

# 3M™ Scotchkote™ System Application Guide

## High Performance System To Line Mark Concrete Or Steel Floors

### SKF.28L - Issue 3

Surface Preparation and Cleaning	As required
Concrete Primer Application (if required)	<b>3M™ Scotchkote Urethane Sealer 165CS @ 100 microns</b> with Kiln Dried Sand. Theoretical coverage rate at 100 microns is 10m <sup>2</sup> /litre
Steel Primer Application	<b>3M™ Scotchkote™ Urethane Aluminium Primer MCU 125 @ 50μ dft</b> Theoretical coverage rate at 50μ is 11m <sup>2</sup> /litre
Finish Application	<b>3M™ Scotchkote™ Liquid Line Marking LXF 897 @ 150-200 microns dft</b> Theoretical coverage rate at 200 microns dft is 5 m <sup>2</sup> /ltr

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## Surface Preparation

All contamination, including oil and grease spots should be removed by high pressure detergent washing. Concrete surface with heavy deposits of oils and grease may require sweating out using hot compressed air.

New concrete should be fully cured.

Areas to be treated should now be defined by applying low tack masking tape to the floor.

Surfaces should then be thoroughly abraded and scarified to ensure all existing coating and traces of laitance are removed.

Steel surfaces should ideally be grit blasted, however, where this is not possible, surfaces should be thoroughly mechanically abraded and ground to produce a course profile. Care should be taken not to polish the surface.

All dust and abrasive residue must be removed from the surface.

**Prior to any coating, concrete surfaces should be dry and the moisture content should be checked using a proprietary surface moisture indicator, such as an Elcometer 7420 Digital Moisture Meter. When tested in accordance with the manufacturer's instructions, the reading should be classified as 'dry.'**

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## Application Of 3M™ Scotchkote™ Urethane Sealer 165CS To Concrete Surfaces (If required)

Very porous concrete surfaces should be primed with **Scotchkote Urethane Sealer 165CS** prior to the application of **3M™ Scotchkote™ Liquid Line Marking LXF 897**.

Surfaces to be coated must be clean, dry and free from contamination.

**Scotchkote Urethane Sealer 165CS** is a two component product consisting of a Part A (Base) component and a Part B (Activator) component which should be mixed together prior to use. The contents of the Part B (Activator) container should be added to the Part A (Base) unit and thoroughly mixed to produce a uniform material. The mixed product should be applied by brush or roller, within 30 minutes of mixing at 20°C, at a rate of 0.125kg/m<sup>2</sup> ≅ 100 microns dft.

On rough surfaces the **Scotchkote Urethane Sealer 165CS** should be stippled into the surface to ensure complete wetting of the substrate.

Whilst the surface is still wet the **Scotchkote Urethane Sealer 165CS** should be obliterated with 600 micron kiln dried silica sand.

**Scotchkote Urethane Sealer 165CS** can be overcoated after a minimum drying interval of 3 hours and within 24 hours at 20°C . The following table is given as a guide for different temperatures:-

	<u>MINIMUM</u>	<u>MAXIMUM</u>
10°C	6 hours	48 hours
15°C	4 hours	36 hours
20°C	3 hours	24 hours
25°C	2 hours	18 hours
30°C	1 hour	12 hours

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## Application Of 3M™ Scotchkote™ Urethane Aluminium Primer MCU 125 To Steel Surfaces

**Scotchkote Urethane Aluminium Primer MCU 125** is a single component solvent based primer and should only require stirring prior to use to incorporate any slight separation.

Provided the prepared surface is clean, dry and free from condensation or ice, **Scotchkote Urethane Aluminium Primer MCU 125** can be applied at temperatures down to 0°C with no restriction on dew point or relative humidity.

**Scotchkote Urethane Aluminium Primer MCU 125** should be applied by brush at a nominal 90 microns wet to give 50 microns dry film thickness. Care should be taken to ensure complete wetting out of the surface.

The theoretical coverage rate at 50 dft microns is 11m<sup>2</sup>/litre.

**Scotchkote Urethane Aluminium Primer MCU 125** can be overcoated after a minimum of 2 hours at 20°C. The following table is given as a guide for different temperatures.

<u>TEMPERATURE</u>	<u>MINIMUM</u>
15°C	3 hours
20°C	2 hours
25°C	1½ hours
30°C	1 hours

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## Application Of 3M™ Scotchkote™ Liquid Line Marking LXF 897

The prepared or primed surface should be clean, dry and free from loose material.

**Scotchkote Liquid Line Marking LXF 897** is a fast curing two component coating comprising of Part A (Base) and Part B (Activator) components. The Part A (Base) component should be stirred, then whilst continuing stirring the contents of the Part B (Activator) container should be added and thoroughly mixed. After mixing, the product should be transferred to a clean container and the Part A (Base) container scraped out and further mixing carried out.

The material can be applied by brush, roller at a nominal wet film thickness of 150-200 $\mu$ . The theoretical coverage rate at 200 $\mu$  is 5m<sup>2</sup>/litre.

As soon as the **Scotchkote Liquid Line Marking LXF 897** is touch dry all masking tape should be removed.

Where, due to surface roughness or colour, a second coat is required for maximum cosmetic affect, the first coat of **Scotchkote Liquid Line Marking LXF 897** should be allowed a minimum period of 1 hour at 20°C and within 24 hours be re-masked and overcoated with the second coat, these times will be extended at lower temperatures and reduced at higher temperatures.

Where a slip resistant finish is required **3M™ Scotchkote™ Granular Aggregate WD 093** should be scattered onto the surface of the **Scotchkote Liquid Line Marking LXF 897** at a rate of 100 - 150 gms/m<sup>2</sup> and back rolled in, This equates to 10 - 15 gms per linear metre based on a 100mm wide line. If a two coat system is being applied the aggregate should be incorporated into the second coat.

This system is suitable for light pedestrian traffic after a minimum of 1 hour at a surface temperature of 20°C.

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## Notes

## Document References

3M™ Scotchkote™ Urethane Sealer 165CS  
3M™ Scotchkote™ Liquid Line Marking LXF 897

Product Technical Data Sheet

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## Important Notice

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