



ALEXIT® Clear Coat MC100C / 499-03

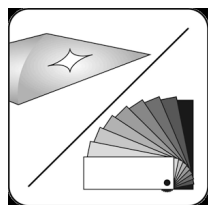
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Characteristics



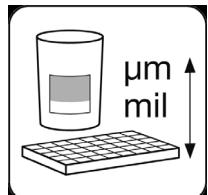
- High-solid polyurethane based Clearcoat especially developed for aircraft exterior applications
- Outstanding gloss and color retention
- Excellent Buffing Characteristics
- Excellent Distinctness of Image (DOI)
- Excellent resistance to chemical and mechanical influences
- 420 g/L VOC
- Used in combination with ALEXIT H/S Basecoat 411-A7 and ALEXIT H/S Topcoat 411-07

Color and Gloss



Color: transparent
Gloss: high gloss

Theoretical Coverage



Area	Quantity	Film Thickness
830 ft ²	1 Gal	1 mil
519 ft ²	1 Gal	40 μm

Surface Pre-treatment



The Basecoat or Topcoat surface has to be free from oil, grease, glue residues or other contaminations. If necessary, clean the surface with a suitable cleaning agent, preferably ether based solvents e.g. ALEXIT BC/CC Surface Cleaner 904-55 or MEK. Remove dust with a tack rag.

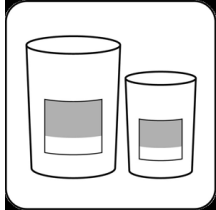




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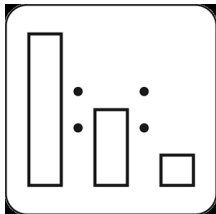
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Trade Names and Packaging



Material	Trade Name	Container size [net]
Base material	ALEXIT Clearcoat 499-03	2 gal or 2 quart
Hardener	ALEXIT Hardener 405-A8	1 gal or 1 quart
Thinner	ALEXIT Activated Thinner 902-AX	1 gal or 1 quart
Touchup	ALEXIT Repair Thinner 902-A0	1 quart

Mixing



	Trade Name	Hardener	Thinner
Trade name	ALEXIT ClearCoat 499-03	ALEXIT Hardner 405-A8	ALEXIT Activated Thinners 902-series ALEXIT Repair Thinner 902-A0
By volume	2	1	1

⚠ Note: Do not shake the base component in order to avoid air entrapment.

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

Temperature	Thinner
30 – 35 °C / 85 - 95 °F	ALEXIT Activated Thinner 902-A3
15 - 30 °C / 60 - 85 °F	ALEXIT Activated Thinner 902-A2
7 - 15 °C / 45 - 60 °F	ALEXIT Activated Thinner 902-A1
Touchup	ALEXIT Activated Thinner 902-A0

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

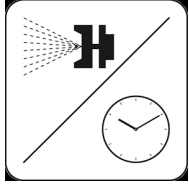




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Pot Life



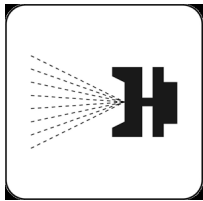
Use of ALEXIT Activated Thinner 902-A3/ 902-A2/ 902-A1

- 4 h for one layer application at 23 °C / 73 °F / 50 %
- For two-layer applications fresh mixed material is required for every
- Dispose material with exceeded pot life

Use of ALEXIT Repair Thinner 902-A0

- 1 h at 23 °C / 73 °F / 50 % RH

Application



	Compressed Air Spraying	Electrostatic Application	Air Assisted Airless Application
Spray Gun Type	Cup Gun	e.g. Graco PRO XS 4 / XS 3	e.g. Graco PRO XS 4 AA
Nozzle Size/ Nozzle Type	1.2 or 1.6 mm	1.2 - 1.5 mm	509/ 511/ 609/ 611
Air Pressure / Atomising Pressure	2 - 4 bar 30 - 60 psi	5 - 6 bar 75 - 90 psi	3 - 4 bar 40 - 60 psi
Air Cap	-	197 480 24A 438	-
Material Flow	-	260 - 300 ml/min 9 - 10 oz/min	
Material Pressure			60 - 80 bar 850 - 1200 psi

Please observe the technical recommendations of the equipment manufacturers.

Flow Time

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

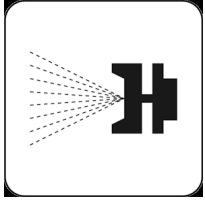




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Application (cont.)



Application recommendations when using ALEXIT Activated Thinners 902-series

One-layer application	Apply one layer (dry film thickness 30 - 40 µm (1.2 - 1.6 mil)) in 1 - 1.5 cross coats.
Two-layer application	Apply the first layer in a uniform closed film (light to medium coat). Allow a flash-off of 45 - 120 min before application of the second layer (1 - 1.5 cross coats). Make sure to use fresh mixed material for the second layer.

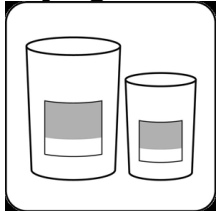
Application recommendations when using ALEXIT Repair Thinner 902-A0

 Please note that ALEXIT Repair Thinner 902-A0 is used for small repair areas only. Apply one layer (dry film thickness 25 - 50 µm / 1 - 2 mil) in 1 - 1.5 crosscoats

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.

Drying



	ALEXIT Activated Thinner 902-A3	ALEXIT Activated Thinner 902-A2	ALEXIT Activated Thinner 902-A1	ALEXIT Repair Thinner 902-A0
Dust free	2 - 3 h	1.5 - 2.5 h	1 - 2 h	0.5 - 1 h
Dry to tape	7 - 10 h	5 - 8 h	3 - 6 h	1 - 3 h
Polishable/sandable	8 h	6 h	4 h	2 h
Recoatable	Up to 36 h	Up to 36 h	-	-
Fully Cured	7 d	7 d	-	-

The temperature specified is the object temperature.

The Drying behaviour of ALEXIT Clearcoat 499-03 strongly depends on the object temperature. The above mentioned values refer to 23 °C / 73 °F and 50 % RH.



Note: The maximum recoating time of ALEXIT ClearCoat 499-03 should not be exceeded. If it is exceeded, the surface has to be reactivated with 3M Scotch-Brite™ (fine grade) and cleaned with compressed air (no wet cleaning).

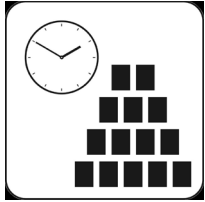




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Shelf Life



Material	Shelf Life
ALEXIT ClearCoat 499-03	24 Months
ALEXIT Hardener 405-A8	18 Months
ALEXIT Thinner 902-A3	24 Months
ALEXIT Thinner 902-A2	24 Months
ALEXIT Thinner 902-A1	24 Months
ALEXIT Thinner 902-A0	24 Months

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

Additional Details



- **Dry film weight**
approx. 34 g/m² at 30 µm
approx. 1.14 g/m² at 1 µm / 0.0067 lb/ft² at 1 mil
- **Dry film thickness**
One layer application: 30 - 40 µm / 1.2 - 1.6 mil
Two layer application: 60 - 80 µm / 2.4 - 3.2 mil
- **Compatible Coatings**
ALEXIT H/S BaseCoat 411-A7
ALEXIT H/S TopCoat 411-07
- For additional application information refer to the respective application guide 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.

