

3M™ Scotchkote™ Liquid Epoxy Coatings

323/323i Product Handling Times*

| Product Temperature | Pot-Life | Dry to Touch Time | Back Fill Time |
|---------------------|------------|-------------------|----------------|
| 40°F (4°C) | 45 minutes | 6-7 hours | 7-9 hours |
| 60°F (16°C) | 25 minutes | 2-3 hours | 4-6 hours |
| 75°F (24°C) | 18 minutes | 90-120 minutes | 2.5-3.5 hours |
| 85°F (29°C) | 14 minutes | 50-70 minutes | 1.5-2.5 hours |
| 100°F (38°C) | 10 minutes | 35-45 minutes | 60-90 minutes |
| 120°F (49°C) | 7 minutes | 20-30 minutes | 30-60 minutes |
| 150°F (66°C) | — | 5-15 minutes | 15-30 minutes |

*It is very important to understand that the times listed above are approximations and will vary due to separate product, ambient and substrate temperatures as well as a combination of them.

Handling and Safety Precautions

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

Ordering Information/Customer Service

For ordering technical or product information, or a copy of the Material Safety Data Sheet, call:

Phone: 800/878-8837 or 925/427-6200

Fax: 925/427-6202

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Corrosion Protection Products Division

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