

ALEXIT®

H/S-Clearcoat 411-14

6. Trade Names	Base	ALEXIT-H/S-Clearcoat 411-14
	Hardener	ALEXIT-Hardener 405-86
	Activator	ALEXIT-Activated Thinner 901-72

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

1 part by volume	ALEXIT-H/S-Clearcoat 411-14
1 part by volume	ALEXIT-Hardener 405-86
0,5 parts by volume	ALEXIT-Activated Thinner 901-72

Mixing Instructions:

Mix ALEXIT-H/S-Clearcoat 411-14, ALEXIT-Hardener 405-86 and ALEXIT-Activated Thinner 901-72 in the proper mixing ratio until the mixture is homogeneous. An induction time is not required.

8. Application

Equipment

The equipment must be thoroughly cleaned with an appropriate cleaner such as SEEVENAX-Verdüner 75 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	260 to 300 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 %

Application Recommendations:

If one layer of Clearcoat is required, apply the Clearcoat as an even wet full layer with an even gloss appearance and with a dry film thickness of 30 – 40 µm.

If two layers of Clearcoat are required, apply the first layer as an even wet film, after a flash off time of 1 - 2 hrs followed by the application of a second even wet layer and with an overall dry film thickness of 50 – 80 µm.

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9. Drying

Dry to tape	16 to 19 hrs
Dry to overcoat	2 to 48 hrs
Dry to fly	48 hrs
Fully cured	7 days

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

Note:

The maximum recoating time of ALEXIT-H/S-Clearcoat 411-14 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.

12. Packaging

ALEXIT-H/S-Clearcoat 411-14	2 and 5 litres
ALEXIT-Hardener 405-86	2 and 5 litres
ALEXIT-Activated Thinner 901-72	1 and 2,5 litres

13. Storage Life

at + 5 to 35 °C

ALEXIT-H/S Clearcoat 411-14	24 months
ALEXIT-Hardener 405-86	12 months
ALEXIT-Activated Thinner 901-72	18 months

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