

ALEXIT®

FST-Strukturlack 404-12/topcoat (for solid colours only)

Data sheet: 404-12

Technical info:

Gen. techn. info:

1. Introduction/Characteristics

ALEXIT-FST-Strukturlack 404-12 is a two-component paint based on polyurethane with high filling qualities. The paint can be sprayed to either a very fine or a coarse texture. By using different colour shades, e.g. light-dark, for the two-layer pearl texture a decorative multi-colour effect can be obtained. The cured film is resistant to abrasion and general wear as well as to soiling and cleaning agents.

ALEXIT-FST-Strukturlack 404-12 fulfills the requirements of the 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-Strukturlack 404-12 is officially approved by Airbus and conforms to the Material Data Sheet AIMS 04-08-002 and to the Technical Data Sheet AIMS 04-08-000. The paint is also approved by Fokker TH 33.0162 and Dornier DON 354.

2. Range of Application

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

3. Colour

available in colour shades for industrial series production

4. Gloss

silk gloss

5. Coverage

3,5 m² / kg - dry film thickness: 65 µm
recommended dry film thickness: 60 to 70 µm

6. Substrate Pretreatment

In most cases ALEXIT-FST-Strukturlack 404-12 can be applied directly onto the appropriately cleaned / pretreated metal or thermoplastic substrates with good adhesion results, even if applied in only one layer.

However, some plastic substrates require two-layer application. In these cases, ALEXIT-FST-Füllgrund 414-12 is used as a primer.

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

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7. Trade names	Base Material Hardener Thinner	ALEXIT-FST-Strukturlack 404-12 ALEXIT-Härter 400 ALEXIT-Verdünner 62 ALEXIT-Verdünner 901-45
8. Mixing ratio	20 parts by weight 1 part by weight	ALEXIT-FST-Strukturlack ALEXIT-Härter
	The VOC content is 634 g/l (use of thinner: 20 %).	
9. Application Two-coat application Fine Texture	<u>First application</u>	as primer or coloured intermediate coat or smooth surface coat
	Compressed air spraying Flow time (ISO 2431-4) Intermediate drying	approx. 20 % thinner approx. 40 seconds approx. 15 minutes
	<u>Second application</u> Compressed air spraying	effect-giving final coat without / max. 5 % thinner
	To prolong the open time, e.g. in particularly hot regions, we recommend use of ALEXIT-Verdünner 901-45.	
	<u>Climate conditions</u>	
	Temperature	8 to 35°C (46 to 95°F)
	Humidity	10 to 90 %
10. Pot life	Room temperature	approx. 8 hours (without thinner) approx. 16 hours (with thinner)
11. Drying	Room temperature 20° C / 60 % rel. humidity	dust free : approx. 20 min. assembly dry : approx. 2 hours fully cured : approx. 7 days
	Oven drying	15 minutes flash-off time, 1 hour at 60° C
12. Packaging	ALEXIT-FST-Strukturlack 404-12 ALEXIT-Härter 400 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
13. Shelf Life	Base 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.