

AWLGRIP® HDT HIGH DEFINITION TECHNOLOGY POLYURETHANE FINISH

INFORMATION

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TIPS & TRICKS FOR AWLGRIP HDT APPLICATION

If you are new to using Awlgrip High Definition Technology or just want to get the most out of your product, follow these simple tips

WHY CHOOSE AWLGRIP HDT?

- High gloss & excellent distinction of image (DOI)
- Durable and repairable, making maintenance easier
- True color and provides a hard & micro-scratch resistant finish



SURFACE PREPARATION

Awlgrip HDT can be applied over a range of Awlgrip Primers sanded with P320 or for best results P400 (see TDS for more detailed information).

MIXING & REDUCING

1. Mix all 3 components of Awlgrip HDT thoroughly, especially the base. Mix by volume to a homogeneous mixture:
 - 1 part Awlgrip HDT Base (OC series)
 - 1 part Awlgrip HDT Curing Solution (OC0010)
 - 0.25 part (or 12.5%) of Activator OA0010, OA0015 or OA0020 required to enable the cure & achieve full properties.

For example, mix 100ml OC series, 100ml OC0010 & 25ml OA0020 (or 32 ounces OC series, 32 ounces OC0010 & 8 ounces OA0020). Keep in mind that adding more activator into the mix may compromise pot life and could affect the flow of the product.

2. Once the product is mixed, ensure **at least 15 minutes induction time**. If the induction time is not followed, the product may lose gloss / haze once cured.
3. Initial spray viscosity should be 14-20 seconds (DIN4 or equivalent) and varies with the application conditions. The best choice of activator will depend on application conditions and boat size.

As a general guideline (see below):

Activator	15°C 59°F	20°C 68°F	25°C 77°F	30°C 86°F	35°C 95°F
OA0020 Fast					
OA0015 Med					
OA0010 Slow					

(20-30°C: use OA0015 or mixture of OA0010 and OA0020, 50/50 volume)

APPLICATION & CONDITIONS

4. Application equipment: Gravity or pressure feed, air atomized spray or electrostatic spray
5. The primed surface must be clean and dry.
6. Apply 2 coats of Awlgrip HDT, this should be sufficient to achieve the correct DFT of 50-75 microns (3mils) DFT. However, some colours may require additional coats to achieve full hide / opacity and colour development. Application of the first coat should be approximately 75 microns (3 mils) WFT and application of the second coat should be approximately 100 microns (3.9mils) WFT. The surface may not become completely 'tack free' in between coats, however it is recommended to wait at least 30 minutes between coats (this time will vary depending on activator selection, temperature and humidity and air flow)
7. Awlgrip HDT has a relatively short pot life compared to Awlgrip topcoat, so for optimal performance prepare a fresh mix for each application. Don't mix the new & old paint together as this may compromise the final finish.
8. The Awlgrip HDT activators can be blended together to suit not only environmental conditions but also project complexity. For a good starting point use a 50/50 OA0010/OA0020 blend (or OA0015) then adjust to your preference.
 - 8.1 To achieve a longer pot life or longer wet edge, the blend of OA0010 and OA0020 should be adjusted to include more OA0010.
 - 8.2 Similarly, for small areas or where drying time needs to be reduced, the proportion of OA0020 should be increased.

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9. Even if temperature has a greater effect on the cure and the potlife, humidity to some extent can also have an influence on the flow and performance of the product.
- 9.1 In cooler humid conditions it is suggested to either use only OA0020 or a blend of OA0020 and OA0010 with a higher proportion of OA0020 to OA0010. Example 75/25 OA0020/OA0010.
- 9.2 In hot humid conditions it may be necessary to increase the proportion of OA0010 and decrease the proportion of OA0020. Example, 75/25 OA0010/OA0020. Even in hot humid conditions, it is not recommended to solely use OA0010 due to the risk of moisture causing down glossing.
10. When first using Awlgrip HDT, it can apply differently to other topcoats currently in use. To help with this, up to 12.5% of T0002, T0001, T0003, T0005 or T0031 can be added to help with wetting out of the surface. Using extra reducer may require an additional coat to be applied and will mean the product is no longer 'VOC compliant'. Once applicators are used to the behaviour of HDT on application, a similar quality of finish can be achieved without the addition of extra reducer. It is recommended to mix separately the Activator (OA0010, OA0015, OA0020) in equal amounts to the chosen reducer. This mix can then be added to the 1:1 base & curing solution at 25%. This mix will contain 12.5% Activator (as recommended) with 12.5% reducer; from a painters perspective this gives a 1:1:0.5 overall mix ratio.
11. Thanks to the activator/ reducer choice based on temperature, Awlgrip HDT has been proven to be a very adaptable product. The chart on page 1 is to be used as a guide only. In low temperatures, the standard paint mix with fast activator works very well. On larger surfaces, the addition of standard solvents helps to carry a wet edge if the applicator is struggling. For hot weather, OA0015 activator works well. If the applicator is struggling with wet edge, the addition of solvents helps. It is recommended when blending the activators to use the two extremes OA0010

(Slow) and OA0020 (Fast) this allows more control. In low temperatures, we recommend T0001 or T0002; in medium temperatures T0003 and in hot temperatures T0005. In hot to very hot weather T0031. Start with the addition of 5% solvent. It is recommended for larger applications that a pre-shoot on panels is to be carried out, "to enable applicator to choose" the best optimization for the size project and conditions.

DRYING TIMES & REPAIRS

12. If environmental conditions require that the product dries faster (cooler more humid conditions), add slightly more OA0020 into the mix. Keep in mind this may compromise pot life and could affect the flow of the product. Also, in that case the product is no longer VOC compliant.
13. Awlgrip HDT has a new repair process compared to the standard Awlgrip repair. See the Repair & maintenance brochure for further info.
14. Awlgrip HDT can be harder to polish therefore we only recommend this for repairs and to remove localised defects. If working in an environment where you know you're going to polish the whole boat, Awlcraft 2000 is the best choice.
15. Polishing Awlgrip HDT: Always test a small, low visibility area (or a sample panel) first before proceeding. Certain color shades may not be suitable for polishing. The tone of the color may be affected during sanding or aggressive polishing. Multi-stage sanding & polishing systems can also be used. You should contact your local supplier for further information.

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The information given in this 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 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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9624/0719

