

3M™ Scotchkote™ Epoxy Primer GP 120

Data Sheet and Application Guide

Product Description

Scotchkote Epoxy Primer GP 120 has been specifically developed as an anti corrosive coating for steel structures that cannot be abrasive blast cleaned.

Product Features

- Combines good application characteristics with excellent corrosion protection.
- Designed for application by brush, roller or spray.
- Suitable for use on mechanically prepared steelwork or high pressure water cleaned steel, can also be used on abrasive blasted steel.
- Can be applied over existing coatings.
- Can be used as a two coat primer/finish system or overcoated with a variety of 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 Epoxy Primer GP 120 coating at the specified thickness
4. Allow to cure.
5. Visually inspect the coating for defects.
6. Repair all defects.

Properties

Property	Value
Colour	Aluminium
Ratio	1:1 By Volume
Drying & Cure times at 20°C (68°F)	
Usable Life	1½ hours
Touch Dry	6 hours
Hard Dry	24 hours
Minimum Overcoating	16 hours
Maximum Overcoating	72 hours - with itself 24 hours - with 2 pack PU finishes
Full Cure	7 days
Volume Solids	90%
Specific Gravity	1.34
V.O.C	83gm/ltr - estimated
Film Thickness	140 microns wet, 125 microns dry.
Theoretical Coverage Rate	7sq metres per litre at 125 microns dft..

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.

Performance Data

Abrasion Resistance	70mgm weight loss per 1000 cycles - 1kg load - CS17 Wheel (ASTM D4060)
Dry Heat Resistance	100°C (ASTM D2485)
Direct Pull Adhesion	6.2Mpa (900 psi) on abrasive blasted steel (ASTM D4541)
Salt Fog Resistance	Unaffected after 5000 hours exposure (ASTM B117)
Humidity Resistance	Unaffected after 5000 hours exposure (BS3900 Part F2)
Impact Resistance	2.6 Joules (ASTM G14)
Scratch Resistance	No Failure 2.5kg (5.5lbs) load
Tensile Shear Adhesion	17.25 Mpa (2500 psi) (ASTM D1002)

Application Procedures for 3M™ Scotchkote™ Epoxy Primer GP 120

Surface Preparation

Surfaces should be clean and free from oils, grease, rust, milscale, loosely adhering coatings and visible moisture.

Surfaces should be prepared by mechanical wire brushing, grinding or high pressure water jetting (typically 5000 psi) to achieve SSPC-SP2/SP3 ISO 8501-4 St 2-St 3 taking particular care when cleaning badly pitted surfaces.

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.

All oil and grease must be removed by the use of **3M™ Scotchkote™ Thinners SA65** or approved degreasers prior to carrying out surface preparation.

Application Procedures

Product Mixing

The product is a two component material comprising a Part A (Base) component and a Part B (Activator) component which must be mixed together prior to use. Both components should be thoroughly stirred to incorporate any slight separation prior to mixing. Whilst continually stirring Part A (Base), Part B (Activator) component should be slowly added with mixing continuing until completely homogeneous. The mixed material must be used within 1½ hours at 20°C. This time will be reduced at higher temperatures and extended at lower temperatures.

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.

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Application

Application should not be carried out at temperatures below 7°C, nor when humidity exceeds 90% or when surface to be coated is less than 3°C above the dew point.

Scotchkote Epoxy Primer GP120 can be applied by brush, roller or spray. When application is carried out by brush, two coats may be required to achieve the correct film build.

When airless spray application is used, a tip size of 15-18 thou is recommended with a tip pressure of approximately 2500 psi.

Only sufficient material should be mixed that can be applied within the usable life of the product.

Clean all equipment 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 **01462 421 333**
For emergencies, please contact +44 (0)1344 858000.