

# 3M™ Scotchkote™ Epoxy Coating 162PW

## Data Sheet and Application Guide

### Product Description

Scotchkote Epoxy Coating 162PW has been specifically developed as a 100% solids lining for the internals of tanks, vessels and other equipment in contact with potable water.

### Product Features

- Combines good application characteristics with excellent corrosion protection and chemical resistance.
- Is designed for application in two or more coats by brush or roller.
- Is primarily intended for use on steel.

To comply with the conditions of approval under Regulation 31(4)(a), this product must be applied in accordance with the approved Instructions For Use Document 10T-F, available from the Northallerton Technical Centre on request.

- **Adhesion** - Excellent to correctly prepared surfaces.
- **Abrasion Resistance** - Excellent resistance to abrasion and mechanical damage.
- **Erosion resistance** - Excellent erosion resistance, suitable for use on aqueous slurries.

### General Application Steps

1. Remove oil, grease and loosely adhering deposits.
2. Abrasive blast clean steel surfaces to NACE No. 2/SSPC-SP10 Near White Metal, ISO 8501:1, Grade SA2½ .
3. Apply Scotchkote Epoxy Coating 162PW at the specified thickness.
4. Allow to cure.
5. Visually or electrically inspect the coating for defects.
6. Repair all defects.

### Properties

Property	Value
Colour	Grey or Water Industry Blue <b>Note:</b> Not colour stable, where a colour stable finish is required it must be overcoated with an appropriate top coat.
Ratio	2:1 By volume
<b>Drying &amp; Cure times at 20°C (68°F)</b>	
Usable Life	45 mins
Touch Dry	6 hours
Minimum Overcoating	6 hours
Maximum Overcoating	24 hours <b>Note:</b> For overcoating see Application Procedures over.
Full Cure	7 days
Volume Solids	100%
Specific Gravity (Average Mixed)	1.5
Film Thickness (Typical)	Wet/Dry 250 microns per coat. <b>Note:</b> Normally applied as a two coat system to achieve a minimum dry film thickness of 500 microns. Detailed application instructions in the form of system recommendations are available on request.
Theoretical Coverage Rate	4 sq metres per litre at 250 microns dft.
Standards Met	BS6920 – WRAS Listed UK Water Regulations 31(4)(a)
<b>Performance Data</b>	
Abrasion Resistance	40mgm weight loss per 1000 cycles - 1kg load-CS17 wheel (ASTM D4060)
Impact Resistance	0.26kg.m (ASTM D2794)
Direct Pull Adhesion	12Mpa (1760 psi) - grit blasted steel (ASTM D4541)
Water Vapour Permeability	3.75 x 10 <sup>-6</sup> perm.cm (ASTM D1653)
Pencil Hardness	5H (ASTM D3363)
Salt Fog Resistance	Excellent, unaffected after 5,000 hours exposure (ASTM B117)
Cathodic Disbondment	Pass <6mm (ASTM G8)
Humidity Resistance	Unaffected 5,000 hours exposure (BS 3900 Part F2)
Scratch Resistance	No failure 2.5kg (5.5lbs) load (BS 3900 Part E2)



# Application Procedures for 3M™ Scotchkote™ Epoxy Coating 162PW

## Surface Preparation

**Steel Surfaces** - Steel surfaces should be abrasive blasted in accordance with NACE No 2/SSPC-SP10 Near White Metal, ISO 8501-1 grade Sa2½ or equivalent. The blast profile is generally specified by the client, a typical profile is 75-100 microns. Where blast cleaning cannot be carried out the surface should be mechanically abraded to remove all loose scale and produce a surface which is clean, dry and free from rust or dust and provide a coarse surface profile.

## Product Mixing

Scotchkote Epoxy Coating 162PW is a two component material comprising Part A (Base) and Part B (Activator) components which must be mixed together prior to use. Stir the contents of the Part A (Base) component, continue stirring and gradually add the total contents of the Part B (Activator) container, stir the combined mix until completely homogeneous.

The mixed materials should be used within 45 minutes of mixing at 20°C. This time will be reduced at higher temperatures and extended at lower temperatures.

## Handling and Safety Precautions

Read all health hazard, precautionary and first aid statements found in the Material Safety Data Sheet, and/or product label prior to handling or use.

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## Application Procedures

### a) Multi Coat/Stripe Coat Applications.

Do not apply when the Relative Humidity exceeds 70% or when the surface to be coated is less than 3°C above the dew point. Minimum temperature for application and subsequent curing is 10°C.

**b) Single Coat Application.** Do not apply when the Relative Humidity exceeds 85% or when the surface to be coated is less than 3°C above the dew point. Minimum temperature for application is 7°C.

Scotchkote Epoxy Coating 162PW is primarily designed for application by brush or roller. Good quality brushes or short to medium pile rollers should be used for these methods of application. The product should be applied to give a uniform even coating thickness and optimum results are achieved when both material and substrate temperatures above 15°C.

Clean all equipment immediately after use with 3M™ Scotchkote™ Thinners SA65.

## Packaging and Storage

Supplied in 1 litre and 5 litre packs

Use within 5 years of date of manufacture. Store in original sealed containers at temperatures between 5°C and 32°C.

## Ordering Information/Customer Service

For ordering, technical and product information or to request a copy of the Material Safety Data Sheet, call +44 (0)1609 780170 or fax +44 (0)1609 783762 (Sales) or 788718 (Technical).

For emergencies, please contact +44 (0)1344 858000.

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