

3M™ Scotchkote™ Purple Patch Compound 323

Data Sheet

Product Description

3M™ Scotchkote™ 323 Purple Patch Compound is an ambient temperature cure, two-part system designed to protect metal, concrete and other surfaces from corrosion and deterioration. Scotchkote 323 Purple Patch Compound is the patch material color matched to 3M Scotchkote 3M™ Scotchkote™ Fusion Bonded Epoxy 426.

Features

- Excellent edge coverage
- No solvents needed
- 100% solids
- Application by cartridge
- Excellent adhesion
- Can be applied to substrate as cold as 41°F / 5°C
- VOC for parts A and B as mixed 12 g/L

General Application Steps

1. Remove oil, grease and loosely adhering deposits.
2. Abrasive blast clean the surface to near-white in accordance with NACE No.2/SSPC-SP 10 near-white metal, ISO 8501-Sa2.5.
3. Ensure the abraded surface is cleaned of debris with the use of an air blaster or a clean lint free cloth.

4. Within 4 hours of blasting as per the above cleaning process and with the metal above 41°F/5°C, apply Scotchkote 323 purple patch compound at the specified thickness.
5. Allow to cure.
6. Visually or electrically inspect the coating for defects.
7. Repair all defects using same material.

*To prevent the formation of rust or oxide, coat as soon as possible after cleaning. For maximum protection, the coating must have direct contact with the metal or parent coating surface.

Repair of Fusion Bonded Epoxy Coating

Scotchkote coating requiring limited repair (scrapes, scars, coating imperfections or other minor defects) should be cleaned to remove dirt, scale and damaged coating by sanding or other suitable means. Feather the adjacent coating and remove all dust by wiping. Next, apply the coating to the clean surface. The freshly coated area should be allowed to properly cure prior to handling and storage. Cure can be accelerated with heat.

Multiple Coats

Scotchkote 323 Purple Patch Compound has been formulated for single coat applications. If additional coats are required, for example edge coverage, apply the additional coats within three hours of the initial coat. This coating may be applied in any thickness consistent with producing an acceptable surface finish.

Typical Properties

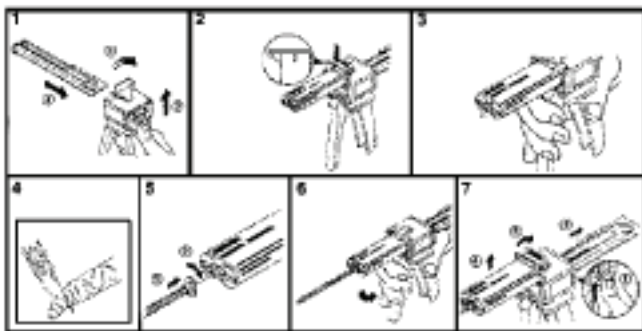
| Property | Typical Value |
|---------------------------------------|---|
| Color | Purple |
| Mix Ratio | 2 A to 1 B by volume 70.8% : 29.2% by weight |
| Shelf Life, unmixed, closed container | 24 months |
| Viscosity in CPS | Part A: 120,000 Part B: 20,000 |
| Specific gravity mixed | 1.34 |
| Coverage | 50 ml cartridge yields approximately 360 sq. in. @ 8.5 mils 450 ml cartridge yields approximately 22 sqft @ 8.5 mils |



3M™ Scotchkote™ 323 Purple Patch Compound

| Property | Test Description | Typical Value | | | |
|--|--|---------------|--------------|----------|---------|
| Shyodu Gel Time (approximate pot life) | 200 gm mass | 75°F/24°C | 17 min | | |
| | | 104°F/40°C | 11 min | | |
| Dry to Touch Time | ASTM D1640 clause 7.5.2 | 41°F/ 5°C | 7 hrs | | |
| | | 75°F/24°C | 1 hrs 45 min | | |
| | | 122°F/50°C | 26 min | | |
| Dry to Handle Time | ASTM D1640 clause 7.7.1 | 41°F/ 5°C | 8 hrs | | |
| | | 75°F/24°C | 2 hrs 39 min | | |
| | | 122°F/50°C | 39 min | | |
| Cathodic Disbondment (steel grit blasted plates laboratory applied; results may vary depending on blast media) | CSA Z245.20-98 clause 12.8 | 149°F/65°C | 3.5V | 24 hrs | 4.9 mmr |
| | | 149°F/65°C | 1.5V | 48 hrs | 5.5 mmr |
| | | 149°F/65°C | 1.5V | 28 days | 7.5 mmr |
| | | 176°F/80°C | 1.5V | 14 days | 6.4 mmr |
| | | 176°F/80°C | 1.5V | 28 days | 6.6 mmr |
| Adhesion | CSA Z245.20-98 clause 12.14 | 203°F/95°C | 24 hrs | Rating 1 | |
| | | 167°F/75°C | 48 hrs | Rating 1 | |
| | | 167°F/75°C | 28 days | Rating 1 | |
| Flexibility | CSA Z245.20-98 clause 12.11 | 68°F/20°C | 0.7 | */PD | |
| | | 32°F/ 0°C | 0.7 | */PD | |
| Abrasion Resistance | ASTM D 4060-95 CS-17 wheels 1000 g load 5000 cycles wheels resurfaced every 500 cycles | 0.325 g loss | | | |

Scotch 323 Patch Compound Applicator



Handling and Safety Precautions

Read all Health Hazard, Precautionary, and First Aid statements found in the Material Safety Data Sheet, and/or product label of chemicals 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**

Fax: **925/427-6202**

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DISTRIBUTED BY:



2201 Harbor St, Unit C
Pittsburg, CA 94565
Tel: 800.878.8837

302 South 700 West
Pleasant Grove, UT 84062
Tel: 801.785.1546

www.corrosioncoatings.com info@corrosioncoatings.com