

Product Data Sheet

Awlcraft 3000



Intended Uses

Awlcraft 3000 is a two component, premium polyurethane finish that is easy to apply and delivers a high gloss finish in a wide range of colors with enhanced color and gloss retention.

- * Provides a buffable, high gloss finish
- * Fast drying and easy to apply
- * Uses the AkzoNobel color platform (YSC toners) for a truer, more consistent and more vibrant finish.

Awlcraft 3000 is specifically developed for Professional use and spray application only. Do not use below the waterline.

Specification Data

Volume Solids	46.6% (average, unthinned)
Specific Gravity	1.1455 (average, unthinned)
Available Packs	1 US Quart, 1 US Gallon
Base	Awlcraft 3000 (range of colors)
Converter	Awlcat #2 (G3010)
Reducer	T0001 - Fast Evaporating Reducer-Spray T0002 - Very Fast Evaporating Reducer-Spray T0003 - Standard Reducer-Spray T0005 - Hot Weather Reducer - Spray
Equipment Cleaning	T0001, T0002, T0003
Typical Shelf Life	Base - 3 Years; Converter - 2 Years

Theoretical Coverage

Application Methods	Number of Coats	Recommended Per Coat			Theoretical Coverage Per Coat (at recommended DFT)
		WFT	DFT	Max DFT	
Air Atomized	3	75 µm 3 mil	35 µm 1.4 mil	35 µm 1.4 mil	18.2 m ² /lt 741.5 ft ² /Gal

Calculated for mixed base and converter, unthinned.

Coverage calculations are based on theoretical transfer efficiency of 100%. Actual coverage rate obtained will vary according to equipment choice, thinning, 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 from one color to another and when tested via standard test methodology.

Typical VOC for Awlcraft 3000 Bases range between 386 and 414 g/L.

Awlcraft 3000 VOC data is the average mixed product without thinner.

Product	As Supplied (without reducer)			
	g/L	lb/gal	g/Kg	lb/lb
OG3010 Converter	589	4.92	593	0.59
Awlcraft 3000	484	4.04	422	0.42



Surface Preparation

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.

The surface should be sanded with P320-P400 and cleaned with Surface Cleaner (T0170 US & T0340 EU).

Best results are achieved when sprayed over properly prepared 545 Epoxy Primer or Quick Build. May be applied directly over some existing finishes. The existing finish must be sound, tightly adhered to the substrate, and chemically compatible with Awlcraft 3000.



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	2:1 by volume	T0001	15 - 33 %	11 - 15 seconds DIN 4 cup
Air Atomized	2:1 by volume	T0002	15 - 33 %	11 - 15 seconds DIN 4 cup
Air Atomized	2:1 by volume	T0003	15 - 33 %	11 - 15 seconds DIN 4 cup
Air Atomized	2:1 by volume	T0005	15 - 33 %	11 - 15 seconds DIN 4 cup

Mix by volume two parts Awlcraft 3000 Base with one part Awlcat #2 (G3010) Spray Converter to a smooth, homogenous mixture. Reducer addition level required to achieve 11-15 seconds viscosity DIN4 or equivalent (16-18 seconds viscosity Zahn 2) varies color to color. For standard air atomized application this can be attained by adding up to 33% reducer, using the correct spray reducer appropriate for conditions. Clear coats and painting in high temperature conditions may require additional reduction.

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

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For example, if a 25% reduction is used, overall mix is 2:1:¼ by volume (8 oz. Base, 4 oz. G3010, 3 oz. Reducer or 2L Base, 1L G3010, 0.75L Reducer).



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.

General: The primed surface must be clean and dry. Achieving maximum gloss and distinction of image requires the primer be smooth sanded with 320 grit paper before topcoat application. Smooth sanding until all the "guide coat" is removed indicates a texture free surface.

Apply a smooth, wet coat to the surface. Allow coat to "flash off" 15–45 minutes. Then apply a full, wet coat to achieve color coverage and film thickness requirements. Allow the second coat to "flash off" 30–45 minutes until only slightly tacky before applying a third coat. For best results, coats two and three should be applied wet for the paint film to fully coalesce and level. However, take care not to overapply which could lead to sagging of the topcoat.

Typically three coats are recommended for spray applications. Spray applying certain colors may require 4 or more coats to obtain full hide (opacity) or color coverage.

Application Methods	Fluid Tip	Fluid Pressure	Fluid Flow Rate	Air Pressure
Air Atomized	1.00 - 1.20 mm 39 - 47 thou	-	200 - 300 cc/min	2 - 2.5 bar 29 - 36 psi

For specific equipment setups, please contact your local technical sales representative, the equipment manufacturer or your distributor.



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)
Tape Free	48 Hours	24 Hours	24 Hours
Hard Dry	72 Hours	24 Hours	24 Hours
Light Service	5 Days	3 Days	3 Days
Cure Time	21 Days	21 Days	21 Days
Pot Life	7 Hours	7 Hours	7 Hours

Overcoated By	15°C (59°F)		25°C (77°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max
Awlcraft 3000	60 Minutes	24 Hours	30 Minutes	24 Hours	30 Minutes	24 Hours

Typical spray applications consist of three coats applied over 1-4 hours. Exact time will vary with temperature, project size, and film thickness applied. Awlcraft 3000 topcoats which have been allowed to cure more than 24 hours must be sanded before recoating.

Note: If you wish to buff & polish Awlcraft 3000, 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. Sanding and polishing will also reduce the film thickness of the applied topcoat and can in some instances reduce it below the recommended dry film thickness thus having an impact on the long-term performance.



Warning Notes

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 55°F (13°C) and maximum 105°F (41°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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