

# 3M™ Scotchkote™ Epoxy Coating KS16W

## Data Sheet and Application Guide

### Product Description

Scotchkote Epoxy Coating KS16W is a solvent based two component material designed for use in wet/immersed aqueous conditions at temperatures up to 120°C.

### Product Features

- Combines good application characteristics with excellent corrosion protection and temperature resistance.
- Widely used for protection of desalination equipment.
- Reaction to fire performance test data available on request.

**Adhesion:** Excellent on correctly prepared surfaces.

**Chemical Resistance:** The fully cured coating offers outstanding resistance to aqueous solutions.

**Temperature resistance:** Service temperature range up to 150°C dry 120°C wet.

### 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 KS16W in 3 or 4 coats to achieve 200-250 microns dft.
4. Allow to cure.
5. Visually or electrically inspect the coating for defects.
6. Repair all defects.

### Properties

Property	Value
Colour	Red Oxide
Ratio	4:1 by volume
<b>Drying &amp; Cure times at 20°C (68°F)</b>	
Usable Life	Approximately 6 hours
Touch Dry	4 hours
Hard Dry	16 hours
Overcoating Minimum	16 hours
Maximum	7 days
Full Cure	7 days
Volume Solids (Average by Volume)	50%
Specific Gravity (Average Mixed)	1.40
V.O.C (As Supplied)	407gm/litre
V.O.C. (Thinned 10%)	447.5gm/litre
Film Thickness (Typical)	Wet 100 microns. Dry 50 microns
	Wet 150 microns, Dry 75 microns
Theoretical Coverage Rate	10 sq metres per litre at 50 microns dft.
	6.67 sq metres per litre at 75 microns dft.



# Application Procedures for 3M™ Scotchkote™ Epoxy Coating KS16W

All surfaces should be thoroughly degreased.

Steel including Stainless Steel: Abrasive blast clean to NACE No. 2/SSPC-SP10 near white metal, ISO 8501:1, Sa2½ BS 7079 Part A1 1989/ISO 8501-1: 1988 - with a medium profile - 35 microns average

## Application Procedures

### Mixing

Stir the contents of the Part A (Base) component. Continue stirring whilst gradually adding the total contents of the Part B (Activator) container. Continue stirring until a homogeneous mix is obtained.

### Application

#### Conditions for Application

- Do not apply when the relative humidity exceeds 90°C or when the surface to be coated is less than 3°C above the dew point.
- Minimum temperature for application is 7°C.

#### Method

Scotchkote Epoxy Coating KS16W can be applied by brush, roller, conventional or airless spray, with airless spray being the preferred method

## 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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Typical spray settings are as follows :-

**Airless Spray 30:** 1 pump ratio minimum

**Tip Size:** 13-15 Thou orifice;

**Tip pressure:** approx 2000 psi (145 Bar)

**Conventional Spray Pressure Pot Needle Setup:**

1.4 - 1.8 mm

Scotchkote Epoxy Coating KS16W normally requires thinning for spray application, and approximately 10%. 3M™ Scotchkote™ Thinners SA65 should be added depending on the equipment being used. Clean all equipment after use with Scotchkote Thinners SA65

**Note** When airless spray is being used, excessively high tip spraying pressures should be avoided. The minimum pressure at the pump conducive with good atomisation should be used.

Scotchkote Epoxy Coating KS16W is normally applied as a 3/4 coat system. The thickness of each coat should be 50-75 microns giving a total dry film thickness of 200-250 microns. The final coat must be allowed to cure for a minimum of 7 days before being put into service.

### Packaging and Storage

Supplied in 5 and 20 litre packs.

Use within 2 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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