

Characteristics



- Waterborne polyurethane-based two-component interior topcoat
- Smooth and textured surfaces possible
- Quick-drying
- Low heat release
- High resistance to abrasion
- Dirt-repellent
- High resistance to cleaning agents
- VOC contents < 200 g/L
- Fulfills the FST properties of the aerospace industry with regard to:

Flammability

FAR/JAR/CS § 25.853 (a) and App. F, Part I § (a) (1) (I)

Smoke Density

FAR/JAR/CS § 25.853 (d) and App. F, Part V § (b)

Toxicity

ABD 0031 and AITM 3.0005

Heat Release

FAR/JAR/CS § 25.853 (d) and App. F, Part IV § (h)

Range of Application

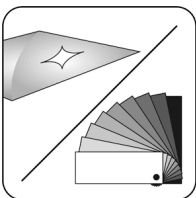


For the decorative surface design of cabin interiors in the aerospace industry.

Accredited in acc. with:

- AIMS 04-08-002 (Airbus)
- AIMS 04-08-012 (Airbus)
- BMS10-83N Type VII (Boeing)
- CMS-CT-301 (COMAC)
- DHMS C 4.22 (Bombardier)
- MEP 10-073 (Embraer)
- ZMS 1083 (AVIC)

Color and Gloss



Color: available in colour shades for industrial series production

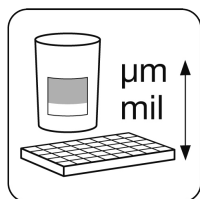
Gloss: obtainable in various gloss grades



ALEXIT[®] FST-Topcoat 346-57

Technical Datasheet 346-57

Theoretical Coverage



Area	Quantity	Film thickness
300 m ²	1 kg	1 µm
4,8 m ²	1 kg	60 µm
630 ft ²	1 gal	1 mil

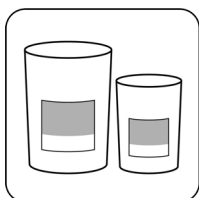
Recommended dry film thickness: 30 - 70 µm (1.2 - 2.8 mil) , depending on colour shade and customer specification

Surface Pre-treatment



- May be applied in most cases directly on to the clean primer/substrate.
- Appropriate waterborne fillers (e.g. ALEXIT FST Filler 343-60) are to be applied on composite substrates.
- On metal substrates, chemical pretreatment (phosphating/chromating) is mandatory. Additional application of primer (e.g. SEEVENAX 313-02) can further improve adhesion.
- A white primer (e.g. ALEXIT FST Filler 343-60) must be used under very brilliant colours (such as yellow, orange or red) and light or pure white shades and defined dry film thickness have to be applied. For further details please contact your local Mankiewicz representative.
- The recoating time of the paint layer underneath must be observed. For further details please refer to the latest version of the relevant technical datasheet.

Trade Names and Packaging



Material	Trade name	Container size [net]
Base material	ALEXIT FST-Topcoat 346-57	6 kg, 12 kg US gal, US quart
Hardener	ALEXIT Hardener 345-57	1 kg US quart, US pint

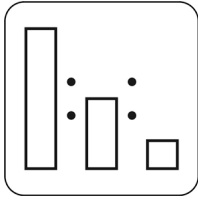
Special packaging sizes available upon request.



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Technical Datasheet 346-57

Mixing



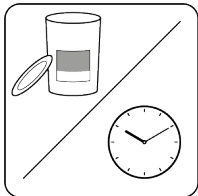
	Base	Hardener	Thinner
Trade name	ALEXIT FST-Topcoat 346-57	ALEXIT Hardener 345-57	Water
By weight	6	1	see "Application"

In order to guarantee optimal blending of the hardener the material must be pre-diluted with the water first. Only then may the hardener be added and mixed in thoroughly manually for approx. 1 minute.

The amount of water to be added is dependent on the required surface appearance - please refer to "Application".

NOTE: Calculation of thinner amount based on mixture of base component and hardener.

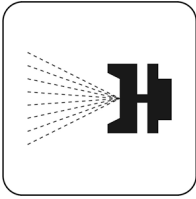
Pot Life



approx. 3 h at 20 °C (68 °F)



Application



Single-layer application, smooth surface

	Compressed air spraying
Addition of water	20 %
Flow time (DIN EN ISO 2431 - 6 mm)	12 - 22 s
Nozzle size	1.4 - 2.0 mm
Spraying pressure	1.5 - 4.0 bar (21.8 - 58.0 psi)

Two-layer application, pearl texture

1st work step

Addition of water	20 %
Flow time (DIN EN ISO 2431 - 6 mm)	12 - 22 s
Nozzle size	1.4 - 2.0 mm
Spraying pressure	1.5 - 4.0 bar (21.8 - 58.0 psi)
Flash-off time at 20 °C (68 °F) / 50 % RH	45 - 60 min

2nd work step

	fine texture	coarse texture
Addition of water	10 - 15 %	10 - 15 %
Nozzle size	1.4 - 2.0 mm	1.6 - 2.5 mm
Spraying pressure	0.6 - 1.2 bar (8.7 - 17.4 psi)	0.3 - 0.8 bar (4.4 - 11.6 psi)

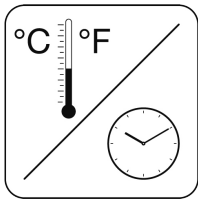
Please observe the technical recommendations of the equipment manufacturers.



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Drying



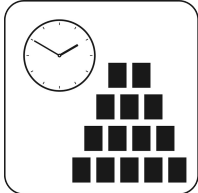
	20 °C (68 °F) drying / 50 % RH	40 °C (104 °F) drying	60 °C (140 °F) drying
Flash-off time at 20 °C (68 °F)	-	45 - 60 min	45 - 60 min
Dust dry	approx. 30 min	-	-
Dry to touch	approx. 60 min	-	-
Assembly dry	approx. 3 h	60 min	30 min
Recoating window (without sanding)	3 h to 48 h	After cool down up to 24 h	After cool down up to 24 h
Fully cured	7 d	-	-

The temperature specified is the object temperature.

- Recoating with ALEXIT FST Decor Basecoat 404-55, as well as CELEROL FST Decor Basecoat 366-56 must be carried out at room temperature (20 °C / 68 °F) within a drying time of 1 - 12 h .

If the recoating time is exceeded, the surface can be reactivated with 3M Scotch-Brite™ (fine grade).

Shelf Life



Material	Shelf life
Base material	24 months
Hardener	12 months

The storage data specified relates to unopened original containers.

The recommended temperature during storage and transport is
5 – 35 °C (41 - 95 °F)

Protect from frost!

Additional Details



The substrate and the film thicknesses applied have an impact on the compliance with the requirements of the aerospace industry.

Please refer to GTI 46 – Water-dilutable coating materials for industrial series production.

For additional application information refer to the respective application recommendation or contact your local Mankiewicz support center.

The information contained in this document is based on our current state of research and development. Revisal by the user with regard to the intended purpose is necessary due to the variety of processing options and fields of application – please refer to the General Terms and Conditions of Sale.

