

ALEXIT[®] H/S Topcoat 411-07

Technical Datasheet 411-07

Characteristics



- High-solid polyurethane based Topcoat especially developed for aircraft exterior applications
 - Excellent hiding power
 - Very good gloss and color retention
 - High resistant to chemical and mechanical influences
- Complies with the aviation requirements regarding VOC
(VOC value \leq 420 g/L / 3.5 lb/gal)

Color and Gloss



Color: full range of colors
Gloss: high gloss

Theoretical Coverage



Area	Quantity	Film Thickness
448 ft ²	1 Gal	1 mil
538 ft ²	1 Gal	2 mil
1,075 ft ²	1 Gal	1 mil

Surface Pre-treatment

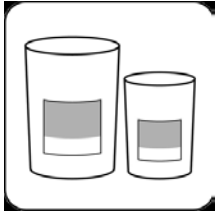


Remove oil, grease and other contaminations with a suitable cleaning agent, preferably either based solvents e.g. ALEXIT BC/CC Surface Cleaner 904-55 or MEK. Remove dust with a tack rag.

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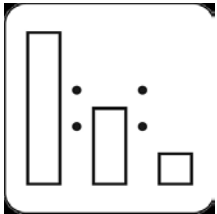
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Trade Names and Packaging



Material	Trade Name	Container size [net]
Base material	ALEXIT H/S Topcoat 411-07	1 Gal
Hardener	ALEXIT Hardener 405-A8	1 Gal
Thinner	ALEXIT Activated Thinner	1 Gal, 1 Qt
30 – 35 °C / 85 - 95 °F	902A7.0000.E	1 Gal
25 – 30 °C / 75 - 85 °F	902A7.0000.D	1 Gal
20 – 25 °C / 65 - 75 °F	902A7.0000.C	1 Gal
15 – 20 °C / 60 - 65 °F	902A7.0000.B	1 Gal
Touchup	902A0.0000.A	1 Gal, 1 Qt

Mixing



	Trade Name	Hardener	Thinner
Trade name	ALEXIT H/S Topcoat 411-07	ALEXIT Hardener 405-A8	ALEXIT Activated Thinner 902-A7 Series
By volume	2	1	1

Prior to mixing, shake or stir the base material to uniform consistency without any solid particles on the bottom of the container.

The choice of the thinner is depending on the climatic conditions during application:

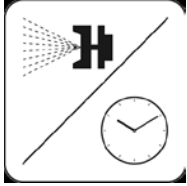
Temperature	Thinner
30 – 35 °C / 85 - 95 °F	ALEXIT Activated Thinner 902A7.0000.E
25 – 30 °C / 75 - 85 °F	ALEXIT Activated Thinner 902A7.0000.D
20 – 25 °C / 65 - 75 °F	ALEXIT Activated Thinner 902A7.0000.C
15 – 20 °C / 60 - 65 °F	ALEXIT Activated Thinner 902A7.0000.B

Mix the materials mention above in the proper mixing ratio and stir to uniform consistency. No induction time required.

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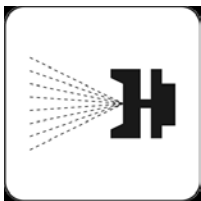
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Pot Life



4 h 23 °C / 73 °F / 50 % RH and ALEXIT Activated Thinner 902A7.0000.C

Application



	Compressed Air Spraying	Electrostatic Application
Thinner 	902-A7 Series	902-A7 Series
Spray Gun Type	Cup Gun	e.g. Graco PRO XS 4 / XS 3
Nozzle Size/ Nozzle Type	1.2 – 1.6 mm	1.2 - 1.5 mm
Air Pressure / Atomizing Pressure	2 - 3 bar 30 - 45 psi	5 - 6 bar 75 - 90 psi
Air Cap	-	197 480 / 24A 438
Material Flow	-	280 - 340 ml/min 9.5 – 11.5 oz/min

Please observe the technical recommendations of the equipment manufacturers.

