

# 3M™ Scotchkote™ Liquid Phenolic Primer 345

## Product Description

3M™ Scotchkote™ Liquid Phenolic Primer 345 is a one-part phenolic base primer designed specifically for application to metal surfaces prior to topcoating with Scotchkote Fusion Bonded Epoxy Coating. When properly applied, Scotchkote 345 primer and topcoat system provide excellent resistance to CO<sub>2</sub>, H<sub>2</sub>S, CH<sub>4</sub>, petroleum distillates and brine at elevated temperatures and pressures.

## Features

- Excellent chemical resistance
- Excellent CO<sub>2</sub> and H<sub>2</sub>S resistance
- Excellent surface adhesion
- Operational at high temperatures and pressures
- Compatible with all Scotchkote fusion bonded epoxy topcoats
- Resists settling

## Properties

Property	Value
Color	Red
Components	One
Viscosity, Zahn #2	Range 15–22 seconds
Solids by weight	44% ± -2%
Theoretical coverage at 1 Mil (25,4 µm) dry film thickness	444 ft <sup>2</sup> /US gallon (10,9 m <sup>2</sup> /liter)
Flash Point Tag Closed Cup	59°F (15°C)
Reducing Solvents	Ethanol, Methanol
Shelf Life at	<77°F (25°C) 12 months
Air Dry to Touch At 73°F (23°C)	5 minutes

## General Application Steps

1. Remove oil, grease and loosely adhering deposits.
2. Abrasive blast to SSPC-SP5 or NACE No. 1 ISO 8501 Sa2.5 white metal blast cleaned surface finish with 1.5–4 mils (38–100 µm) surface profile.
3. Reduce viscosity for consistent application thickness—usually ZAHN2 15–17 seconds.
4. Spray apply Scotchkote 345 primer to a nominal dry film thickness of 1 mils (25,4 µm).
5. Air dry primer for 5 minutes at 73°F (22°C).
6. Preheat cleaned, primed metal at 340°F to 375°F (171°C to 191°C) for 30 minutes. Or 400°F to 420°F (204°C to 215°C) for 15 minutes.
7. Apply Scotchkote fusion bonded epoxy powder topcoat by spray, lance, fluid bed, or blow coating to a nominal dry film thickness of 12 mils (305 µm).
8. Post cure coating system at 450°F (232°C) for 30 minutes.
9. Electrically inspect the coating for defects.



## Handling and Safety Precautions

Read all Health Hazard, Precautionary, and first Aid statements found in the Material Safety Data Sheet (MSDS) 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: 800/828-9329

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