

3M™ Scotchkote™ Rebar Liquid Patch Compound 413PC

Data Sheet

April 2017

Product Description 3M™ Scotchkote™ Rebar Liquid Patch Compound 413PC is a two-part, ambient temperature cure, 71.1% solids content, thermosetting, liquid epoxy coating.

Agency Approvals & Self Certifications For RoHS information, please visit www.3M.com/ROHS

Installation Techniques

The mixing ratio of Scotchkote patch compound 413PC is one part A to one part B by volume. Combine the two parts and mix thoroughly until a uniform color is obtained. If the components are mixed in an incorrect proportion, or the components are not thoroughly mixed, the coating will not cure properly and will remain tacky. The coating may be applied immediately after mixing. Multiple applications may be required to meet edge coverage requirements. If necessary, a second coat can be applied once the first coat is tack free.

The pot life of the combined material depends on temperature. Use the pot life information provided. Pot life may be reduced if a large quantity is mixed. Prepare only the quantity of coating that can be applied in the indicated period of time.

For minor damage or repair of 3M Scotchkote Fusion Bonded Epoxy Coating 413 apply Scotchkote patch compound 413PC as follows:

1. Remove moisture.
 2. Clean all oil, grease, dust, scale, rust and damaged coating from the area to be repaired.
 3. Mix A and B components thoroughly before combining.
 4. Apply Scotchkote patch compound 413PC by standard spray or airless spray equipment, brush, or roller. To achieve maximum coating thickness, Scotchkote patch compounds SHOULD NOT be thinned. To spray the patch compound use a minimum 0.046 in (1.17 mm) tip orifice opening and a dry, oil free air supply capable of continuously supplying at least 20 cfm (0.57 m³/min) at 40 psi (2.8 bar) to the gun nozzle.
 5. Allow applied coating to dry prior to handling and storage. For best results, use Scotchkote patch compound 413PC when the ambient air temperature is 5°F (10°C) or higher during application and cure. Minimum recommended coating thickness is 7 mils. Minimum application temperature is 40°F (4°C).
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Handling and Safety Precautions Read all Health Hazard, Precautionary and First Aid, Safety Data Sheet, and product label prior to handling or use.

Availability **Ordering Information/Customer Service**
For ordering technical or product information, or a copy of the Safety Data Sheet, call 800.722.6721 or send a fax to 877.601.1305.

Typical Physical Properties Not for specifications. Values are typical, not to be considered minimum or maximum. Properties measured at room temperature 73°F (23°C) unless otherwise stated.
Product meets the requirements of Patch Material outlined in ASTM 775/A775M-17 Annex A2

Test Property	Test	Test Results
Color		Light Green
Density	Mixed	10.88 lbs/gal 1.30 g/ml
Coverage	Mixed	148 ft ² /lbs/mil
Hegman Grind Gauge		6.0
Viscosity	@ 20rpm & 77°F/25°C	Part A – 5400 cps Part B – 4400 cps
Shelf Life Unmixed	24	24 months
Storage Temperature		40°F (4°C) - 100°F (38°C)
Dry to Touch @ 77°F/25°C	ASTM D1640	3.5 Hours
Dry to Hard @ 77°F/25°C	ASTM D1640	15 Hours
Approximate Pot Life @ 77°F/25°C	Shyodu	5.6 Hours
Sag @ 77°F/25°C	Leneta	14 mils
Mix Ratio		1 : 1 by Volume 1 (A) : 1.35 (B) by weight

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