

# 3M™ Scotchkote™ Epoxy Coating EA9HB

## Data Sheet and Application Guide

### Product Description

Scotchkote Epoxy Coating EA9HB is a solvent based two component high build material designed to provide corrosion protection to steel surfaces.

### Product Features

- Combines good application characteristics with excellent corrosion protection and chemical resistance.
- Proven long term corrosion protection of ferrous substrates.
- As the basis of a multi coat system, can be overcoated with a number of Scotchkote finishes.
- Widely used throughout the rail industry and heavy engineering fabrication and civil engineering work.

**Abrasion:** Good resistance to abrasion and mechanical damage.

**Adhesion:** Excellent on correctly prepared or primed surfaces.

**Chemical Resistance:** The fully cured coating offers outstanding resistance to aqueous solutions and a wide range of industrial chemicals.

**Temperature resistance:** Dry service temperature range up to 100°C.

### 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 EA9HB at the specified thickness.
4. Allow to cure.
5. Visually or electrically inspect the coating for defects.
6. Repair all defects.

### Properties

| Property                                      | Value   |
|---|---|
| Colour  | Mid Grey or Off White, other colours may be produced on request |
| Ratio   | 7.2:1 by volume   |
| <b>Drying &amp; Cure times at 20°C (68°F)</b> |   |
| Usable Life                                   | Approximately 5 hours   |
| Touch Dry                                     | 2 hours   |
| Hard Dry                                      | 16 hours  |
| Overcoating Minimum                           | 16 hours  |
| Maximum                                       | 4 days  |
| Full Cure                                     | 7 days  |
| Volume Solids (Average by Volume)             | 55%   |
| Specific Gravity (Average Mixed)              | 1.22  |
| V.O.C (As Supplied)                           | 435gm/litre   |
| V.O.C (Thinned 10%)                           | 473gm/litre   |
| Film Thickness (Typical)                      | Wet 210 microns. Dry 115 microns                                |
| Theoretical Coverage Rate                     | 7.5 sq metres per litre at 60 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.



# Application Procedures for 3M™ Scotchkote™ Epoxy Coating EA9HB

## Surface Preparation

Surfaces should be thoroughly degreased then abrasive blast cleaned to NACE No. 2/SSPC-SP10 near white metal, ISO 8501-1, Sa2½ BS 7079 Part A1 1989/ISO 8501-1: 1988 - with a medium profile - 35 microns average.

## Application Procedures

### Mixing

Stir the contents of the Part A component. Continue stirring whilst gradually adding the total contents of the Part B 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, the minimum temperature of application is 7°C.

## Method

3M Scotchkote Epoxy Coating EA9HB can be applied by brush, roller, conventional or airless spray, with spray application being the preferred method.

Typical spray settings are as follows:-

**Airless Spray:** Minimum 45:1 pump ratio

**Tip Size:** 13-17 Thou

**Tip pressure:** 3000-3500 psi

**Conventional Spray Pressure Pot**

**Needle Setup:** 1.4-1.8mm

**For Airless Spray:** Scotchkote Epoxy Coating EA9HB requires thinning up to 10% with 3M™ Scotchkote™ Thinners SA65.

**For Pressure Pot :** Up to 30% Scotchkote Thinners SA65 will be required. Good quality brushes and mohair rollers should be used for these methods of application.

Clean all equipment after use with Scotchkote Thinners SA65.

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

## Packaging and Storage

Supplied in 4.1 litre packs

Use within 2 years of date of manufacture. Store in original sealed containers at temperatures between 5°C (40°F) and 30°C (86°F).

## 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.

## Handling and Safety Precautions

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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## Important Notice

All statements, technical information and recommendations are based on information believed to be reliable, but the accuracy or completeness is not guaranteed. Before using the 3M™ Scotchkote™ Product, you must evaluate it and determine if it is suitable for your intended application. Because conditions of product use are outside of 3M control's and vary widely you assume all risks and liability associated with such use. Any product related statements not contained in current 3M publications, or any contrary statements contained in your purchase order, shall have no force or effect unless expressly agreed to 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.

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