxiliary Components

Awlgrip HS Topcoat Base.....	(N-series)
Converter	N3242
Slow Activator	AN200
Medium Activator.....	AN210
Fast Activator	AN220
Equipment cleaning.....	M.E.K or T0002

Application Equipment

Air atomized spray (Conventional, RP, HVLP). Small areas: brush or roll.

Air Spray:

SATAjet K3 RP or Equivalent

Needle: 0.8-1.1 mm

Atomising air pressure: 30 to 36 psi (2,1 to 2,5 bar)

Fluid delivery: 12-16 oz/min (350-450 mL/min)

Spraying Viscosity: 17-23 seconds (#2 Zahn), 17-21 seconds (#4 DIN).

OR

Devilbiss JGA-510 (Pressure Pot)

Air Cap: 704

Fluid Nozzle : FX

Fluid Needle: 1.1 mm

Air Atomizing Pressure: 50+ psi

Pot Pressure: 10-20 psi

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Surface Preparation

Awlgrip HS should be applied over properly prepared Awlgrip Primers such as 545 Primer or 345 HS Primer. Refer to the Product Datasheets for the primers for information about their application.

Mixing & Reduction

Spray: Mix by volume one part Awlgrip HS Topcoat Base Component with one part N3242 Converter to a smooth, homogenous mixture. Add 0.125 part of Activator. Overall mix is 1:1:0.125 (1:1:1/8) by volume. Example: 1gl. Base, 1gl. Converter, 1 pt. Activator. Three activator options are available depending upon dry to tape times required. The faster activator will significantly reduce pot life. At standard temperature and humidity conditions, AN200 or AN210 will provide the indicated dry to tape time and a wet edge time of 30-60 minutes. The pot life and wet edge time will be reduced dramatically with the use of AN220.

Brush: Mix ratio is 1 part base : 1 part converter N3242 : 0.125 part AN200 activator (1:1:1/8).

Induction Time after Mixing: 15 Minutes

Anticipated Pot Life at 77°F/50% R.H: 3-4 hours with AN200 and AN210; 15-30 minutes with AN220.

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 280-320 grit paper before topcoat application. Application of a guide coat such as 3M Dry Guide Coat (P/N 051131-05860) before sanding the primer is recommended. Smooth sanding until all of the "guide coat" is removed indicates a texture free surface.

A minimum of two coats is required to achieve proper film thickness.

Spray: Apply a smooth, wet, solid film tack coat to the surface. Allow tack coat to "flash off" for 30-60 minutes. Then apply a full, wet coat to achieve color coverage (i.e., hide) and film thickness requirements. If full hide is not achieved in 2 coats, a 3rd coat will be required. Allow the 2nd coat to flash 30-60 minutes or until slightly tacky before applying a 3rd coat. If a need to apply a third coat just wet enough to obtain full hide (opacity) or color coverage.

Brush/Roller application: Suitable for smaller areas only. Awlgrip HS is optimized for spray application. For brush/roller application apply AWLGRIP HS Topcoat in at least 2 coats of 2-3 mils WFT each. Allow 16 hours between each coat. Sanding between coats with 280 to 400 grit paper will provide a smoother finish.

Roll the AWLGRIP HS Topcoat and then smooth the roller stipple by lightly tipping the surface with a brush. This can be done with 2 painters working side by side (i.e. 1 rolling and 1 tipping), or with 1 painter rolling approximately 6 square feet and then tipping that area before rolling any further.

Do not apply paint materials to surfaces warmer than 90°F/40°C or colder than 55°F/13°C. Do not apply Awlgrip HS below an ambient temperature of 60°F/ 16°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.

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