

3M™ Scotchkote™ Liquid Epoxy Coatings

323/323i Product Handling Times*

Product Temperature	Pot-Life	Dry to Touch Time	Back Fill Time
40°F (4°C)	45 minutes	6-7 hours	7-9 hours
60°F (16°C)	25 minutes	2-3 hours	4-6 hours
75°F (24°C)	18 minutes	90-120 minutes	2.5-3.5 hours
85°F (29°C)	14 minutes	50-70 minutes	1.5-2.5 hours
100°F (38°C)	10 minutes	35-45 minutes	60-90 minutes
120°F (49°C)	7 minutes	20-30 minutes	30-60 minutes
150°F (66°C)	—	5-15 minutes	15-30 minutes

*It is very important to understand that the times listed above are approximations and will vary due to separate product, ambient and substrate temperatures as well as a combination of them.

Handling and Safety Precautions

Read all Health Hazard, Precautionary, First Aid, 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 or 512/984-9393

Fax: 877/601-1305 or 512/984-6296

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Corrosion Protection Products Division

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