Scotchkote™
345 Liquid Phenolic Primer

Product Description
3M™ Scotchkote™ 345 Liquid Phenolic Primer 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 CO₂, H₂S, CH₄, petroleum distillates and brine at elevated temperatures and pressures.

Features
• Excellent chemical resistance
• Excellent CO₂ and H₂S resistance
• Excellent surface adhesion
• Operational at high temperatures and pressures
• Compatible with all Scotchkote fusion bonded epoxy topcoats
• Resists settling

Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Color</td>
<td>Red</td>
</tr>
<tr>
<td>Components</td>
<td>One</td>
</tr>
<tr>
<td>Viscosity, Zahn #2</td>
<td>Range 15-22 seconds</td>
</tr>
<tr>
<td>Solids by weight</td>
<td>40% † 2%</td>
</tr>
<tr>
<td>Theoretical coverage at 1 Mil (25.4 µm) dry film thickness</td>
<td>444 ft²/US gallon (10.9 m²/liter)</td>
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<tr>
<td>Flash Point</td>
<td>59°F(15°C)</td>
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<tr>
<td>Reducing Solvents</td>
<td>Ethanol, Methanol</td>
</tr>
<tr>
<td>Shelf Life at</td>
<td></td>
</tr>
<tr>
<td>73°F (23°C)</td>
<td>3 months</td>
</tr>
<tr>
<td>50°F (10°C)</td>
<td>1 year</td>
</tr>
<tr>
<td>Air Dry To Touch</td>
<td>5 minutes</td>
</tr>
<tr>
<td>(At 73°F (23°C))</td>
<td></td>
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</table>

Important Notice
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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 325° to 375°F (163° to 191°C) for 30 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
For ordering technical or product information, or a copy of the Material Safety Data Sheet, call:
Phone: 800/722-6721 or 512/984-1038
Fax: 877/601-1305 or 512/984-6296

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