3M™ Scotchkote™ Epoxy Coating 175UC

Data Sheet and Application Guide

Product Description

Scotchkote Epoxy Coating 175UC has been specifically developed as a 100% solids lining for the internals of tanks, vessels and other equipment in contact with aggressive chemicals.

Product Features

- Combines good application characteristics with excellent corrosion protection and ultimate chemical resistance.
- Is designed for application in two or more coats by brush or roller.
- Is primarily intended for use on steel but can also be used on concrete surfaces with the appropriate primer.
- **Adhesion -** Excellent to currently prepared surfaces.
- **Abrasion Resistance -** Excellent resistance to abrasion and mechanical damage.
- **Chemical Resistance -** Suitable for continuous immersion in inorganic acids.

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 SP 810.
3. Apply Scotchkote Epoxy Coating 175UC 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 and Dark Grey
Ratio	2:1 By volume
Drying & Cure times at 20°C (68°F)	
Usable Life	30 mins
Touch Dry	4½ hours
Minimum Overcoating	4½ hours
Maximum Overcoating	24 hours **Note:** For overcoating see Application Procedures over.
Full Cure	7 days
Volume Solids	100%
Specific Gravity (Average Mixed)	1.15
Film Thickness (Typical)	Wet/Dry 250 microns per coat. **Note:** Normally applied as a two coat system by brush to achieve a minimum dry film thickness of 500 microns. Can be applied in single coat by hot airless spray at 500 microns. Detailed application instructions in the form of system recommendations are available on request.
Theoretical Coverage Rate	3.54 sq metres per kg at 250 microns dft.

Application Procedures for 3M™ Scotchkote™ Epoxy Coating 175UC

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 with a coarse profile which is clean, dry and free from rust or dust.

Concrete Surfaces - 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 SP 810.

Product Mixing

Scotchkote Epoxy Coating 175UC is a two component material comprising Part A and Part B components which must be mixed together prior

to use. Stir the contents of the Part A component, continue stirring and gradually add the total contents of the Part B container, stir the combined mix until completely homogenous. The mixed materials should be used within 30 minutes of mixing at 20°C (68°F). This time will be reduced at higher temperatures and extended at lower temperatures.

Application Procedures

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 5°C.

Best application results are obtained at a minimum substrate and product temperature of 20°C. For optimum chemical resistance the product must be applied and allowed to cure at a minimum temperature of 20°C for at least 7 days before chemical contact.

Scotchkote Epoxy Coating 175UC 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

Packaging and Storage

Supplied in 2, 5 and 20 kilo packs

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).

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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