

3MTM ScotchkoteTM Epoxy Coating EA 29

Data Sheet and Application Guide

Product Description

Scotchkote Epoxy Coating EA 29 is solvent based two component high performance anti corrosive primer. specifically developed to provide high degree of corrosion resistance.

Product Features

- Combines good application characteristics with excellent corrosion protection.
- As a primer, it offers long term corrosion protection of ferrous metallic substrates.
- As the basis of multi coat system, Scotchkote Epoxy Coating EA29 can be over coated with itself or with other Scotchkote finishes.
- **Adhesion** - Excellent to both blast cleaned and mechanically scraped surfaces.
- **Corrosion Resistance** - Excellent even under aggressive conditions.
- **Chemical Resistance** – The fully cured coating offers outstanding resistance to aqueous solutions and wide range of industrial chemicals. Consult 3M Technical for specific chemical exposure.
- **Temperature Resistance** – Suitable for use up to 100°C in dry service condition

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 EA 29 at the specified thickness.
4. Allow to cure.
5. Inspect the coating visually and Repair application defects, if any.

Properties

Property	Value
Colour	Red Oxide
Ratio	1:1 by Volume
Drying & Cure times at 20°C	
Usable Life	8 hours
Touch Dry	2 hours
Hard Dry	16 hours
Full Cure	7 days
Volume Solids	50%
Shelf Life	Use within 2 years from Manufacturing. Store in original sealed containers at temperatures between 5°C and 35°C.
Specific Gravity	1.14
Film Thickness per coat (Typical)	Wet: 150 - 250 microns Dry: 75 -125 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	5 sq metres per litre at 100 microns
Cleaning Thinner	Scotchkote TM Thinner SA 65

Performance Data

(Tested at 200 microns DFT)

Salt Fog Resistance	Excellent, unaffected after 3000 hours exposure (ASTM B 117)
Humidity Resistance	Unaffected after 1000 hours exposure (ASTM D 2247)
Direct Pull Adhesion	10 MPa (On abrasive blasted steel) (ASTM D 4541)
Abrasion Resistance	Weight loss not more than 75 mg (CS 10 Wheel, 1Kg load, 1000 Cycles) (ASTM D 4060)
Scratch Resistance	2 Kg minimum (BS 3900 Part E 2)



Application Procedures for 3M™ Scotchkote™ Epoxy Coating EA 29

Surface Preparation:

All surfaces should be thoroughly degreased

Steel Surfaces including Stainless steel

Abrasive blast clean to NACE No 2/ SSPC-SP10 near white metal, ISO 8501:1 Grade Sa2½. With a typical profile in the range of 35 – 50 microns. Slivers, rough welds, or other defects in the steel shall be ground out prior to abrasive blasting.

Application Procedures

Mixing:

Stir the contents of 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:

Do not apply when relative humidity exceeds 90% or when surfaces to be coated are less than 3°C above the dew point. 3M Scotchkote Epoxy Coating EA 29 can be applied by brush, roller, conventional or airless spray with airless spray being a preferred method.

- Airless Spray Minimum 30: 1 Pump Ratio
- Tip Size 15 – 21 Thou orifice
- Tip Pressure minimum 2500 psi (175 bar)

Conventional Spray Pressure Pot

- Needle setup 1.4 – 1.8 mm

Scotchkote Epoxy Coating EA 29 will require thinning for conventional spray application. For Airless spray application thinning may be required.

Clean all equipment immediately after use with 3M™ Scotchkote™ Thinners SA 65.

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

Storage, Handling and Safety Precautions

Store in original sealed containers under shed at temperatures between 5°C and 35°C. 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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