

3M™ Scotchkote™ Epoxy Coating KSIR88

Data Sheet and Application Guide

Product Description

Scotchkote Epoxy Coating KSIR88 has been specifically developed as a high performance internal lining for pipelines and tanks.

Product Features

Scotchkote Epoxy Coating KSIR88 combines good application characteristics with excellent corrosion protection and chemical resistance.

Scotchkote Epoxy Coating KSIR88 is WRAS listed for use in contact with potable water.

- **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, mixtures, sour gas, petrochemical products and most industrial chemicals.
- **Temperature Resistance**—Suitable for use up to 120°C in dry service conditions and 90°C in wet 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 KSIR88 coating 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	Off White, Light Grey and Water Industry Blue
Ratio	3.5:1 By volume
Drying & Cure times at 20°C (68°F)	
Usable Life	4 hours
Touch Dry	1 hour
Overcoating	6 hours (min) 48 hours (max)
Hard Dry	8 hours
Full Cure	7 days
Volume Solids	60%
Shelf Life	Use within 2 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)	1.30
V.O.C. (As Supplied) V.O.C. (Thinned 10%)	350g/litre 393g/litre
Film Thickness (Typical)	125 microns dft 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	4.8 sq metres per litre at 125 microns dft.



Application Procedures for 3M™ Scotchkote™ Epoxy Coating KSIR88

Surface Preparation

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 35–75 microns.

Mixing

The contents of the Part A container should be stirred, and while stirring, the contents of the Part B container should be added with stirring continuing until a homogenous mix is achieved.

Application

Do not apply when relative humidity exceeds 90% or when surfaces to be coated are less than 3°C above the dew point.

Scotchkote Epoxy Coating KSIR88 can be applied by brush, roller, conventional or airless spray, with airless spray being the preferred method.

- Airless Spray Minimum 30: 1 pump ratio
- Tip Size 13–15 Thou orifice;
- Tip pressure minimum 2500 psi (175 bar)

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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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 either 4 and 20 litre packs or 200 litre bulk containers.

Use within 2 years of date of manufacture. Store in original sealed containers at temperatures between 5°C and 30°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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