

Product Data Sheet

Awlcraft CS



Intended Uses

Awlcraft CS is a two component, intermixable matt clearcoat designed for the yacht market, specially created to be applied on small and larger areas. Whether your boat requires a matt, satin or semi gloss finish, Awlcraft CS can do the job. Designed to complement the full range of colors and effects of the Awlcraft® SE basecoat. It can also be applied over Awlcraft 2000. Awlcraft CS, the perfect solution for a finish in any gloss level.

Specification Data

Volume Solids	46.4%
Available Packs	1 US Gallon (=3.78L) for Base and Curing Solution
Base	Awlcraft CS - Low Gloss Base (OJ0300) Awlcraft CS - Medium Gloss Base (OJ0301)
Converter	Awlcraft CS - Curing Solution (OJ0010)
Reducer	OT0003
Equipment Cleaning	OT0001, OT0002, OT0003
Typical Shelf Life	2 years base 1 year for Curing Solution

Theoretical Coverage

Application Methods	Number of Coats	Recommended Per Coat			Theoretical Coverage Per Coat (at recommended DFT)
		WFT	DFT	Max DFT	
Air Atomized	2	75 µm 3 mil	35 µm 1.4 mil		13.2 m²/lit 537.8 ft²/Gal

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
OJ0300	500	4.17		
OJ0301	526	4.39		
OJ0010	360	3.01		



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.

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

Awlcraft CS should be applied over Awlcraft SE Basecoat. Awlcraft SE Basecoat surface must be kept clean at all times before Awlcraft CS application. See Awlcraft SE Technical Datasheet for recommendations.

Awlcraft CS can also be applied over sanded Awlgrip Topcoat, Awlgrip HDT and Awlcraft 2000.

Over Awlgrip Topcoat/Awlgrip HDT/Awcraft 2000 sand topcoat with P400 to remove the gloss and clean with Surface Cleaner T0170 (US/AP) or T0340 (EU) using the two cloth wipe down method. Do not use unless mixed thoroughly with the curing agent at specified ratio. Avoid painting in direct sunlight. Substrate temperature should be minimum 5°C/41°F and maximum 30°C/86°F. Product temperature should be minimum 15°C/59°F and maximum 35°C/95°F. Ambient temperature should be minimum 5°C/41°F and maximum 30°C/86°F. Avoid applying late in the evening as condensation can cause a loss of gloss during overnight cure. Allow to dry in a well ventilated environment.



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	100:40:60 by volume	T0002	-	-
Air Atomized	100:40:60 by volume	T0003	-	-

Mix = Base:Converter:Thinner

Product Data Sheet

Awlcraft CS



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.

To apply Awlcraft SE Basecoat please refer to the Awlcraft SE TDS.

To ensure optimal adhesion between coats Awlcraft CS should be applied according to the overcoating intervals as described in the Awlcraft CS Recoatability & Drying Times section. Apply two full coats of Awlcraft CS according to the WFT recommended to reach the correct DFT.

The following finishes can be achieved:

- Matt/Flat - 0-15 gloss units at 60° use 100 Parts OJ0300
- Satin - 16-30 gloss units at 60° use 60 Parts OJ0300 - 40 Parts OJ0301
- Semi Gloss - 31-60 gloss units at 60° use 30 Parts OJ0300 - 70 Parts OJ0301
- Gloss - 61-85 gloss units at 60° use 100 Parts OJ0301

Mix ratios are advisory and gloss levels may show slight deviation. Application on a panel is recommended to ensure desired gloss level is achieved before carrying out full scale application.

Cutting in lines will be inevitable on large scale applications.

For in tent applications an airflow of 0.5/0.6 m/s is recommended.

This product cannot be applied using electrostatic spray application method. All loose parts need to be isolated or taped off to protect them from overspray.

Air Atomization Pressure: Air Atomization needs to be measured at the gun.

Application Methods	Fluid Tip	Fluid Pressure	Fluid Flow Rate	Air Pressure
Air Atomized	1.20 - 1.40 mm 47 - 55 thou	-	-	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	15°C (59°F)	25°C (77°F)	35°C (95°F)
Hard Dry	6 Hours	5 Hours	3 Hours
Touch Dry	5 Hours	3 Hours	2 Hours
Pot Life	90 Minutes	90 Minutes	60 Minutes

Overcoated By	15°C (59°F)		25°C (77°F)		35°C (95°F)	
	Min	Max	Min	Max	Min	Max
Awlcraft CS	8 Hours	24 Hours	6 Hours	24 Hours	6 Hours	24 Hours

Overcoating figures refer to unsanded Awlcraft CS using OT0003.

T0003 can be replaced with T0002 for small scale applications. A maximum overcoating window of 30 minutes between coats is required if using T0002.



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