**3M™ Scotchkote™**

**Urethane Repair Paste 165TGSG**

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### Data Sheet and Application Guide

#### Product Description

Scotchkote Urethane Repair Paste 165TGSG has been specifically developed as the high build repair version of Scotchkote Urethane Repair Paste 165 protection system for the externals of pipes for application by trowel, stiff brush or spatula. As such, it permits single coat application at thicknesses up to 6mm.

#### Product Features

Scotchkote Urethane Repair Paste 165TGSG combines good application characteristics with excellent corrosion protection and chemical resistance.

Scotchkote Urethane Repair Paste 165TGSG is designed to be fully compatible with other Scotchkote 165 products.

Scotchkote Urethane Repair Paste 165TGSG is primarily designed for use on steel surfaces but also exhibits good adhesion to polyethylene and other common external pipe coating materials.

- **Adhesion**—Excellent to both blast cleaned and mechanically scraped surfaces.
- **Corrosion Resistance**—Excellent even under aggressive immersion conditions.
- **Chemical Resistance**—Virtually unaffected by most industrial chemicals.

#### General Application Steps

1. Remove oil, grease and loosely adhering deposits.
2. Abrasive blast clean steel surfaces to NACE No. 2/SSPC-SP10 near white metal, ISO 8501:1, Grade SA2½.
3. Apply Scotchkote Urethane Repair Paste 165 TGSG at the specified thickness.
4. Allow to cure.
5. Visually or electrically inspect the coating for defects.
6. Repair all defects.

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### Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Colour</td>
<td>12B21</td>
</tr>
<tr>
<td>Ratio</td>
<td>3:1 By volume 3:1 By weight</td>
</tr>
<tr>
<td>Drying &amp; Cure times at 20°C (68°F)</td>
<td></td>
</tr>
<tr>
<td>Usable Life</td>
<td>18 mins</td>
</tr>
<tr>
<td>Touch Dry</td>
<td>2 hours</td>
</tr>
<tr>
<td>Hard Dry</td>
<td>4 hours</td>
</tr>
<tr>
<td>Full Cure</td>
<td>7 days</td>
</tr>
<tr>
<td>Minimum Overcoating</td>
<td>2 hours</td>
</tr>
<tr>
<td>Maximum Overcoating</td>
<td>24 hours</td>
</tr>
<tr>
<td>Volume Solids</td>
<td>100%</td>
</tr>
<tr>
<td>Specific Gravity</td>
<td>1.2</td>
</tr>
<tr>
<td>Film Thickness (Typical)</td>
<td>Wet/Dry: up to 6mm. Note: The actual thickness to be applied should be agreed between the specifier and the manufacturer dependant on operational performance criteria and may be higher or lower than the quoted typical value.</td>
</tr>
<tr>
<td>Theoretical Coverage Rate</td>
<td>0.8 sq metre per kilo at 1mm microns dft.</td>
</tr>
<tr>
<td>Dielectric Strength</td>
<td>&gt; 20KV</td>
</tr>
<tr>
<td>Standards Met</td>
<td>DIN 30671 GBE/CW6 Pt 1 NFA 49-716</td>
</tr>
</tbody>
</table>
Application Procedures for 3M™ Scotchkote™ Urethane Repair Paste 165TGSG

Surface Preparation
Steel surfaces should be abrasive blasted to NACE No 2/SSPC-SP10 near white metal, ISO 8501:1 Grade Sa2½. The blast profile is generally specified by the client; a typical profile is 75–100 microns.

Application Procedures
The Part A (Base) component should be stirred. While stirring, the contents of the Part B (Activator) container should be added. Initially the two components are fluid, but on mixing a paste is formed, which should be transferred to a mixing board. Further mixing should be carried out to produce a streak-free material.

Scotchkote Urethane Repair Paste 165TGSG is intended for application by trowel.

Ideally, Scotchkote Urethane Repair Paste 165TGSG should be applied in a single high-build coat by trowel, stiff brush or spatula. If a second coat is required for any reason, overcoating must be carried out within 24 hours of application of the preceding coat. If the overcoating time is extended, thorough mechanical abrading or flash blasting of the first coat should be carried out once the coating is hard dry.

Clean all equipment immediately after use with 3M™ Scotchkote™ Thinners PU71.

Packaging and Storage
Supplied in 1 kilo packs.

Use within 2 years of date of manufacture. Store in original sealed containers at temperatures between 5°C and 32°C.

Handling and 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 and product information or to request a copy of the Material Safety Data Sheet, call +44 (0)1609 780170 or fax +44 (0)1609 783762 (Sales) or 788718 (Technical).

For emergencies, please contact +44 (0)1344 858000.

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