

RTB-653-R is a temperature-resistant resin bonded and lubricant and coating. It has been formulated to provide corrosion protection combined with dry film lubrication properties against non-ferrous melting metals in continuous casting dies and is suitable for use in interior coating systems for crucibles.

### USES AND SUITABLE TOP-COATS

**Recommended Uses** This coating is designed as a bulk or spray application material when applied with proper film thickness and cured. coating will provide over 100 hours salt spray resistance on test panels according to ASTM Test Method B-117.

### CHEMICAL COMPOSITION

Type of Binder	Heat-Resistant Resins	Solid Content	50 ± 1% By Weight
Number of Component(s)	1 Components		29 ± 2% By Volume
Curing Mechanism	Solvent Evaporation and Oxidation		
Main Pigment(s)	Silver Graphite Micronized Powder.	Flash Point	28°C (82°F)

### PHYSICAL PROPERTIES

Finish	Semi gloss
Colour	Graphite Grey
Specific Gravity	1.20 ± 0.02 gr/cm <sup>3</sup>

### APPLICATION DETAILS

**Surface Preparation** All oil, grease, dirt and other contaminants must be removed from the surface. Wire brush or hand tool cleaning is recommended.

**Theoretical Consumption** 1240 gr/m<sup>2</sup> @ 300 Microns DFT

Paint Application	Methods	Airless Spray	Air Spray	Brush
	Nozzle Size	---	1.80	---
	Pump Ratio	---	---	---
	Air Pressure	---	4 – 6 Bar	---
	Thinning	---	10 – 20% T-411	3 – 5% T-411

Film Thickness		Recommended	Minimum	Maximum
	Wet Film Thickness (µm)	1035	690	3450
	Dry Film Thickness (µm)	300	200	1000

Drying Time	Dust Free Time	Tack Free Time	Dry to Handle
	20 – 40 Minutes	2 – 3 Hours	12 – 16 Hours

*Drying time calculated at 25°C according to ASTM test method D-1640 for 100 µm WFT*

Application Limits	Relative Humidity	Min. ---	Max. 80%
	Temperature	Min. +5°C	Max. +40°C
	Substrate Temperature*	Min. +5°C	Max. +45°C

*\*Please note that the substrate temperature should be at least 5°C above the dew point*

**Recommendations** -Should the recoating interval have expired, please refer to the procedures outlined in the Ronass Instruction Leaflet.  
-Clean tools thoroughly before and immediately after use with cleaning solvent T-111 or T-411.

### PACKING, STORAGE AND SAFETY

Packing	6 Litres Containers (6 kgs. Net)
Storage Conditions	To be stored in cool and dry conditions in original sealed containers.
Shelf Life	At least 12 months after delivery in original sealed containers and proper storage conditions with temperature of 25°C.
Safety	This product contains organic solvents and flammable materials. Keep away from sparks, fires, electrical cables and equipments, direct sunshine and out of children's reach.
	Protect skin, eyes, and avoid prolonged breathing of solvent vapor during application. Use with adequate ventilation.