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

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Clear</td>
</tr>
<tr>
<td>Coverage</td>
<td>1600 ft²/gal/40 m²/L</td>
</tr>
</tbody>
</table>

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 inquiries please visit:
www.3m.com/corrosion

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