

ALEXIT®

FST-Topcoat 346-55

Data sheet: **346-55**
 Technical info:
 Gen. techn. info:

1. Introduction / Characteristics ALEXIT-FST-Topcoat 346-55 is a water-dilutable two-component interior effect coating based on polyurethane, used to achieve smooth surfaces and pearl textures.

The cured film is resistant to abrasion and general wear as well as to soiling and cleaning agents.

ALEXIT-FST-Topcoat 346-55 fulfills the requirements of ABD 0031, which is stricter than the international aviation rules according to FAR 25.853 (a) + (b) and FAR 25.853 (a-1), Amdt. 66 (65/65).

ALEXIT-FST-Topcoat 346-55 is qualified by Airbus and is in accordance with AIMS 04-08-002 and the technical delivery conditions of AIMS 04-08-000.

ALEXIT-FST-Topcoat 346-55 is qualified according to BMS 10-83.

2. Range of Application ALEXIT-FST-Topcoat 346-55 is used for decorative interior aircraft application.

3. Colours available in colour shades for the industrial series production.

4. Gloss available in different gloss levels

5. Coverage 5 m² / kg – dry film thickness: 65 µm
 recommended dry film thickness: 60 to 70 µm

6. Substrate Pretreatment In many cases ALEXIT-FST-Topcoat 346-55 can be applied directly onto the appropriately cleaned / pretreated metal or plastic substrates with good adhesion results, even if applied in only one layer.

In other cases a water based primer, e.g. ALEXIT-FST-Filler 343-55 or 343-60 shall be used..

On metal substrates adhesion may be improved by chemical pre-treatments such as phosphatizing or chromating.

7. Trade Names

Basic Material	ALEXIT-FST-Topcoat 346-55
Hardener	ALEXIT-Härter 345-55
Thinner	Water (≤ 20° German hardness)

For further information on the application of waterborne materials please see our technical info ATI B 2.

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8. Mixing Ratio	5 parts by weight	ALEXIT-FST-Topcoat
	1 part by weight	ALEXIT-Härter
	3.5 parts by volume	ALEXIT-FST-Topcoat
	1 part by volume	ALEXIT-Härter

When ALEXIT-Härter 345-55 is mixed with the basic paint, a high speed mixer has to be used for 1 to 2 minutes.

The VOC content is 170 g/l (use of thinner: 20 %).

9. Application

One coat application Grained surface	Compressed air spraying	approx. 10 % water
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Two coat application Pearl texture	1. Application	as primer, coloured intermediate coat or smooth surface
	Compressed air spraying	approx. 20 % water
	Efflux time (ISO 2431-4)	40 ± 5 sec.
	Intermediate drying	20 min. to 1 hour at RT

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

2. Application	effect-giving final coat
Compressed air spraying	approx. 10 % water (depending on desired effect)

10. Pot Life	Room temperature	approx. 3 hours
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11. Drying	Oven drying	1 hour flash-off 2 hours at 40 °C or 2 hours at 60 °C
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12. Packaging	ALEXIT-FST-Topcoat 346-55	5, 10 and 25 kg net
	ALEXIT-Härter 345-55	1 and 5 kg net

13. Storage	Storage temperature	5 to 25 °C; keep from frost
	Storage ability	base material 12 months hardener 12 months

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