Product Data Sheet
Awlcraft SE
E-Code, L-Code, P-Code, S-Code

Intended Uses
Awlcraft SE is a revolutionary basecoat clearcoat system encompassing 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. Awlcraft SE imparts the colour and effect and is then topcoated with a clear finish topcoat to give protection. This combination forms a high performance robust topcoat system.
Awlcraft SE provides coverage, effect finish (metallic, pearl or effect) and is applied to the primer or previous Awlgrip/Awlcraft topcoat finish. It is a fast drying formulation which allows multiple coats to be applied within a day reducing working time overall.

Specification Data

Volume Solids	22%
Available Packs	1 US Quart, 1 US Gallon
Base	L-Code (Awlcraft SE Solid Basecoat) E-Code (Awlcraft SE Metallic Basecoat) P-Code (Awlcraft SE Pearlescent Basecoat) S-Code (Awlcraft SE Solids, Pearls, Matallic Basecoats)
Converter	OG3010
Reducer	T0001, T0003, T0005
Equipment Cleaning	T0001, T0002, T0003
Typical Shelf Life	3 years

Theoretical Coverage

Application Methods	Number of Coats	Recommended Per Coat			Theoretical Coverage Per Coat (at recommended DFT)
		WFT	DFT	Max DFT	
Air Atomized	2 [1]	50 µm 2 mil	25 µm 1 mil	50 µm 2 mil	19.8 m²/lt 806.7 ft²/Gal

[1] minimum

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.

VOC
All VOC information contained herein is theoretical (unless otherwise stated). Actual VOC content may vary by batch and when tested via standard test methodology.

Product	As Supplied (without reducer)			
	g/L	lb/gal	g/Kg	lb/lb
Awlcraft SE	691	5.77		

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/AP) or T0340 (EU) using the two cloth wipe down method. Achieving maximum gloss and distinction of image requires the primer and/or existing topcoat be smooth sanded with P400 grit paper before application.

The surface preparation advice provided, and equipment suggestions, can be used as a guide. Preparation techniques and results will vary according to individual conditions, equipment choice/condition and other factors. Testing on a non-critical area should be carried out prior to full-scale preparation.

Mixing & Reduction
Mixing and reduction requirements will vary according to individual conditions, climate, equipment choice/condition and other factors. Mixing and application of a small sample before full-scale application is recommended.

Application Methods	Mix Ratio (Base:Converter)	Reducer	Recommended Thinning	Spraying Viscosity
Air Atomized	100:15 by volume	T0001	44 %	14 - 15 seconds DIN 4 cup
Air Atomized	100:15 by volume	T0003	44 %	14 - 15 seconds DIN 4 cup
Air Atomized	100:15 by volume	T0005	44 %	14 - 15 seconds DIN 4 cup

100 parts Base:15 parts Awlcat #2 (G3010):50 parts Reducer
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
Application equipment and parameters are given as a guide. Actual equipment choices will vary according to application conditions, equipment condition and other factors. Testing on a non-critical area should be carried out prior to full-scale application. Contact your local technical service representative for further advice if necessary.

Apply first crosscoat using a smooth, even and fluid spray application technique in order to achieve a uniform, consistent finish. Apply no more than 25-35cm

Please refer to your local representative or visit http://www.awlgrip.com for further information.

(10-14") 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 25°C/77°F).

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.

Once the surface has gone completely matt apply 2 full coats of Awlcraft 2000 Clear, Awlcraft CS or Awlgrip HDT Clear. After applying the specified basecoat color, allow the coating to cure a minimum of 1 hour at 25°C (77°F) and up to 3 days before clear applications. See application and mixing instructions on the Clear Coat Technical Data Sheet.

DO NOT add accelerators to Awlcraft SE.

Awlcraft SE is designed for spray application only.

Awlcraft SE must be clear coated.

Surface/Ambient temperature range is 23-32°C (70-90°F). Proper application and/or cure results may be more difficult to achieve when conditions are outside this range.
Do not apply paint materials to surfaces less than 3°C (5°F) above dew point, or to surfaces warmer than 41°C (105°F).
Ambient temperature should be minimum 10°C (50°F) and maximum 41°C (105°F).

Application Methods	Fluid Tip	Fluid Pressure	Fluid Flow Rate	Air Pressure
Air Atomized	1.20 - 1.40 mm 47 - 55 thou	-	180 - 250 cc/min	2 - 2.4 bar 29 - 35 psi

Recoatability & Drying Times

The data given for recoatability is not exhaustive. Actual recoatability can vary according to individual conditions, climate and surroundings. If unsure, consult your local technical service representative before proceeding.

Drying	25°C (77°F)	35°C (95°F)		
Tape Free	90 Minutes	60 Minutes		
Light Service	24 Hours	24 Hours		
Cure Time	7 Days	7 Days		

Overcoated By	25°C (77°F)		35°C (95°F)					
	Min	Max	Min	Max				
Awlcraft 2000, Awlcraft CS, Awlcraft SE, Awlgrip HDT Clearcoat	60 Minutes	3 Days	60 Minutes	3 Days				

Awlcraft SE Basecoat surface must be kept clean at all time before clearcoat application. To reduce dust contamination, clean compressed air or tack rags should be used over Awlcraft SE Basecoat. Oil contamination should be removed using light amounts of Awlgrip Wipe Down Solvent (NA/AP: Awlprep T0008 or Awlprep Plus T0115; EU: Surface Cleaner T0340). In case of heavy contamination contact your local Representative.

Warning Notes

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.