

ALEXIT® Monolyer® 402-4B

Technical Datasheet 402-4B

Characteristics



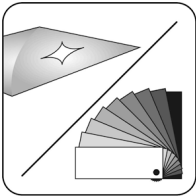
- Weather-resistant two-component polyurethane-based high solid paint
- High gloss and color stability, even in extreme climatic conditions
- Resistant to abrasion, elastic
- Excellent chemical and mechanical resistance
- Good corrosion protection

Range of Application



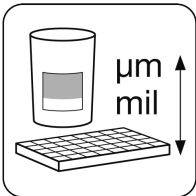
- For efficient application to agricultural and construction vehicles and utility vehicle parts

Color and Gloss



Color: available in color shades for industrial series production
Gloss: silk gloss, glossy

Theoretical Coverage



Area	Quantity	Film thickness
480 m ²	1 kg	1 µm
1,000 sqft	1 gal	1 mil

Recommended dry film thickness: 60 – 80 µm (2.4 – 3.2 mil), depending on the color shade

Surface Pre-treatment



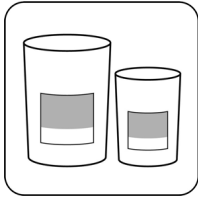
- Is usually applied directly onto the appropriately cleaned / pre-treated substrate, preferably chemical pretreatment (Zn, Fe phosphating, etc.) or sandblasting with Sa 2½.



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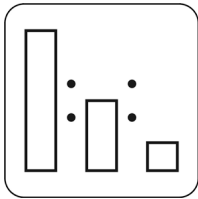
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Trade Names and Packaging



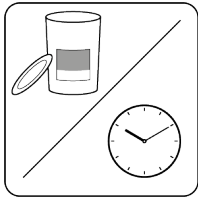
Material	Trade name	Container size [net]
Base material	ALEXIT Monolyer® 402-4B	10 kg, 25 kg
Hardener	ALEXIT Härter 405-33	6 kg, 25 kg
Thinner (short)	ALEXIT Verdünner 62	5 kg, 25 kg
Thinner (medium)	ALEXIT Verdünner 68	5 kg, 25 kg
Thinner (long)	ALEXIT Verdünner 901-70	5 kg, 25 kg

Mixing



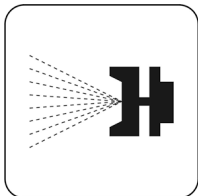
	Base	Hardener
Trade name	ALEXIT Monolyer® 402-4B	ALEXIT Härter 405-33
By weight	3.3	1
By volume	2.7	1

Pot Life



approx. 20 min at 20 °C (68 °F)

Application

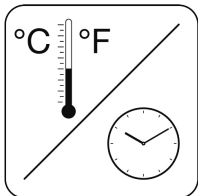


	Compressed air spraying with ESTA support
Addition of thinner	max. 10%
Efflux time (DIN 53211 / 4 mm)	30 - 40 s
Nozzle size	1.2 - 1.8 mm (0.047 - 0.071 inch)
Spraying pressure	2 - 4 bar (29 - 58 psi)

Please review the technical recommendations of the equipment manufacturers.

Depending on the paint unit and environmental conditions as well as the component geometry these values may vary and have to be established on site.

Drying



	20 °C (68 °F) drying	60 °C (140 °F) drying
Flash-off time at 20 °C (68 °F)	-	15 min
Dust-dry	1 - 2 h	-
Assembly-dry	6 - 8 h	30 min
Fully cured	7 d	-

The temperature specified is the object temperature.

The drying time at 20 °C (68 °F) depends on the dry film thickness and air circulation.





ACE Coatings

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Additional Details



Store between 5 - 35 °C (41 - 95 °F) in original, unopened containers (acc. to DIN 3840:2007).

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.

