

3M™ Scotchkote™ Epoxy Primer MC 135

Data Sheet and Application Guide

Product Description

Scotchkote Epoxy Primer MC 135 is a solvent based two component primer suitable for use on a wide range of metallic and GRP surfaces prior to the application of Scotchkote finish systems.

Product Features

- Combines good application characteristics with excellent adhesion to correctly prepared surfaces.
- As a primer, it offers proven long term corrosion protection of ferrous and non ferrous metallic substrates.
- Extended overcoating window for a wide range of top coats.
- Can be applied by brush, roller or spray.

General Application Steps

1. Remove oil, grease and loosely adhering deposits.
2. Appropriately prepare the surface
3. Apply Scotchkote Epoxy Primer MC 135 coating at the specified thickness
4. Allow to cure.
5. Visually inspect the coating for defects.
6. Repair all defects.

Properties

Property	Value
Colour	Light Grey and White
Ratio	3:1 By volume
Drying & Cure times at 20°C (68°F)	
Usable Life	8 hours
Touch Dry	4 hours
Hard Dry	16 hours
Minimum Overcoating	16 hours
Maximum Overcoating	3 months
Full Cure	7 days
Volume Solids	50%
Specific Gravity	1.34
V.O.C	475g/litre as supplied 510g/litre thinned 10%
Film Thickness	100 microns wet, 50 microns dry.
Theoretical Coverage Rate	10 sq metres per litre at 50 microns dft..
Performance Data	
Abrasion Resistance	70mgm weight loss per 1000 cycles - 1kg load- CS17 wheel (ASTM D4060)
Impact Resistance	Direct - 5mm (0.2 inch) Reverse - 2.5mm (0.1 inch) (BS 3900 - E3)
Dry Heat Resistance	100°C (212°F) (ASTM D2485)
Direct Pull Adhesion	3.8N/mm ² (550 psi) (Abrasive Blasted Steel) (ASTM D4541)
Salt Fog Resistance	Excellent, unaffected after 500 hours exposure (ASTM B117)
Humidity Resistance	Unaffected 500 hours exposure (BS 3900 - F2)
Scratch Resistance	No Failure 2.5kg (5.5lbs) load (BS 3900 - E2)



Application Procedures for 3M™ Scotchkote™ Epoxy Primer MC 135

Surface Preparation

All surfaces should be thoroughly degreased.

Steel: Surfaces should be mechanically abraded to create a profile.

Aluminium: Mechanically abrade with 120 grade paper or Scotchbrite pad.

Galvanised Steel: New galvanising only requires degreasing. Weathered galvanising should be abraded to remove corrosion deposits.

GRP: Surfaces should be abraded using 180 grade abrasive paper.

Application Procedures

Product Mixing

Stir the contents of the 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.

Note When mixing complete units of product, the use of a slow or variable speed mechanical mixer is beneficial in terms of ease and complete mixing.

Application

- Do not apply when relative humidity exceeds 90% or when the surface to be coated is less than 3°C above the dew point.
- For optimum results a minimum material and substrate temperature of 7°C is necessary.

METHOD 3M™ Scotchkote™ Epoxy Primer MC 135 can be applied by most types of spray equipment, brush and roller.

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.

3M and Scotchkote are trademarks of 3M Company.

Important Notice

All statements, technical information, and recommendations related to 3M's products are based on information believed to be reliable, but the accuracy or completeness is not guaranteed. Before using this product, you must evaluate it and determine if it is suitable for your intended application. You assume all risks and liability associated with such use. Any statements related to the product which are not contained in 3M's current publications, or any contrary statements contained on your purchase order shall have no force or effect unless expressly agreed upon, in writing, by an authorised officer of 3M.

Warranty; Limited Remedy; Limited Liability.

3M warrants that the 3M™ Scotchkote™ Product will conform to 3M published specifications upon shipment. If the product is proven not to have met the specifications your exclusive remedy within 12 months of sale by 3M of the product and 3M's sole obligation will be, at 3M's option, to replace the Product or to refund the purchase price of the Product. Except where prohibited by law, this warranty is made in lieu of all other warranties, express or implied, including, but not limited to, any implied warranty of suitability or fitness for a particular purpose, or those arising from a course of dealing, custom or usage or trade.

3M has no obligation under this warranty with respect to any product that has failed due to inadequate or improper storage, handling, surface preparation, application, or maintenance; failure to follow product instructions or recommendations or alteration or damage to the Product caused by accident, neglect, or misuse. OTHER THAN IN THE CASE OF DEATH OR PERSONAL INJURY CAUSED BY ITS NEGLIGENCE AND EXCEPT WHERE PROHIBITED BY LAW, IN NO EVENT SHALL 3M BE LIABLE FOR ANY DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL LOSS OR DAMAGES (INCLUDING LOST PROFITS) ARISING FROM THIS PRODUCT, REGARDLESS OF THE LEGAL THEORY ASSERTED.



Infrastructure Protection Division (IsPD) 3M United Kingdom Plc

23 Standard Way Industrial Estate
Northallerton
North Yorkshire DL6 2XA
United Kingdom
Phone: +44 (0)1609 780170
Fax: +44 (0)1609 780438
www.3M.co.uk/scotchkote

Infrastructure Protection Division (IsPD) 3M United Kingdom Plc

3M Centre
Cain Road, Bracknell
Berkshire RG12 8HT
Phone: 01344 858000
Fax: 01344 857970
www.3M.co.uk

The product is supplied ready for use by airless or air assisted spray.

The product will require thinning for application by conventional spray, where the minimum quantity of 3M™ Scotchkote™ Thinners SA65 required for optimum atomisation should be used. Typically this is up to 10% volume.

Detailed guidance on the spraying procedures is available from the Technical Centre at 3M Northallerton.

Typical Spray Settings are:

Airless Spray Tip Size 13 - 15 thou

Conventional Spray Pressure Pot. Needle Setup 1.4 - 1.8 mm

Note: When airless spray is being used, excessively high tip spraying pressures should be avoided. The minimum pressure at the pump conducive with good atomisation should be used.

All equipment must be cleaned IMMEDIATELY after use with Scotchkote Thinners SA65.

Packaging and Storage

Supplied in 5 and 20 litre units.

Use within 2 years of date of manufacture. Store in original sealed containers at temperatures between 5°C and 32°C.

ALWAYS PROTECT FROM FROST DURING STORAGE AND 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.

Please recycle. Printed in UK.
© 3M 2013. All rights reserved.
MC 135-0113