

ALEXSEAL Flat Finish 555

Technical Data Sheet: 471-FF
F Series

1. Introduction

ALEXSEAL Flat Finish 555 is a two-component polyurethane based material flat topcoat which is easy to apply to a uniform layer. It is used for coating for example the ceiling panels in exterior areas. It has good adhesion properties on a variety of substrates, combined with high resistance values and is suitable for many areas of application.

2. Range of application

ALEXSEAL Flat Finish 555 is used to finish panels of all kind of materials. It is weather resistant and shows a uniform flat finish.

3. Color

Base Material: F9003 Signal White (near RAL 9003)
F9010 Pure White (near RAL 9010)
F9016 Traffic White (near RAL 9016)
F7035 Light Gray (near RAL 7035)
F9005 Jet Black (near RAL 9005)

Converter: Clear

4. Coverage

Volume solids catalyzed without reduction: 62%

Note: Coverage rates are figured for base and converter. Reducer is added as percent of total quantity of base & converter.

	m ² / liter	m ² / gal	sq. ft. / gal	Rec. DFT in μm (mils)
Theoretical	9	34,1	326	60-100
Practical				
Conventional Air Spray Equipment	6	22,7	244	60-100
HVLP Air Spray Equipment	7	26,5	285	60-100
Airless Spray Equipment	9	34,1	367	60-100

5. Substrate pre-treatment

The substrate must be clean, dry and free from dust, grease, oil and other contamination. ALEXSEAL Flat Finish can be directly applied to existing paint surfaces of 442 Primer. A light sanding with P240-320 is recommended.

6. Trade names & Packaging

F...	ALEXSEAL Flat Finish 555	2 Gal (filled with 7 liter)
C5556	ALEXSEAL Flat Finish 555 Converter	1 QT
R5557	ALEXSEAL Flat Finish 555 Reducer	1 Gal

7. Mixing ratio

7 part by volume	F...	ALEXSEAL Flat Finish 555
1 part by volume	C5556	ALEXSEAL Flat Finish 555 Converter
15-20 % reduction (vol.)	R5557	ALEXSEAL Flat Finish 555 Reducer

The amount of reducer required may vary depending on the application conditions. Mixed material must be filtered before application.

8. Application

Viscosity	Zahn #2: ≈ 24 - 33 sec, DIN 4 cup 4mm: ≈ 20 - 30 sec
Nozzle Size Gravity Gun	1.6 mm - 2.0 mm ((0.060 to 0.080) - Conventional & HVLP
Fluid Nozzle Size Pressure Pot	1.2 to 1.5 mm (0.050 to 0.060) - Conventional & HVLP
Atomizing Pressure	2.0 to 4.0 bar (30 to 60 PSI) - Conventional & HVLP
Pot Pressure	1.0 to 2.0 bar (15 to 30 PSI) - Conventional & HVLP

Application by Spraying:

Spray one cross coat to a wet film thickness (WFT) of 125 - 150 microns (5 - 6 mils). This will achieve a dry film thickness (DFT) of 60 - 100 microns (2 - 4 mils).
If required repeat after 1h at room temperature.

Note:

Final gloss of the paint film may vary while painting under different conditions (e.g. airflow, temperature, humidity). Paint parts in equal conditions to ensure a uniform gloss.

Professional Use Only

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9. Pot life and Drying

Optimal application environment range - min. 15°C (60°F) 40% RH, up to max. 30°C (85°F) 80% RH

Temperature for minimum time	15°C (60°F)	20°C (68°F)	25°C (77°F)	30°C (85°F)	Max Time
Pot Life - approx.	90 min	75 min	60 min	45 min	NA
Tape Dry	4,5 hrs	3,5 hrs	3 hrs	2 hrs	NA
Fully Cured	7 days	5 days	3 days	2 days	N/A
Recoat after tack up with ALEXSEAL Flat Finish (spray application)	90 min	75 min	60 min	45 min	2 hrs

Note: The above chart reflects approximate minimum and maximum time. Surface temperature, air flow, direct or non-direct sunlight, quantity and or choice of reducer, and film thickness will effect actual tack up, recoat, overcoat, and drying times during application. During the drying phase the minimum temperature is 15°C (60°F). Ideal temperature: 25°C (77°F).

Note: The minimum application condition should be 3°C (5.4°F) above dew point.

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