

# 3M™ Scotchkote™ Fusion Bonded Epoxy 206N Long Gel

**Data Sheet and Application Guide**

**April 2016**

**Handling and Safety Precautions:** Read all Health Hazard, Precautionary and First Aid, Material Safety Data Sheet, and product label information prior to handling or use.

## Product Description

3M Scotchkote Fusion Bonded Epoxy coating 206N Long Gel is a one-part, heat curable, thermosetting, powdered epoxy coating designed for coating the interior of line pipe.

Scotchkote coating 206N LG meets the requirements of AWWA Standard C213 and C550.

## General Application Information

1. Remove oil, grease and loosely adhering deposits.
2. Abrasive blast clean the surface to NACE No. 2/SSPC-SP10 ISO 8501:1, Grade SA 2 1/2 near-white metal.
3. Heat pipe to 350°F/177°C to 450°F/232°C.
4. Deposit Scotchkote 206N LG onto the interior of the pipe at 16mils/406 µm to 40 mils/1016 µm.
5. Within 24 hours move coated pipe to a post cure station and hold the pipe at 450°F/232°C (steel temperature) for 10 minutes.
6. Electrically inspect for holidays after coating has cooled to 200°F/93°C or lower.
7. When Scotchkote 206N LG is used with 3M primers, contact the 3M representative for application and cure conditions.



Scotchkote coating 206N has been tested and certified to NSF/ANSI Standard 61, Drinking Water System Components. For NSF certified applications, maximum approved thickness is 60 mils (1.5mm) cured for 10 minutes at 400°F/204°C. The maximum approved operating temperature is 140°/60°C.

## Typical Properties

Property	Value
Color	Dark Green
Specific Gravity (Air Pycnometer)	1.44
Coverage	134 ft <sup>2</sup> /lb/mil (0.694 m <sup>2</sup> /kg/mm)
Shelf Life at 80°F/27°C Storage Temperature	12 months minimum <80°F/27°C
Average Gel Time (423°F/217°C) Modified CSA-Z245.20	30-45 seconds

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## Product - Physical and Chemical Properties

### Coating Test Data

Property	Test Description	Results
Impact	ASTM G14 1/8" x 3" x 3" in steel panel (0.32 cm x 7.6 cm x 7.6 cm) 5/8" (1.6 cm) diameter tup	160 in-lbs (1.8 kg-m)
Bendability	Saudi Aramco 09-SAMSS-091 500-625 micron thickness	10.5 PD (5.5°/PD)
Water Resistance	ASTM D 4585-92 Resistance Cleveland Test 52°C with 15°C Gradient 3 weeks continuous	*Pass
Abrasion Resistance	Saudi Aramco 09-SAMSS-091 ASTM D4060	0.11 g loss

\*Pass means excellent adhesion, no blisters and no swelling

**Availability** For ordering, technical, product information, or the Safety Data Sheet, call:  
Phone: 800-722-6721  
Fax: 877-601-1305

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78-8141-8606-6 Rev A