

Product Data Sheet

Awlcraft 3000 Clearcoat



Intended Uses

Awlcraft 3000 Clearcoat is a two component, premium polyurethane clearcoat finish that is easy to apply and delivers a high gloss.
 * Easily repaired and maintained in a wide variety of climates
 * Fast drying and easy to apply

Awlcraft 3000 Clearcoat is specifically developed for Professional use.

Specification Data

Volume Solids	44.3% unthinned
Specific Gravity	0.99
Available Packs	1 US Quart, 1 US Gallon
Base	TF0300
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 - 1 Year

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	33 µm 1.3 mil		13.1 m²/lit 533.7 ft²/Gal

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.

Product	As Supplied (without reducer)			
	g/L	lb/gal	g/Kg	lb/lb
G3010 Converter	589	4.92	593	0.59
TF0300 Base	429	3.58	433	0.43
Awlcraft 3000 Clearcoat	488	4.07	494	0.49



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 the application of the basecoat please refer to the Awlcraft SE TDS.

Awlcraft 3000 Clearcoat should be applied over Awlcraft SE Basecoat. Awlcraft SE Basecoat surface must be kept clean at all times before Awlcraft 3000 Clearcoat application. See Awlcraft SE Technical Datasheet for recommendations.

Over Awlcraft 2000 & Awlcraft 3000 topcoat sand 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. 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). At standard conditions (77°F (25°C), 50% R.H.), avoid applying topcoats when the temperature could drop below the dew point within 6–8 hours after the application.



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 Clearcoat 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.

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.

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.

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 Clearcoat	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 Clearcoat topcoats which have been allowed to cure more than 24 hours must be sanded before recoating.



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.

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