

# 3M™ Scotchkote™ Water Base Primer 500N

Data Sheet

January 2016

**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.

**Product Description** Scotchkote primer 500N is a water-based metal treatment designed to increase adhesion of fusion bonded epoxy coatings. Properly applied to blast-cleaned steel, it helps provide protection for metal surfaces and a uniform bonding base for increased coating performance.

**Product Features**

- Significantly improves cathodic disbondment and salt spray resistance of the coating.
- Improves hot water and autoclave resistance of the coating.
- Promotes a chemically uniform steel surface condition.
- Easily applied with minimal application equipment.

**Typical Physical Property**

Property	Value
Color	Clear
Coverage	1600 ft <sup>2</sup> /gal/40 m <sup>2</sup> /L

**General Application Steps**

1. Remove salt, oil, grease, and loosely adhering deposits.
2. Abrasive blast to NACE No. 2/SSPC-SP10 ISO 8501:1, Grade SA 2 1/2 near-white finish.
3. Apply Scotchkote primer 500N by flooding, brush, squeegee, roller, spraying or wiping to achieve a uniformly wetted surface.
4. Remove drips, runs, and excessive accumulations in weld or deformation areas by any suitable wiping or blowing method.
5. For optimum results, dry Scotchkote primer 500N at ambient temperature by blowing with warm air. Do not exceed 200°F/93°C or boil off conditions during drying stage. Drying should be completed within two minutes of application.
6. Preheat steel, apply and cure 3M Scotchkote Fusion-Bonded Epoxy Coating in accordance with the manufacturer's recommendations.

**System Care and Control**

The application rate of Scotchkote primer 500N should be monitored by keeping a log of material used versus steel surface area processed in accordance with coverage data found under "Typical Properties." Temperature of Scotchkote primer 500N primer in holding tanks should not exceed 140°F/60°C. **DO NOT ALLOW FREEZING.** Recharge at regular, frequent intervals. If flood coating, filter recirculating system to remove loose shot/grit or other solid contaminants. Holding tanks, piping systems and other application apparatus should utilize plastic, fiberglass, or stainless steel. To avoid gelation, the holding tank lid must be closed tight.

# 3M™ Scotchkote™ Water Base Primer 500N

---

**Shelf-Life** This product has a 48 month shelf life from date of manufacture. Store in original sealed containers in a temperature control room >40°F (5°C).

---

**Availability** For ordering call:  
Phone: 800 722 6721  
Fax: 877 601 1305

For Data Sheets and MSDS inquires please visit:  
[www.3m.com/corrosion](http://www.3m.com/corrosion)

---

3M and Scotchkote are trademarks of 3M Company.

---

**Important Notice** All statements, technical information, and recommendations related to 3M's products are based on information believed to be reliable, but the accuracy or completeness is not guaranteed. Before using this product, you must evaluate it and determine if it is suitable for your intended application. You assume all risks and liability associated with such use. Any statements related to the product, which are not contained in 3M's current publications, or any contrary statements contained on your purchase order, shall have no force or effect unless expressly agreed upon, in writing, by an authorized officer of 3M.

---

**Warranty; Limited Remedy; Limited Liability** Because conditions of product use are outside of our control and vary widely, the following is made in lieu of all express or implied warranties: This product will conform to 3M's published product specifications and be free from defects in material and manufacture on the date of your purchase. **3M MAKES NO OTHER WARRANTIES INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.** If this product is defective upon your receipt, your exclusive remedy shall be, at 3M's option, to replace the 3M product or refund the purchase price of the 3M product. **Except where prohibited by law, 3M will not be liable for any direct, indirect, special, incidental or consequential loss or damage arising from this 3M product, regardless of the legal theory asserted.**

---



## Electrical Markets Division

6801 River Place Blvd.  
Austin, TX 78726-9000  
800 722 6721  
FAX: 877 601 1305  
[www.3M.com/corrosion](http://www.3M.com/corrosion)

Please recycle  
© 3M 2016 All rights reserved  
78-8141-8498-8 Rev A