

# ALEXIT®

## H/S-Basecoat 411-22

Data sheet: **411-22**  
 Technical info:  
 Gen. techn. info:

### 1. Introduction/Characteristics

ALEXIT-H/S-Basecoat 411-22 is a high-solid two-component polyurethane-based paint with excellent hiding power especially developed for the aircraft exterior market. ALEXIT-H/S-Basecoat 411-22 has been developed for efficient application processes and enhanced durability of the coating system.

Used in combination with ALEXIT-H/S-Clearcoat 411-14, the material shows excellent chemical and mechanical resistances and is extremely gloss and colour stable. ALEXIT-H/S-Basecoat 411-22 fulfils the current aviation requirements regarding VOC regulations.

### 2. Range of Application

AIMS 04-04-025, AIMS 04-04-033, AIMS 04-04-037

### 3. Technical Data of Wet Film

The below values refer to the ready to use mixture at 23°C / 50% rel. hum

- |   |  |
|---|--|
| a) Theoretical coverage                   | approx. 11 m <sup>2</sup> /l at 50 µm<br>(M8001 / white)   |
| b) Weight of solid content<br>(DIN53216)  | approx 550 m <sup>2</sup> /l at 1µm<br>approx. 74 %        |
| c) Volume of solid content<br>(DIN 53219) | approx. 55 %   |
| d) Density<br>(DIN 53217)                 | approx 1,4 to 1,9 g/cm <sup>3</sup><br>depending on colour |
| e) VOC value<br>(ASTM D 3960)             | ≤ 420 g/l  |
| f) Flow time<br>(ISO 2431, 4 mm)          | 25 to 35 seconds,<br>viscosity depends on colour           |
| g) Pot life                               | 2 hrs  |

### 4. Technical Data of Cured Film

- |                       |   |
|-----------------------|---|
| a) Colour             | colour shades upon request  |
| b) Dry film thickness | 25 to 130 µm, depending on colour   |
| c) Dry film weight    | approx. 100 g/m <sup>2</sup> at 50 µm<br>(M8001 / white)<br>approx. 1,5 to 2,0 g/m <sup>2</sup> at 1 µm |

Coverage and dry film weights are strongly depending on colour and the corresponding hiding power. Please contact your nearest Mankiewicz branch for more detailed information.

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### 5. Substrate Pre-treatment

The substrates shall be pre-treated according to afore mentioned specifications (refer to 2. Range of Application). If necessary remove oil, grease and other contaminations with a suitable cleaner. If the max. recoat time of the coat applied before is elapsed, a reconditioning by sanding and solvent cleaning is required. Before application of ALEXIT-H/S-Basecoat 411-22 dust shall be removed with a tack rag.

Compatible Coatings: SEEVENAX-Primer 113-22  
 SEEVENAX-H/S-CF-Primer 113-44  
 ALEXIT-H/S-Topcoat 411-77  
 ALEXIT-H/S-Clearcoat 411-14

### 6. Trade Names

Base	ALEXIT-H/S-Basecoat 411-22
Hardener	ALEXIT-Hardener 405-86
Thinner	ALEXIT-Activated Thinner 902-02

### 7. Mixing Ratio

Shake or stir the base material until the mixture is homogeneous without any solid particles on the bottom of the tin.

3 parts by volume	ALEXIT-H/S-Basecoat
0,75 parts by volume	ALEXIT-Activated Thinner
1 part by volume	ALEXIT-Hardener

Mixing instructions: Mix ALEXIT-H/S-Basecoat 411-22 and ALEXIT-Activated Thinner 902-02 in the proper mixing ratio. Afterwards add ALEXIT-Hardener 405-86 and stir until the mixture is homogeneous. An induction time is not required.

### 8. Application

Equipment  
Note: The equipment must be thoroughly cleaned with an appropriate cleaner such as SEEVENAX-Verdüner 75 (thinner) or methyl ethyl ketone (MEK) before and after use.

Compressed air spraying (cup gun)  
 Nozzle Ø 1.2 to 1.5 mm  
 Pressure 3 to 4 bar

Graco PRO XS 4 / PRO XS 3  
 Material flow 280 to 330 ml/min  
 Nozzle Ø 1.2 or 1.5 mm  
 Air pressure 5 – 6 bar  
 Air cup 197 480

Climatic conditions  
 Temperature 15 to 30 °C  
 Relative humidity 30 to 75 %

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### 9. Drying

Dry to tape	2 to 4 hrs
Recoatable	2 to 120 hrs
Sandable	3 hrs
Fully cured	7 days

These values refer to normal climate conditions (23°C/50% rel. hum.)

Note: The maximum recoating time of ALEXIT-H/S-Basecoat 411-22 should not be exceeded. In case over-coating time is elapsed, recondition the surface with Scotch brite (fine grade) and clean with a suitable cleaner.

### 10. Packaging

ALEXIT-H/S-Basecoat 411-22	3 and 9 litres
ALEXIT Hardener 405-86	1 and 3 litres
ALEXIT Activated Thinner 902-02	0,75 and 2,25 litres

### 11. Storage Life

at + 5 to 35° C

ALEXIT-H/S-Basecoat 411-22	24 months
ALEXIT-Hardener 405-86	12 months
ALEXIT-Activated Thinner 902-02	18 months

For further details on application parameters please contact your nearest Mankiewicz branch.