

3M™ Scotchkote™ Fusion Bonded Epoxy Rough Overcoating 207R

Product Description

3M™ Scotchkote™ Fusion Bonded Epoxy Rough Overcoating 207R is a one-part, heat-curing, thermosetting fusion bonded epoxy coating. It is designed to produce a granular finish on all Scotchkote fusion bonded epoxy coating products where increased surface roughness is required. Scotchkote 207R overcoating was specifically developed to provide added traction for guide/feed wheels used in the installation of offshore pipelines. It may also help reduce slippage of fusion bonded epoxy with concrete overcoat. Scotchkote 207R overcoating is applied as a dry powder on top of primary coatings of Scotchkote fusion bonded epoxy coatings while they are still in the gel state. The coating then cures along with the primary coating.

Temperature Operating Range

Scotchkote coating 207R, when properly applied, should perform in a satisfactory manner on pipelines operating between -100°F/-73°C to 230°F/110°C. For temperatures between +170°F/77°C to 230°F/110°C, laboratory tests indicate that the thicker coatings may improve the service capability. However, it is difficult to accurately predict field performance from the laboratory data due to the wide variation in actual field conditions. Soil types, moisture content, temperatures, coating thickness and other factors specific to the area all influence the coating performance and the upper temperature operating limit.

Features

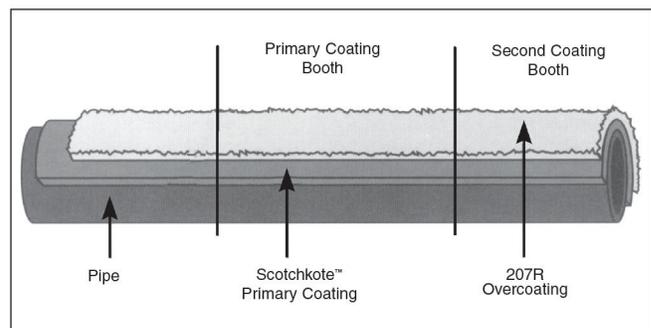
- Increases surface roughness.
- Adds traction for lay barge feed wheels.
- Thermosetting - does not cold flow.
- Bendability exceeds requirements of ANSI B31.4 or B31.8 Codes.
- Fast curing.
- Compatible with all Scotchkote fusion bonded epoxy coatings.
- Can be applied on girth welds in the field.

General Application Steps

1. Remove oil, grease and loosely adhering deposits.
2. Abrasive blast clean the surface to NACE No.2 / SSPC-SP10 to near-white.
3. Pre-heat cleaned pipe to approximately 450°F (232°C).
4. Deposit Scotchkote 226N, 6233 or 226N+ FBEC by electrostatic spray to the specified thickness.
5. Apply Scotchkote 207R overcoating while primary coating is still in the gel state. For best results, use a second inline coating booth to apply the powder.
6. Scotchkote 207R overcoating cures quickly. Cure in accordance with the cure specification below.
7. Electrically inspect for holidays after coating has cooled to 200°F (93°C) or lower.
8. Repair all holidays.

Cure Specifications

Scotchkote 207R overcoating must be cured to achieve maximum performance properties. Cure by residual heat. Post bake is not normally required. However, extra-light wall pipe may require additional curing. Cure time is based on the temperature of the steel at time of application.



Cure Guide

Application Temperature	Minimum Cure Time
450°F (232°C)	30 seconds

Properties

Property	Value
Color	Blue-Green
Specific Gravity-Powder (Air Pycnometer)	1.44
Coverage	134 ft ² /lb/mil 0,700 m ² /kg/mm
Shelf Life at 80°F (27°C)	12 months
Gel time at 450°F (232°C)	3-4 seconds

3M and Scotchkote are trademarks of 3M Company.

Handling & Safety Precautions

Read all Health Hazard, Precautionary, and First Aid statements found in the Material Safety Data Sheet, and/or product label 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: 800/722-6721
Fax: 877/601-1305

Important Notice

All statements, technical information and recommendations related to 3M Products are based on information believed to be reliable, but the accuracy or completeness is not guaranteed. Before using the 3M Product, you must evaluate it and determine if it is suitable for your intended application. Because conditions of Product use are outside of our control and vary widely you assume all risks and liability associated with such use. Any Product-related statements not contained in current 3M publications, or any contrary statements contained in your purchase order, shall have no force or effect unless expressly agreed to in writing by an authorized officer of 3M.

Warranty; Limited Remedy; Limited Liability.

3M warrants that Product will conform to 3M published specifications upon shipment. If Product is proven not to have met the specifications your exclusive remedy and 3M's sole obligation will be, at 3M's option, to replace the Product or to refund the purchase price of the Product. **EXCEPT WHERE PROHIBITED BY LAW, THIS WARRANTY IS MADE IN LIEU OF ALL OTHER WARRANTIES, EXPRESS OR IMPLIED, INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE OR THOSE ARISING FROM A COURSE OF DEALING, CUSTOM OR USAGE OF TRADE.** Buyer is an expert in its field and is responsible for determining if Products are suitable for a particular purpose or application. 3M has no obligation under this warranty with respect to any Product that has failed due to inadequate or improper storage, handling, surface preparation, application, or maintenance; failure to follow Product instructions; or alteration or damage to the Product caused by accident, neglect, or misuse. **EXCEPT WHERE PROHIBITED BY LAW, IN NO EVENT SHALL 3M BE LIABLE FOR ANY DIRECT, INDIRECT, SPECIAL, INCIDENTAL OR CONSEQUENTIAL LOSS OR DAMAGES (INCLUDING LOST PROFITS) ARISING FROM THIS PRODUCT, REGARDLESS OF THE LEGAL THEORY ASSERTED.**



Infrastructure Protection Division

6801 River Place Blvd.
Austin, TX 78726-9000
www.3M.com/corrosion

Please recycle. Printed in USA.
© 3M 2013. All rights reserved.
80-6111-8371-8 Rev. C