

Product Data Sheet

Awlgrip HDT Clearcoat



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.

Mix Ratio (by volume):
1:1:0.25L, 1:1:12.5% (Base:Curing Solution:Activator)

Induction time = 15 minutes.

Mix to a smooth, homogenous mixture.

Awlgrip HDT Clearcoat is designed for spray application only. Correct choice of activator must be made according to the application conditions and project size. For further guidelines please refer to Awlgrip HDT Clearcoat tips and tricks or contact your local representative.

General guideline:

- 15-23°C - OA0020
- 20-30°C - OA0010-OA0020 with a 50:50 mixture by volume (or OA0015 Awlgrip HDT Medium Activator)
- >30°C - OA0010



Application

To apply Awlcraft SE Basecoat please refer to the Awlcraft SE TDS. To ensure optimal adhesion between coats Awlgrip HDT Clearcoat should be applied according to the overcoating intervals as described in the Recoatability & Drying Times section.

Apply a full coat of Awlgrip HDT Clearcoat to the surface. Allow tack coat to "flash off" 30-45 minutes depending on application conditions. Apply a slightly heavy second coat. A third coat can be applied to reach DFT if needed.

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.

Application Methods	Fluid Tip	Fluid Pressure	Fluid Flow Rate	Air Pressure
Air Atomized	1.20 - 1.40 mm 47 - 55 thou	-	180 - 280 cc/min	3 - 5 bar 44 - 73 psi

Air Pressure: Please refer to the air cap datasheet for further information.



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	15°C (59°F)	25°C (77°F)	35°C (95°F)
Hard Dry	2 Days	24 Hours	6 Hours
Touch Dry	20 Hours	17 Hours	3.5 Hours
Pot Life	3.5 Hours	2.5 Hours	1.5 Hours

Values in the table are for a 50:50 mix by volume of Awlgrip HDT Fast Activator and Awlgrip HDT Slow Activator. If using only Awlgrip HDT Fast Activator or Awlgrip HDT Slow Activator at a different ratio drying time and pot life will vary.

Awlgrip HDT Clearcoat has a shorter pot life than a standard polyurethane topcoat.

Overcoated By	15°C (59°F)		25°C (77°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max
Awlgrip HDT Clearcoat	2 Hours	24 Hours	30 Minutes	24 Hours	30 Minutes	24 Hours

For overcoating over Awlcraft SE Basecoat, please refer to Basecoat TDS.

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; EU: Surface Cleaner T0340). In case of heavy contamination contact your local Representative.

Recoatability: Spray application consists of 2 to 3 coats applied over 2-4 hours. Exact time will vary with temperature, project size and film thickness applied. Awlgrip HDT Clearcoat cannot be overcoated with itself after 24h. Please contact your local representative for more information.

Some Important Points

Awlgrip HDT Clearcoat is compatible with Awlgrip repair product. Please refer to the Awlgrip Application Guide or Awlcraft SE Repair manual for further information.



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.

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

Awlgrip, the AkzoNobel logo and other products mentioned in this publication are trademarks of AkzoNobel. ©AkzoNobel 2019