

3M™ Scotchkote™ 321 Liquid epoxy Rust Preventive Coating

Data Sheet and Application Guide

Product Description

Scotchkote 321 Liquid Epoxy Rust preventive coating has been specifically developed as an anti corrosive coating for steel structures that cannot be abrasive blast cleaned.

Product Features

- Designed for room temperature drying as well as baking as per cure requirements.
- Combines good application characteristics with excellent corrosion protection.
- Designed for application by brush, roller, dipping or spray.
- Suitable for use on mechanically prepared steelwork or high pressure water cleaned steel, (abrasive blasting is not mandatory).
- Can be applied over existing coatings.
- Can be used as a two coat primer/finish system or overcoated with Rust preventive clear top coats

General Application Steps

1. Remove oil, grease and loosely adhering deposits and all visible water.
2. Appropriately prepare the surface
3. Apply Scotchkote Rust preventive coating.
4. Allow to dry.
5. Visually inspect the coating for defects.
6. Repair all defects.

Properties

Property	Value
Color:	Black, Black tinge and Clear

Room temperature drying at 30°C (86°F)

Touch Dry 15 Minutes

Hard Dry 1 Hour

Minimum Overcoating 1 Hour

Maximum Overcoating 72 Hour

Drying for testing: 7 days

NVM 25% (+/-3%)

Volume Solids 20% (+/-3%)

Specific Gravity 0.92 (+/-0.03)

Film Thickness 75-100µ Wet,
15- 20 µ Dry.

Theoretical Coverage Rate	13.14	m ² /L@15µ dft.
	9.89	m ² /L@20µ dft.
	7.88	m ² /L@25µ dft.

Baking: 5-10 Minutes of flash off period should be given before baking for hard dry of coating. Baking should be done as per below schedule:

80 °C	20 Min
100°C	15 Min
120°C	10 Min
150°C	05 Min
180°C	01 Min
260°C	30 Sec

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. Detailed system recommendations are available on request. Product is primarily designed for single coat application, however if surface is abrasive blasted then 2 coats of application are recommended.



Application Procedures for 3M™ Scotchkote™ 321 Liquid epoxy Rust Preventive Coating

Surface Preparation

Surfaces should be clean and free from oils, grease, loosely adhering deposits and visible moisture.

Previously coated surfaces should be abraded using 180 grade emery paper. Any loosely adherent coating must be removed and surrounding areas feather edged.

Where blast cleaning is possible surfaces should be prepared to NACE No 3/SSPC-SP6, ISO 8501-1 grade Sa2 or equivalent.

Application Procedures

Product Mixing:

This is a single component material, ensure homogeneous mixing prior to use, should be thoroughly stirred to incorporate any slight separation.

Application

Application should not be carried out at temperatures below 5°C (40°F), nor when humidity exceeds 90% or when surface to be coated is less than 3°C above the dew point. All loose rust, millscale, and loosely adherent coatings must be removed. Ideal methods of achieving the surface preparation are high pressure water jetting, mechanical wire brushing, needle gun, mechanical grinders etc. Surfaces that can be abrasive blast cleaned should be prepared to a minimum standard of Sa 2 BS7079:Part A1 1989 or equivalent. All oil and grease must be removed by the use of 3M™ Scotchkote™ Thinners or approved degreasers prior to carrying out surface preparation. Clean all equipment immediately after use with Scotchkote thinners or recommended solvent by our technical representative.

Packaging and Storage:

Supplied in 5, 20 and 200 litre units.

Use within 9 months of date of manufacture. Store in original sealed containers at temperatures between 5°C (40°F) and 30°C (86°F). ALWAYS PROTECT FROM FROST DURING STORAGE

Handling and Safety Precautions

Read all Health Hazard, Precautionary and First Aid, Material Safety Data Sheet, and/or product label prior to handling or use.

Ordering Information/Customer Technical Service

For ordering, technical and product information or to request a copy of the Material Safety Data Sheet, call 1-800- 425-30-30

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