

3M™ Scotchkote™ Epoxy Coating 162 PWX

Data Sheet and Application Guide

Product Description

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

Product Features

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

Scotchkote Epoxy Coating 162 PWX is designed for application in a single high build coat by plural feed hot airless spray and has international approvals for contact with potable water.

Scotchkote Epoxy Coating 162 PWX is suitable for use on steel surfaces and cement mortar lined pipes.

- **Adhesion**—Excellent to both blast cleaned and mechanically scraped surfaces.
- **Corrosion Resistance**—Excellent even under aggressive immersion conditions.
- **Temperature Resistance**—Suitable for use up to 80°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.
3. Apply Scotchkote Epoxy Coating 162 PWX 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
Ratio	2:1 By volume 2:1 By weight
Drying & Cure times at 20°C (68°F)	
Touch Dry	4 hours
Hard Dry	6 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)	1.48
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. Note: For NSF certified applications the maximum approved thickness is 1mm (40mil)
Theoretical Coverage Rate	2 sq metres per litre at 500 microns dft.
Potable Water Approvals	
UK	Regulations 31(4)a, WRAS
France	AFNOR XP P 41-256
USA	ANSI/NSF 61
Australia	AS/NZS 4020
Spain	OTEC
Italy	ARPAL



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

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.

Application Procedures

Do not apply the product when the relative humidity exceeds 90% or when the surface to be coated is less than 3°C above the dew point. The minimum temperature of application is 7°C.

Scotchkote Epoxy Coating 162 PWX is intended for application in a single coat by plural feed airless spray. A material temperature of 35–65°C is required, which should be attained by heating the Part A and Part B components.

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

For small areas, good quality brushes and mohair rollers should be used, a material and substrate minimum temperature of 10°C is advisable when using hand application.

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 information, technical information, product information, or to request a copy of the Material Safety Data Sheet, call:

Phone: +44 (0) 1609 780170

Fax: +44 (0) 1609 783762 (Sales)/788718 (Technical)

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

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