3M™ Scotchkote™ Epoxy Coating 162 HB

Data Sheet and Application Guide

Product Description

Scotchkote Epoxy Coating 162 HB has been specifically developed as a 100% solids lining for the internals of pipes, tanks, vessels and other equipment in contact with fresh water, sea water, oil and effluent. The product can also be used on externals of pipes where an abrasion-resistant system is required.

Product Features

Scotchkote Epoxy Coating 162 HB combines good application characteristics with excellent corrosion protection and chemical resistance.

Scotchkote Epoxy Coating 162 HB is designed for application in a single high build coat of up to 1mm, by plural feed hot airless spray.

Scotchkote Epoxy Coating 162 HB is suitable for use on both steel and concrete surfaces.

- **Adhesion—**Excellent to both blast cleaned and mechanically scraped surfaces.
- **Corrosion Resistance—**Excellent even under aggressive immersion conditions.
- **Chemical Resistance—**Virtually unaffected by crude oil and most industrial chemicals.
- **Temperature Resistance—**Suitable for use up to 100°C in immersion service conditions and up to 120°C in dry service conditions.

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. Scarify or lightly blast concrete surfaces and seal with 3M™ Scotchkote™ Epoxy Sealer 810.
3. Apply Scotchkote Epoxy Coating 162 HB 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	Light Grey or Red
Ratio	2:1 By volume 2:1 By weight
Drying & Cure times at 20°C (68°F)	
Touch Dry	6 hours
Hard Dry	16 hours
Full Cure	7 days
Volume Solids	100%
Shelf Life	Use within 5 years of date of manufacture. Store in original sealed containers at temperatures between 5°C (40°F) and 30°C (86°F).
Specific Gravity (Average Mixed)	1.57
Film Thickness (Typical)	Wet/Dry: 500 microns. **Note:** The actual thickness to be applied should be agreed between the specifier and the manufacturer dependant on operational performance criteria and may be higher or lower than the quoted typical value.
Theoretical Coverage Rate	2 sq metres per litre at 500 microns dft.

Application Procedures for 3M™ Scotchkote™ Epoxy Coating 162 HB

Surface Preparation: Steel Surfaces

Steel surfaces should be abrasive blasted to NACE No 2/ SSPC-SP10 near white metal, ISO 8501:1 Grade Sa2½. The blast profile is generally specified by the client; a typical profile is 75–100 microns.

Concrete Surfaces

Concrete surfaces should be lightly abrasive blasted or mechanically scarified, taking care not to expose the aggregate. All dust and loose residue should then be removed and surfaces then sealed using 3M™ Scotchkote™ Epoxy Sealer 810.

Application

Do not apply Scotchkote Epoxy Coating 162 HB when the relative humidity exceeds 90% of when the surface to be coated is less than 3°C above the dew point. The minimum temperature for application is 5°C.

Scotchkote Epoxy Coating 162 HB is intended for application by plural feed airless spray. A material temperature of 40-60°C is required, which should be attained by heating the Part A and Part B components.

- Tip pressure typically 4000 psi
- Tip Size 19-25 Thou orifice;
- Airless Spray Minimum 45:1 pump ratio

For small areas, good quality brushes and mohair rollers should be used.

Clean all equipment immediately after use with 3M™ 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 atomization should be used.

Packaging and Storage

Supplied in 1 litre packs or the Part A and Part B supplied separately in 18 and 180 litre units, (2 x Part A + 1 x Part B)

Use within 5 years of date of manufacture. Store in original sealed containers at temperatures between 5°C and 30°C.

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.

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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