

ALEXIT®
FST-Filler 343-60

Data sheet: **343-60**
Technical info:
Gen. techn. info:

1. Introduction/Characteristics

ALEXIT-FST-Filler 343-60 is a water-dilutable two-component paint based on polyurethane with high filling qualities. The material's FST-properties (Fire, Smoke, Toxicity) meet the Airbus requirements of 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-Filler 343-60 is qualified by Airbus according to AIMS 04-08-001 and to the technical delivery conditions of AIMS 04-08-000. It is also qualified by Embraer according to MEP 10-075.

ALEXIT-FST-Filler 343-60 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-Filler 343-60 can be used as a filling intermediate coat or as a primer.

After curing, ALEXIT-FST-Filler 343-60 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

4 m² / kg –dry film thickness: 80 µm
recommended dry film thickness: 50 to 100 µm

5. Substrate Pretreatment

In many cases ALEXIT-FST-Filler 343-60 can be applied directly onto the appropriately cleaned / pretreated metal or thermoplastic substrate. On metal substrates adhesion may be improved by chemical pretreatment (phosphatizing, chromating).

6. Trade names

Base Material	ALEXIT-FST-Filler 343-60
Hardener	ALEXIT-Härter 345-15
Thinner	Water (≤ 20° German hardness)

For further information on the application of water-dilutable materials please see our technical information ATI B2.



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7. Mixing ratio

15 parts by weight	ALEXIT-FST-Filler
1 part by weight	ALEXIT-Härter
10 parts by volume	ALEXIT-FST-Filler
1 part by volume	ALEXIT-Härter

When ALEXIT-Härter 345-15 is mixed with the basic paint, a high speed mixer has to be used for 1 to 2 minutes.

The VOC content is 51 g/l (use of thinner: 10 %).

8. Application

High filling

Compressed air spraying	max. 5 % thinner
Efflux time (ISO 2431, Ø 6 mm)	approx. 15 seconds

Complicated,
large parts

Compressed air spraying	10 % thinner
Efflux time (ISO 2431, Ø 6 mm)	approx. 10 seconds

Due to thixotropic properties the efflux time can only be measured after careful stirring of the material.

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

9. Pot life

Room temperature	approx. 3 hours
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10. Drying

Room temperature	dust free	: approx. 20 min.
20°C und 60 % rel. humidity	assembly dry	: approx. 4 hours
	sandable	: approx. 7 hours
	fully cured	: approx. 7 days

Oven drying	1 - 2 hours flash-off time, 2 hours at 60°C or 30 minutes at 80°C
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11. Packaging

ALEXIT-FST-Filler 343-60	10 kg net
ALEXIT-Härter 345-15	1 kg net

12. Storage

storage temperature	5 to 25 °C; keep from frost
storage ability	base material: 12 months hardener: 12 months