

ALEXIT®

FST-Topcoat 346-57

Data sheet: **346-57**
 Technical info:
 Gen. techn. info:

1. Introduction / Characteristics ALEXIT-FST-Topcoat 346-57 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 346-57 complies with the requirements of Airbus norm ABD 0031, which exceeds the international aviation rules according to FAR 25.853 (a) + (b) and FAR 25.853 (a-1), Amdt. 66 (65/65).

ALEXIT-FST-Topcoat 346-57 is qualified according to:
 Boeing-BMS 10-83, Airbus-AIMS 04-08-002, Embraer-MEP 10-073, Bombardier / De Havilland DHMS C 4.22 and AVIC-ZMS 1083.

2. Range of Application ALEXIT-FST-Topcoat 346-57 is used for decorative interior application in aircrafts.

3. Colours ALEXIT-FST-Topcoat 346-57 is available in colour shades for the industrial series production.

4. Gloss available in different gloss levels

5. Coverage 5 m² / kg at a dry film thickness of 50 µm
 Recommended dry film thickness: 30 to 60 µm

6. Substrate Pretreatment In many cases ALEXIT-FST-Topcoat 346-57 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 Primer 343-55 or 343-60 shall be used.

On metal substrates adhesion may be improved by chemical pretreatments such as phosphatising or chromating.

7. Trade Names

Base Material	ALEXIT-FST-Topcoat 346-57
Hardener	ALEXIT-Härter 345-57
Thinner	Water

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

ALEXIT®

FST-Topcoat 346-57

8. Mixing Ratio

6 parts by weight	ALEXIT-FST-Topcoat
1,4 parts by weight	water
1 part by weight	ALEXIT-Härter
4.0 parts by volume	ALEXIT-FST-Topcoat
1.5 parts by volume	water
1.0 part by volume	ALEXIT-Härter

Manual mixing: mix base and water thoroughly until mixture is homogeneous; subsequently, add hardener and mix again thoroughly for approx. 1 min.

The VOC content of this mixture is 180 g/l.

9. Application

Pearl texture

1. Application	as primer, coloured intermediate coat or smooth surface
Compressed air spraying	approx. 20 % water
Intermediate drying	45 minutes to 1 hour at RT
2. Application	effect-giving final coat
Compressed air spraying	approx. 10 % - 20 % (depending on texture)

10. Pot Life

Room temperature approx. 3 hours (with 20 % water)

11. Drying

Room temperature	dust free	: approx. 30 min
	dry to handle	: approx. 60 min
	assembly dry	: approx. 3 hours
Oven drying	45 to 60 minutes flash-off, 60 minutes at 40 °C or 30 minutes at 60 °C	

12. Packaging

ALEXIT-FST-Topcoat 346-57	1, 6, 12 and 24 kg net
ALEXIT-Härter 345-57	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.