



Rethane FHB 658 uses specially selected raw materials, showing excellent color and gloss retention, as well as great resistance to saline and very polluted atmospheres, deriving mainly from gas forming acidic solutions. It is an ecological product, high solids, low content of volatile organic compounds (*VOC low*). It is applied in high thickness and thus saves on number of coats. May be formulated with pigment free of heavy metals. Composed paint system approved to ISO 12944.

TECHNICAL CHARACTERISTICS

TYPE

Aliphatic acrylic polyurethane topcoat, two pack system.

USAGE

Recommended for over epoxy primer. Suitable for plating, deck, superstructure and accessories, metal structures, industrial equipment, marine and offshore. Used as an external coating of tanks and pipes.

TECHNICAL INFORMATION

COLOR	White	Other colors, please consult.	
FINISH	Glossy		
VOLUME SOLIDS	70% ± 2	According to ISO 3233	
WEIGHT PER LITER	1,50 ± 0,05 g/ml	According to ASTM D 1475	
FLASH POINT	32°C		
VOC	270 g/l		
MIXING RATIO		Weight	Volume
	Comp. A	100,0	4,0
	Comp. B	18,0	1,0
POT LIFE (25°C)	4 h		
INDUCTION TIME	15 to 30 min		
THEORETICAL SPREADING RATE	9,3 m ² /l - 75 µm 5,6 m ² /l - 125 µm		
WET THICKNESS	107 µm to 178 µm		
DRY THICKNESS	75 µm to 125 µm		
DRYING TIME, for 75 µm		25°C	
		Minimum	Maximum
	Touch		4 h
	Handle		8 h
	Recoat	8 h	30 days
ENVIRONMENTAL CONDITIONS	Temperature	Should be between 0 to 40°C. At temperatures below 10 ° C, add 1.4 % by volume of drying accelerator 870.0001.	
	Relative Humidity	Between 30 to 85%	
	Dew Point	Surface temperature is at least 3°C above dew point	
	Thinner	440.0000	



	Brush	It is not necessary dilution. This method must be used only for retouch and backing of welding cords and corners.
	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.
APPLICATION	Conventional Spray Gun	Dilute up to 10% (vol.) with recommended thinner. Conventional DeVilbiss JGA 502 EX 67 spray gun or similar. Spray pressure between 2,5 to 3,0 kgf/cm ² (35 to 43 psi). Tank pressure between 1,0 to 2,0 kgf/cm ² (14 to 29 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).
	Over recommended primer	The surface must be dry, free of contaminants such as salt deposits, oil, grease, fat, dust and other kind of contaminants.
SURFACE PREPARATION	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 Primers	Oxibar DST 535, Oxibar DAL 535, Revran PAA 540. Others primers, please contact our technical department.
	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 should be the last coat applied Rethane product DHG 652 Colorless to avoid staining of the film, due to the presence of water and / or moisture, and also due to handling parts already painted .
6. The practical performance of this material is variable according to film thickness, application method and application technique, the type and roughness of the substrate, environmental conditions, etc.
7. IMPORTANT: When the throttle drying used, should be added in the additive component A and mix. After additives, mixing the components A and B in a mechanical shaker for 5 minutes. WARNING: The pot life is reduced with additives.
8. If the recoat interval is exceeded, carry light sanding. For temperatures above the established, the recoat interval is reduced.
9. The 4th digit of the product number 7 indicates organic pigmentation and adds up the acronym ORG and may have restrictions in some colors.

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).
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