

ALEXIT®

FST-Füllgrund 414-12/primer

Data sheet: 414-12

Technical info:

Gen. techn. info:

1. Introduction/Characteristics

ALEXIT-FST-Füllgrund 414-12 is a polyurethane-based two-component-material with good filling qualities.

Its FST-properties (Fire, Smoke, Toxicity) meet the requirements of the ABD 0031 as well as international standards such as FAR 25.853 (a) + (b) and FAR 25.853 (a-1), Amdt. 66 (65/65).

ALEXIT-FST-Füllgrund 414-12 is officially approved by Airbus and corresponds to the Material Data Sheet AIMS 04-08-001 and the Technical Delivery Sheet AIMS 04-08-000.

Furthermore the material is approved by Fokker TH 33.0162 and by Dornier DON 353.

ALEXIT-FST-Füllgrund 414-12 offers excellent adhesion on many kinds of plastic. Due to the material's high filling power uneven surfaces and flow lines can be covered with a one-layer coating. ALEXIT-FST-Füllgrund 414-12 can be used as a filling intermediate coat or as a primer.

ALEXIT-FST-Füllgrund 414-12 can be applied either as a primer or as an intermediate coating.

After curing, ALEXIT-FST-Füllgrund 414-12 is easily sandable, while at the same time being very solid and an ideal base for top coats.

2. Range of Application

For application in the interior of aircraft, ships, automobiles and trains.

3. Colour

ivory, silver-grey, white

4. Coverage

3,5 m² / kg –dry film thickness: 80 µm
recommended dry film thickness: 50 to 100 µm

5. Substrate Pretreatment

In most cases ALEXIT-FST-Füllgrund 414-12 can be applied directly onto the appropriately cleaned / pretreated metal or thermoplastic substrates. On metal substrates adhesion can be improved by chemical pre-treatment (i.e. phosphatizing, chromating).

ALEXIT®

FST-Füllgrund 414-12/primer

6. Trade names	Base Material Hardener Thinner	ALEXIT-FST-Füllgrund 414-12 ALEXIT-Härter 402 ALEXIT-Verdünner 62 ALEXIT-Verdünner 901-45
-----------------------	--------------------------------------	--

7. Mixing ratio	15 parts by weight 1 part by weight	ALEXIT-FST-Füllgrund ALEXIT-Härter
------------------------	--	---------------------------------------

The VOC content is 570 g/l (use of thinner: 20 %).

8. Application

High filling	Compressed air spraying Efflux time (DIN 53211-4) Pre-reaction time	max. 10 % thinner approx. 20 seconds 15 minutes
--------------	---	---

Complicated parts	Compressed air spraying Efflux time (DIN 53211-4)	max . 20 % thinner approx. 15 seconds
-------------------	--	--

Nozzle size	1,5 - 1,8 mm
Pressure	3,0 - 4,0 bar

To prolong the open time, e.g. in particularly hot regions, we recommend use of ALEXIT-Verdünner 901-45.

9. Pot life	Room temperature	approx. 20 hours
--------------------	------------------	------------------

10. Drying	Room temperature 20° C / 60 % rel. humidity	dust free : approx. 10 min. assembly dry : approx. 40 min. sandable : approx. 5 hours fully cured : approx. 7 days
-------------------	--	---

Oven drying	15 minutes flash-off time, 3 hours at 40° C or 1 hour at 60° C
-------------	--

11. Packaging	ALEXIT-FST-Füllgrund 414-12 ALEXIT-Härter 402 ALEXIT-Verdünner 62 ALEXIT-Verdünner 901-45	10 kg net 3 kg, 6 kg net 5 kg, 25 kg net 5 kg, 25 kg net
----------------------	--	---

12. Shelf Life	Base Material Hardener Thinner	18 months 12 months 24 months
-----------------------	--------------------------------------	-------------------------------------

For further details on application parameters please consult the application guide or contact your nearest Mankiewicz branch.