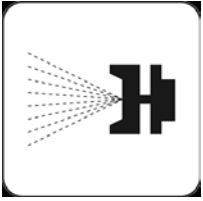
Flow Time of the ready-to-use-mixture at 23 °C / 73 °F / 50 % RH

ISO / 4 mm	18 – 28 s
Zahn 2 SIG	14 - 20 s

Thinner to be used depending on the climatic conditions

Temperature	Thinner
30 – 35 °C / 85 - 95 °F	ALEXIT Activated Thinner 902A7.0000.E
25 – 30 °C / 75 - 85 °F	ALEXIT Activated Thinner 902A7.0000.D.
20 – 25 °C / 65 - 75 °F	ALEXIT Activated Thinner 902A7.0000.C
15 – 20 °C / 60 - 65 °F	ALEXIT Activated Thinner 902A7.0000.B

Application (cont.)



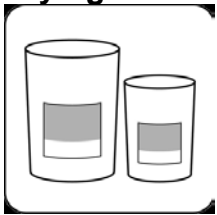
Equipment Cleaning

The equipment has to be cleaned thoroughly with an appropriate cleaner such as SEEVENAX Thinner 75 or methyl ethyl ketone (MEK) before and after use.

Application Recommendations:

Apply ALEXIT H/S Topcoat 411-07 in a minimum of two layers. Apply a first crosscoat (wet film thickness 30 – 50 µm / 1.2 – 2 mil). Followed by another crosscoat (wet film thickness 60 – 80 µm / 2.4 – 3.2 mil) after 45 – 60 min flash-off. If necessary, repeat the above procedure until full hide is achieved.

Drying



	23 °C / 73 °F and 50 % RH ALEXIT Activated Thinner 902-A3
Dust free	1 hr
Cleanable	6 hr (with either based solvents)
Dry to tape	6 - 8 hr
Sandable	8 hr
Polishable	24 hr
Recoatible	8 – 72 hr
Fully cured	7 d

The temperature specified is the object temperature.

The Drying behaviour of ALEXIT H/S Topcoat 411-07 strongly depends on the object temperature and the thinner used.

Forced Cure Process:

Flash-Off: 1 hr at RT

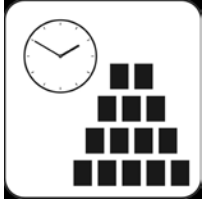
Forced Cure: 1 hr at 60 °C / 140 °F

Note: The maximum recoating time of ALEXIT H/S Topcoat 411-07 should not be exceeded. If it is exceeded, the surface has to be reactivated with 3M Scotch-Brite™ (fine grade) and cleaned with a suitable cleaning agent, such as ALEXIT BC/CC Surface Cleaner 904-55.

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Shelf Life



Material	Shelf Life
ALEXIT H/S Topcoat 411-07	24 Months
ALEXIT Hardener 405-A8	18 Months
ALEXIT Thinner 902-A7 Series	24 Months

The storage data specified relates to unopened original containers.
Storage temperature: 5 - 35 °C / 40 - 100 °F

Additional Details



- Dry film weight**
 85 - 110 g/m² at 60 µm
 1.4 – 1.8 g/m² at 1 µm
- Dry film thickness**
 60 - 130 µm
 2.4 – 5.2 mil
 Coverage, dry-film-thickness and dry-film-weight strongly depend on the color shade and its hiding power.
- Compatible Coatings**
 SEEVENAX CF H/S Primer 113-44
 SEEVENAX Primer 113-82
 SEEVENAX Primer 113-22
 SEEVENAX Primer 113-07
 ALEXIT Primer 492-11
 CELEROL Intermediate Coat 990-09
 ALEXIT H/S Basecoat 411-22
 ALEXIT ClearCoat 411-14
 ALEXIT ClearCoat 499-03

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.