



Rekosil FMT 680 uses specially selected raw materials, showing excellent resistance to heat, an easy application and beautiful visual effect. Do not need thermal cure.

TECHNICAL CHARACTERISTICS

TYPE

One component acrylic-modified silicone topcoat.

USAGE

As coating for exterior of chimneys, stoves, driers, etc.

TECHNICAL INFORMATION

COLOR	Aluminum, White and Black	
FINISH	Semiglossy	
VOLUME SOLIDS	40% ± 2	According to ISO 3233
WEIGHT PER LITER	1,000 ± 0,05 g/ml	According to ASTM D 1475
FLASH POINT	30°C	
THEORETICAL SPREADING RATE	16,0 m ² /l - 25 µm	
WET THICKNESS	63 µm	
DRY THICKNESS	25 µm	
DRYING TIME, for 25 µm	25°C	

	Minimum	Maximum
Touch		30 min
Hard		1h a 150°C (see recommendations)
Recoat	24 h	

ENVIRONMENTAL 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	499.0000

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	
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 42 psi). Tank pressure between 0,5 to 1,5 kgf/cm ² (7 to 21 psi).

AirLess Spray Gun	Dilute up to 10% (vol.) with recommended thinner. Use nozzles between 21 to 27 and pump pressure between 140 to 175 kgf/cm ² (2000 to 2500 psi).
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SURFACE PREPARATION	Direct over carbon steel	If no anticorrosive protection is required, apply the product directly on the surface. Abrasive blasting Sa 2 ½ minimum is recommended for this case, according to ISO 8501-1. If the equipment operates at continuous temperature of maximum 400° C, without thermal shock, the recommended surface preparation only for the color aluminum is mechanical treatment St 3, according to ISO 8501-1. The surface must be dry, free of contaminants such as salt deposits, oil, grease, fat, dust and other kind of contaminants, and coated with adequate primer.
	Recommended Primers	Rezinc SIL 590 (590.0398) and Rezinc EPD 597 (597.0939). 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 6 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. When applied by brush or roller, aluminum pigmented paints might present a different visual effect due to uneven distribution of aluminum pigment.
 4. Color and gloss may vary if temperature is higher than 160°C.
 5. White and black colors: withstands steady temperatures of up to 250° C, and peak temperatures of up to 300°C.
 6. Equipment and piping that reach continuous temperature of 400°C or peak temperature of 450°C, provided that an adequate primer be used (applicable to aluminum color only).
 7. Its maximum performance is reached when the coated equipment works at temperature between 150°C to 250°C. It is convenient to increase this temperature slowly.
 8. The ink dries quickly (to the touch and handling), but the maximum hardness is obtained only when exposed to a temperature of 150 ° C for 1 hour.
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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.

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).
