



## PRODUCT DATA SHEET AWLCRAFT 2000 METALLICS

### Features & Uses

AWLCRAFT® 2000 Metallics are mixed the same way as conventional AWLCRAFT 2000 topcoats. Through the use of flow stabilizers, metallic flake float has been drastically reduced, and color consistency is improved. These new formulas will allow applicators to quickly and easily apply metallics for a finish with outstanding color, brilliance and luster.

AWLCRAFT 2000 metallic flakes are pre-mixed into the pigmented color base which is applied in the same way as conventional pigmented AWLCRAFT 2000 topcoats.

- Notes:- Metallic topcoats must be applied over the appropriate Awlgrip primer or Awlcraft 2000 topcoat that has cured 12-24 hours and has been sanded until all gloss is removed.
- (Optional) Metallics may be clear coated when applied as a base coat/clear coat application.
  - Large area applications such as hull sides will require additional application techniques. Use of an agitated pressure pot is essential for these large areas. Contact your Awlgrip Technical Sales Representative for additional information.

### Specification Data

Type: Two Component Acrylic Urethane Metallic

Color: See color card and/or your Awlmix distributor

Packaging: Available in 1 Gallon and 1 Quart containers.

Theoretical Coverage: Sq. Ft./Gallon 512 Sq. Feet (48m<sup>2</sup>) at one mil dry (25 microns)

171-256 Sq. Feet (16-24m<sup>2</sup>) 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 3 or more coats.

Recommended Dry Film Thickness: 2-3 mils (50-75 microns) total of 3 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: Spray applications consist of 3 coats applied over 2-4 hours. Exact time will vary with temperature, project size, and film thickness applied.

AWLCRAFT 2000 clear coat can be applied after 2 hours at 77°F (25°C) but before 8 hours of cure. The last coat of metallic should be dry to touch to prevent mottling of the metallic. If sanding is desired, apply 2 coats of AWLCRAFT 2000 Clear (F3029) and allow curing over night before sanding. AWLCRAFT 2000 Metallics which have been allowed to cure more than 24 hours must be sanded and recoated with AWLCRAFT 2000 Metallic before recoating with F3029 clear coat.

VOC: Base (e.g. F4161): 472.5 g/ltr or 3.9 lbs/gallon

Converter (G3010): 591 g/ltr or 4.9 lbs/gallon

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

AWLCRAFT 2000 Metallic Base .....	F-Code
AWLCRAFT 2000 Gloss Clear .....	F3029
AWLCAT #2 Spray Converter .....	G3010
Fast Evaporating Reducer-Spray .....	T0001
Very Fast Evaporating Reducer-Spray .....	T0002
Standard Evaporating Reducer-Spray .....	T0003
Equipment Cleaning .....	T0001, T0002, T0003 or M.E.K.

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### Application Equipment

Conventional air atomized spray or HVLP spray. Metallic urethanes are spray only.

#### SPRAY EQUIPMENT

##### **Pressure Pot System**

Devilbiss or equivalent:

Spray Gun: JGA-510

Fluid Nozzle: FX – 1.1

Fluid Needle: 1.1

Air Nozzle: 704

PP PSI: 8-12 PSI

GUN PSI: 50-60 PSI

##### **Cup Gun System**

SATA jet 3000 RP:

Needle / Nozzle: 1.3 mm

PSI: 35 PSI

*HVLP may not provide enough atomization to get uniform distribution of the pearl or metallic particle. Standard conventional, air atomized spray gun is preferred.*

### Surface Preparation

AWLCRAFT® 2000 metallics should be applied over the appropriate Awlgrip primer or Awlcraft 2000 topcoat. The primed surface must be clean and dry. Wipe with a surface cleaner such as T0170 (US)/T0340(EU) or T0008, using the two cloth wipe down method. Achieving maximum gloss and distinction of image requires the primer be smooth sanded with 320 grit paper before topcoat application. When applying metallics over Awlcraft 2000 topcoats, sand the surface with 400-500 grit paper. After sanding, blow off sanding dust and tack off using Awlgrip Deluxe Tack Rags (#73009).

### Mixing and Reduction

Spray Only: Mix by volume two parts AWLCRAFT® 2000 Topcoat Base component with one part AWL-CAT #2 (G3010) Spray converter to a smooth, homogenous mixture. Reduce 12.5-25% with T0001 or T0002 only. Overall mix is 2:1: $\frac{3}{8}$ - $\frac{3}{4}$  by volume. Example: 8 oz. Base, 4 oz. G3010, and 1.5-3.0 oz. Reducer. Clear coats require additional reduction and may require the use of T0003 in certain conditions.

AWLCRAFT 2000 metallics are designed for spray application only and have a significantly shorter pot life than pigmented topcoats. Do not add accelerators to metallic topcoats.

### Application Instructions

Apply by spray in light, slightly wet coats until hide is achieved, most AWLCRAFT 2000 metallic topcoats achieve hide in 3 or more coats. Allow 30 to 40 minutes tack time between coats. This spray method allows uniform development of the metallic color without flooding or floating the metallic particles. After achieving the specified color, allow the coating to cure a minimum of 12 hours at 77°F (25°C) but not more than 24 hours before clear applications.

Metallics may be clear coated when applied as a base coat/clear coat application.

After achieving the desired color, allow the coating to cure a minimum of 2 hours but not more than 8 hours. The last coat of metallic should be fully dry to touch to prevent mottling of the metallic. Within this period, seal the AWLCRAFT 2000 metallic with AWLCRAFT

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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 or T0002 Reducer. Overall mix is 2:1:1 by volume for example: 8 oz. Base, 4 oz. G3010, 4 oz. Reducer.

### 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 Metallic Coatings.

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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