

ALEXIT® FST-Softcoating 404-78

Technical Datasheet 404-78

Characteristics



- Polyurethane-based two-component paint
- Improves the optical, acoustic and haptic properties
- Leather-like surface that feels good to the touch
- Low heat release
- Fulfils 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 Gas 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

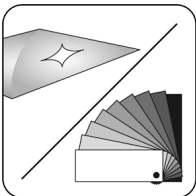


For the transparent protective coating of design effect paints and monochrome colour shades of cabin interiors in the aerospace industry.

Accredited in acc. with:

- BMS 10-121B Type I (Boeing)

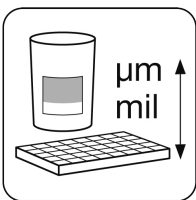
Color and Gloss



Color: transparent

Gloss: mat

Theoretical Coverage



Area	Quantity	Film thickness
290 m ²	1 kg	1 µm
14.5 m ²	1 kg	20 µm
490 ft ²	1 gal	1 mil

Recommended dry film thickness: 20 - 25 µm (0.8 - 1.0 mil) depending on the colour shade



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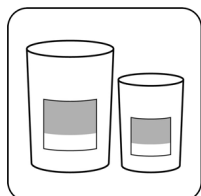
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Surface Pre-treatment



- May be applied in most cases directly on to the clean base coat/primer / primer layer (e.g. ALEXIT FST-Strukturlack 404-12).
- Please observe the recoating times of the base coat layers.

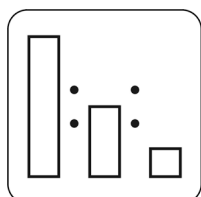
Trade Names and Packaging



Material	Trade name	Container size [net]
Base material	ALEXIT FST-Softcoating 404-78	10 kg US gal, US quart
Hardener	ALEXIT Härter/Hardener 450	1 kg US quart, US pint
Thinner	ALEXIT Verdünner/Thinner 62	5 kg US quart, US pint

Special packaging sizes available upon request.

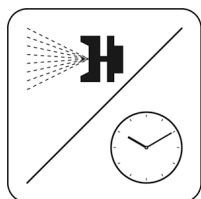
Mixing



	Base	Hardener	Thinner
Trade name	ALEXIT FST Softcoating 404-78	ALEXIT Härter/Hardener 450	ALEXIT Verdünner/Thinner 62
By weight	5	1	see "Application"

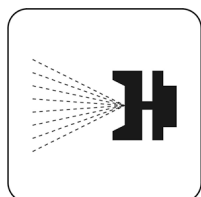
NOTE: Calculation of thinner amount based on mixture of base component and hardener.

Pot Life



approx. 1 h at 20 °C (68 °F)

Application



	Compressed air spraying
Thinner addition	30 %
Flow time (DIN EN ISO 2431 - 4 mm)	35 - 45 s
Nozzle size	1.3 - 1.8 mm
Atomizing pressure	1.0 - 4.0 bar (14.5 - 58.0 psi)

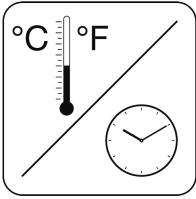
Please observe the technical recommendations of the equipment manufacturers.



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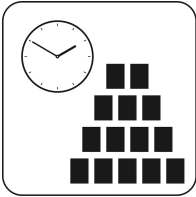
Drying



	60 °C (140 °F) drying	80°C (176 °F) drying
Flash-off time at 20 °C (68 °F)	15 min	15 min
Assembly-dry	60 min	30 min

The temperature specified is the object temperature.

Shelf Life



Material	Shelf life
Base material	18 months
Hardener	12 months
Thinner	24 months

The storage data specified relates to unopened original containers.

The recommended temperature during storage and transport is 5 – 38 °C.

Additional Details



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

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.

