



Process Card
ALEXIT®-BladeRep System

Date: 2010-06-22
Sign: nk
Page: 1 of 2

1. Surface pre-treatment: Prior to application very careful sanding of the repair area with sanding paper grit 120. After sanding remove dust carefully with a brush and dust binding cloth.

2. Application of Putty: (if necessary)

Base: **ALEXIT®- BladeRep Putty 3**
Hardener: **ALEXIT®- BladeRep Hardener 3**

Mixing ratio by weight: 6 parts **ALEXIT®- BladeRep Putty 3**
1 part **ALEXIT®- BladeRep Hardener 3**

Pot life: approx. 5- 10 minutes @ 23°C / 73°F

Application equipment: putty knives

Drying time before sanding: approx. 2 hours @ 23°C / 73°F for sanding by hand
approx. 3 hours @ 23°C / 73°F for mechanically sanding
Sand putty with sanding paper grit 120. After sanding remove dust carefully with a brush and dust binding cloth.

3. Application of Pore filler: (if necessary)

Base: **ALEXIT®- BladeRep Pore Filler 6**
Hardener: **ALEXIT®- BladeRep Hardener 6**

Mixing ratio by weight: 6 parts **ALEXIT®- BladeRep Pore Filler 6**
1 part **ALEXIT®- BladeRep Hardener 6**

Pot life: approx. 5 - 10 minutes @ 23°C / 73°F

Application equipment: putty knives

Drying time before sanding: approx. 2 hours @ 23°C / 73°F for sanding by hand
approx. 3 hours @ 23°C / 73°F for mechanically sanding
Sand pore filler with sanding paper grit 120. After sanding remove dust carefully with a brush and dust binding cloth.

Remark: **ALEXIT®-BladeRep Pore Filler 6** can be used as "fine putty" as well



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Page: 2 of 2

4. Application Leading Edge Protection: (if necessary)

Base: **ALEXIT® - BladeRep LEP 9**
Hardener: **ALEXIT® - BladeRep Hardener 9**

Mixing ratio
by weight: 2 parts **ALEXIT® - BladeRep LEP 9**
1 part **ALEXIT® - Hardener 9**

Pot life: approx. 10 – 15 min @ 23°C / 73°F

Application equipment: Superfloc roller or similar

1st layer: 100 - 125 µm wet film thickness (3.94 – 4.92 mil)

Flash-off time: approx. 45 minutes @ 23°C / 73°F

2nd layer: 100 - 125 µm wet film thickness (3.94 – 4.92 mil)

Drying before overcoating
with **ALEXIT®-BladeRep Topcoat 12**: approx. 60 min @ 23°C / 73°F

5. Application of Topcoat:

Base: **ALEXIT® - BladeRep Topcoat 12**
Hardener: **ALEXIT® - BladeRep Hardener 12**
Thinner: **ALEXIT® - BladeRep Thinner 12**

Mixing ratio
by weight: 4 parts **ALEXIT® - BladeRep Topcoat 12**
1 part **ALEXIT® - BladeRep Hardener 12**
5% **ALEXIT® - BladeRep Thinner 12** (on mixed material)

=> optional:
To decrease drying time: **ALEXIT® - BladeRep Thinner 12** can be replaced by
ALEXIT® - BladeRep Thinner 12 fast

Pot life: approx. 120 min @ 23°C / 73°F

Application equipment: Superfloc roller or similar, respect. suitable spray equipment

1st layer: 100 – 125 µm wet film thickness (3.94 – 4.92 mil)

Flash-off time before 2nd layer: approx. 45 minutes @ 23°C / 73°F

2nd layer: 100 – 125 µm wet film thickness (3.94 – 4.92 mil)

Drying level 7 = assembly dry:
@ 23°C / 73°F approx. 8 hours with **ALEXIT® - BladeRep Thinner 12**
(according to DIN 53150) approx. 4 hours with **ALEXIT® - BladeRep Thinner 12 fast**

The information stated here is based on theoretical values which have been determined under laboratory conditions. These values may vary somewhat depending on the application parameters, such as temperature, humidity, application technology etc. and should thus be perceived solely as guideline values.