



Rethane FMP 646 uses specially selected raw materials, showing excellent resistance to weathering , good color and gloss retention. Also it is overcoatable, easy to apply to conventional spray and drying fast .

TECHNICAL CHARACTERISTICS

TYPE

Aliphatic polyurethane topcoat, two pack system.

USAGE

Suitable for use over epoxy primer, as in steel structures, industrial equipment, marine and offshore. Recommended atmbém as external lining of tanks and pipes.

TECHNICAL INFORMATIONS

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| COLOR | White | Other colors, please consult. | |
| FINISH | Glossy | | |
| VOLUME SOLIDS | 40 % ± 2 | According to ISO 3233 | |
| WEIGHT PER LITER | 1,000 ± 0,05 g/ml | According to ASTM D 1475 | |
| FLASH POINT | 32°C | | |
| MIXING RATIO | | Weight | Volume |
| | Comp. A | 100,0 | 15,0 |
| | Comp. B | 6,4 | 1,0 |
| POT LIFE (25°C) | 4 h | | |
| INDUCTION TIME | 30 to 35 min | | |
| THEORETICAL SPREADING RATE | 10,0 m ² /l - 40 µm | | |
| WET THICKNESS | 100 µm | | |
| DRY THICKNESS | 40 µm | | |
| DRYING TIME, for 40 µm | | 25°C | |

| | | Minimum | Maximum |
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| | Touch | | 10 min |
| | Handle | | 3 h |
| | Recoat | 6 h | |

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| ENVIROMENTAL CONDITIONS | Temperature | Should be between 0 to 40°C |
| | Relative Humidity | Between 30 to 85% |
| | Dew Point | Surface temperature is at least 3°C above dew point |
| | Thinner | 440.0000 |

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| | Brush | It is not necessary dilution. This method must be used only for retouch and backing of welding cords and corners. |
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| | Roller | Dilute up to 10% (vol.) with recommended thinner. Must be used solvent resistant roller (sheep wool). The wool must be cutted (small size) to avoid blistering during the application. |
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APPLICATION

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| | Conventional Spray Gun | Dilute up to 10% (vol.) with recommended thinner. Conventional DeVilbiss JGA 503 FX 704 spray gun or similar. Spray pressure between 2,5 to 3,0 kgf/cm ² (35 to 43 psi). Tank pressure between 0,5 to 1,5 kgf/cm ² (21 to 35 psi). |
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| | AirLess Spray Gun | Dilute up to 10% (vol.) with recommended thinner. Use nozzles between 9 to 19 and pump pressure between 140 to 175 kgf/cm ² . |
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SURFACE PREPARATION

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| Over recommended primer | The surface must be dry, free of contaminants such as salt deposits, oil, grease, fat, dust, etc. |
| Recommended Primers | Revrans PLB 530 (530.0490), Revran PAA 540 (540.0495), Revran WBC 524 (524.0499) and Rekomox PHB 515 (515.0848). For other primers, please contact our Consultants. |
| Coated Surfaces | The surface must be clean and free of contaminants as oils, fat, grease and dust. Must not present peeling's areas. Proceed light sanding (220) to break the gloss. |
| Recommended TopCoat | Not applicable |

SHELF LIFE 12 months

UN NUMBER 1263

HAZARD NUMBER 33

IMPORTANT RECOMMENDATIONS

1. The practical spreading rate of the product varies according to the applied thickness, application method and techniques, type and rugosity of the surface and ambient conditions.
2. The weight/l, viscosity and drying values were obtained in laboratory at a temperature of 25°C. At an altered temperature, the results might be different from the specified ones.
3. Pot life is shortened by higher temperature and by the increase of catalyzed volume.
4. Component B consists of isocyanate , which is reactive with moisture in the air. Therefore, every use of the product, close the container as soon as possible so that does not lose its efficiency.
5. For aluminum color, a coat of the product Rethane DHG 652 colorless should be applied to avoid staining of the film, due to the presence of water and/or moisture, and also due to handling parts already painted.

SAFETY PRECAUTIONS

1. Improper use and handling of this product can be hazardous to health and cause fire or explosion. Do not use it without first taking all appropriate measures to prevent property damage and injuries.
 2. Storage: keep the product in sheltered, well-ventilated areas. Maximum temperature: 40° C. Must not be directly exposed to the sun.
 3. Flammable: flammable product, which must be kept distant from ignition sources, and do not smoke nearby.
 4. Inhalation: Avoid breathing vapors, keeping proper ventilation during application and drying.
 5. Handling: wear proper protective clothing and masks, goggles, etc. Do not eat or drink nor allow children and animals to be near the application area.
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HEALTH HAZARDS

1. Skin contact: wash affected area thoroughly with neutral soap.
2. Clothing contact: remove clothing and wash it.
3. Leakage: Isolate the area, and do not smoke nearby. If large quantity leaked in confined area, wear protective masks. Do not inhale vapors. Stop leakage with sand, sawdust or soil, and transfer liquid and solid to separated recipients for disposal.
4. Fire: protect non-affected recipients with water spray. Extinguish fire using carbon dioxide, foam or dry chemical.
5. Eyes contact: flush eyes with large amounts of clean water for at least 10 minutes, and get medical attention immediately.

IMPORTANT: For further information consult the product MSDS (Material Safety Data Sheet).
