

REC COAT 672

SPRAYABLE CHEMICAL-RESISTANT EPOXY COATING

DESCRIPTION

REC COAT 672 is 100% solids, sprayable, high-build chemical-resistant epoxy coating. It is used to provide resistance to hydrogen sulfide attack in the water and sewage treatment industries. **REC COAT 672** eliminates the need for prefabricated or cast-in-place manhole liners.

PRIMARY APPLICATIONS

APPLICATION

- Applications requiring resistance to hydrogen sulfide
- Rehabilitating manholes
- Lining large diameter pipes
- Lift stations and pumping stations

LOCATION

- Vertical and overhead surfaces
- Nontraffic-bearing horizontal surfaces
- Interior and exterior below grade

SUBSTRATE

- Concrete and masonry.

KEY FEATURES

- High-build material
- Sprayable to thicknesses of up to 2.0 mm.
- Epoxy chemistry.
- Excellent resistance to hydrogen sulfide and many industrial chemicals.
- High bond strength.
- Moisture insensitive.
- Cures well in damp environments.
- Low odor.
- Suitable for application in confined spaces.
- 100% solids.
- Meets applicable federal and state VOC regulations.

TECHNICAL INFORMATION

PROPERTIES	RESULTS	TEST METHODS
Mixed viscosity, cps, #6 spindle, 50 rpm	9,000 – 11,000	Brookfield
Adhesion to dry or damp concrete, psi (MPa)	350 (2.4); minimum substrate failure	ASTM D 4541
Adhesion to SP15, psi (MPa)	350 (2.4); minimum substrate failure	ASTM D 4541
Tensile strength, psi (MPa)	3,000 (20.7)	ASTM D 638
Compressive strength, psi (MPa)	8,500 (58.6)	ASTM D 695
Shore D Hardness	78	ASTM D 2240
Tensile elongation, %	3	ASTM D 638
Compressive modulus, psi (MPa)	5 x 10 ⁵ (3,400)	ASTM D 695
Flexural strength, psi (MPa)	4,300 (29.6)	ASTM C 580
Flexural modulus, psi (MPa)	3.5 x 10 ⁵ (2,400)	ASTM C 580

Mixing ratio, by volume (Part A to B)	1: 1
Tack-Free Time	3 – 5 hrs. (at 24°C)
Final cure	7 Days
Weight change, After 1 year	
Sulfuric acid concentration	%
pH 1	0.7
pH 2	0.3
pH 3	0.3
Chemical Resistance	
Specimens Cured 7 days at 24° C; 1 month Immersion Time	
Bleach	Resistant*
Detergent	Resistant
Gasoline	Resistant
Sodium chloride (20% solution)	Resistant
Sodium hydroxide (20% solution)	Resistant
Sulfuric acid (5% solution)	Resistant
Sulfuric acid (10% solution)	Resistant
*Defined as no severe color change or deterioration of the samples	

DIRECTIONS FOR USE

SURFACE PREPARATION

CURED CONCRETE

1. Surface must be clean, structurally sound, and fully cured 28 days.
2. Remove any loose or unsound brick or concrete.
3. Surface must be entirely free of oil, grease, paint, detergent, rust, laitance, or other surface contaminants. Surfaces can be damp but must be free of standing water.
4. Abrade the surface by abrasive blasting or other mechanical scarification techniques to profile of ICRI CSP, Water blasting is not recommended.
5. For full surface restoration 1/2 – 4" (13 – 102 mm) deep, use SP15 Spray Mortar. Trowel or spray SP15 onto prepared surface and finish with a wood or plastic float.
6. Allow the SP15 to cure a minimum of 4 hours at 21°C before applying **REC COAT 672**. If the SP15 Spray Mortar cures for more than 12 hours, scarify surface to remove all laitance and prime the SP15 Spray Mortar with REC PRIMER before applying a coat of **REC COAT 672**.

MIXING

1. Precondition all components to 21°C for 24 hours before using.
2. If using a conventional airless sprayer, mix each component separately, then pour equal volumes of Part A and Part B into a clean pail. Scrape sides of containers to ensure correct mixing ratios.
3. Do not mix more material than is spray able within the pot life of the mixed material.
4. Mix Part A and B together thoroughly for about 3 minutes using a slow-speed mechanical mixer to obtain a uniform color.

PRIMING

Prime surface with REC PRIMER. Apply **REC COAT 672** after the primer has become tack free (3 hours at 21°C. Re coat with **REC COAT 672** no later than 48 hours after priming with REC PRIMER.

APPLICATION

SPRAY APPLICATION

Spray applies with an airless sprayer with a high- pressure spray hose with an I.D. of 3/8" and a gun with a heavy-duty tip (0.025 – 0.031). For moderate chemical conditions, apply **REC COAT 672** at 0.76 mm at approximately 1.3 m²/L. Harsh chemical environments require thicker applications at 2.0 – 3.2 mm. Two coats may be required to achieve a void-free film on very porous surfaces. Do not use this product if the air, substrate, or material temperature is below 7°C or expected to fall below 7°C within 12 hours of application.

ROLLER APPLICATION

Use a 1/4" (6 mm) nap synthetic roller. Only mix enough material that can be applied within 20 minutes. Be aware that spraying is the preferred method of application.

RECOATING

Re coat within 24 hours at 21°C. After 24 hours, mechanically abrade the entire surface of the coating and clean with acetone or MEK. Allow **REC COAT 672** to dry and reapply coating within 1 hour.

CLEAN UP

Purge the airless system with xylene before material has time to set. Cured material must be removed mechanically.

FOR BEST PERFORMANCE

- Precondition all components to 21°C for 24 hours before using.
- Do not use this product if the air, substrate, or material temperature is below 7°C or expected to fall below 7°C within 12 hours.
- Temperature variations affect non sag properties of this product. Higher temperatures may cause the product to sag; lower temperatures will decrease workability of product by causing it to thicken.
- Do not thin; solvents will prevent proper curing.
- Make certain the most current versions of product data sheet and MSDS are being used.
- Proper application is the responsibility of the user. Field visits by RECKON personnel are for the purpose of making technical recommendations only and not for supervising or providing quality control on the job site.

PACKAGING

REC COAT 672 is available in 6kg, 20 kg and 30 kg packs.

STORAGE

REC COAT 672 has a shelf life of 12 months when stored in warehouse conditions below 35°C in the original, unopened packs.

HEALTH & SAFETY

As with all construction chemical products, caution should always be exercised. Protective clothing such as gloves and goggles should be worn. Treat any splashes to the skin or eyes with fresh water immediately. If irritation persists, seek medical assistance immediately.

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