

FULL METAL JACKET™

FMJ-6000 Emergency Repair

PRODUCT FEATURES & BENEFITS:

FMJ Enterprises specialty coatings are providing the best in corrosion protection, while being safe for our environment and totally user friendly.

FMJ-6000 is a fast version of our high performance FMJ-5100 metal repair. FMJ-6000 is easy to use in machine shops or out in the field to repair and rebuild equipment. Excellent for setting keyways, fixing leaks, and tapered fits.

- 100% Solids, No VOCs
- Excellent mechanical strength in minimal time
- Excellent chemical resistance
- Rapid return to service

SURFACE PREP:

Surfaces must be prepped by removing all surface contaminants and then grit blast to obtain a NACE No. 1 (SSPC-SP5) or 3 mil profile. Sweat/Bake oily chemical saturated pieces before blasting. This process should be repeated until all salts are removed.

MIXING & APPLICATION:

FMJ-6000 is a two component material. Once opened mix entire sachet. The two components should be thoroughly mixed until completely streak free. Apply thin layers to surface to achieve maximum thickness desired. To rebuild use reinforcement cloth embedded with FMJ-6000.

TOP-COATING & JOINING ADJACENT SECTIONS:

If the compound is to be coated, apply the coating within the re-coat window (see table). If this is not possible, allow the compound to cure, then brush-blast, wire-

brush or sand to create a mechanical profile on the surface before coating.

When it is necessary to join multiple sections of the compound to create a continuous protective layer over a large area, do not attempt to feather and overlap adjoining sections. If adjoining sections cannot be applied within the re-coat window (see table below), continue the full thickness of the compound up to the joint between sections. Allow the first section to cure, and then create a mechanical profile, using one of the means listed above, on the edge that will be joined to the next section to ensure a satisfactory bond.

PHYSICAL PROPERTIES:

Color	Grey
Coverage per 170 gm (Theoretical)	6.3 cu.in. per 170 gm unit
Mix Ratio	Entire Sachet
Flash Point	>200°F (93.5°C)
Pull-Off Adhesion Test ASTM D 4541	Minimum adhesion is 2550 psi
Volatile Organic Compounds (VOC)	0 grams/liter
Weight per 170 gm	0.375 lbs
Compressive Strength ASTM D698	15693 psi
Flexural Strength ASTM D790	7000
Hardness ASTM D785	85

CURE TIME (68°F):

Working Time	5 minutes
Re-coat Window	20 minutes
Machining	45 minutes
Mechanical	45 minutes
Chemical Service	3 hours

“Put A Jacket On It”™

FMJ-6000 Emergency Repair

NOTE: Mix resin and hardener on provided mixing board. Do not leave in a large pile. Exotherm heat created during the curing process will considerably shorten the pot life. Spread material out on mixing board.

SERVICE TEMPERATURE:

Dry Service	250°F (121°C)
Spill/Splash	212°F (100°C)
Immersion Service*	140°F (60°C)

*Immersion with solvents, mineral acids, or alkalines, or if over 150°F, contact Distributor.

CHEMICAL RESISTANCE:

- Acetic Acid (up to 10%)
- Ammonium Hydroxide*
- Aromatic & Aliphatic Solvents
- Black Liquor
- Butyl Acetate
- Butyl Carbitol
- Chlorides (Most)
- Hydrogen Sulfide
- Isopropyl Alcohol
- Mineral Acids
- Nitric Acid (up to 20%)

- Organic Acids (Mild)
- Phosphates (Most)
- Phosphoric Acid
- Potassium Hydroxide*
- Sodium Hydroxide*
- Sulfides (Most)
- Sulfuric Acid (up to 50%)
- Urea Solutions
- White Liquor

*Ambient temperature only

ORDERING INFORMATION:

For additional information, prices, or to place an order, please contact your Full Metal Jacket sales representative.

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