



Science.
Applied to Life.™

Protection that's as rugged as the terrain

3M™ Scotchkote™
Liquid Epoxy Coating 328



Proven performance for corrosion protection

3M™ Scotchkote™ Liquid Epoxy Coating 328 is a 100 percent solid, two-part epoxy system designed for applications that require a rugged coating. Traditional liquid epoxy combined with patent pending technology creates enhanced impact resistance, gouge resistance and flexibility. The result is a versatile coating that can be used for corrosion protection and abrasion resistance in the most challenging applications.

3M Scotchkote Coating 328 features:

More rugged than traditional epoxy coatings

- Increased flexibility and abrasion, impact and gouge resistance
- Provides rugged protection compared to standard two part epoxy

Improved performance over traditional liquid epoxies

- Better adhesion to steel and FBE
- Increased cathodic disbondment resistance

Engineered for easy application

- Applied with plural component equipment, spray cartridge or brush/roller
- High, one-pass build up (45 mils / 1150 microns)
- Lower viscosity makes it easier to handle
- Bonds to substrate at low temperatures (45°F/7°C)

Rugged protection, easy application

| | 3M Scotchkote Coating 328 | Competitive Product A |
|---------------------------------------|--|--|
| Abrasion Resistance* ASTM D4060-95 | 1800 cycles/mil | 1250 cycles/mil |
| Flexibility* | 4.0 °/PD at 70°F (21°C) 1.2 °/PD at -22°F (-30°C) (CSA Z245.20-10 Cl. 12.14) | 0.75 °/PD at 0°F (-18°C) (NACE RP-0394) |
| Impact Resistance* ASTM G14 (MOD) | 14 Joules @ 23°C 8 Joules @ -30°C | 7.7 Joules |
| Viscosity of Part A** | 60,000 cps | 200,000 cps |
| Mix Ratio (Part A: Part B)* | 3:1 | 4.8:1 |

*The data for this performance feature was obtained from 3M and competitive published data sheets. All customers are encouraged to perform their own testing or reference third party data when evaluating any coating.
**Viscosity testing on both 3M and Competitive ARO Product A was performed in a 3M laboratory using a Brookfield CAP 2000+ viscometer at 5 rpm and 21°C



Try Scotchkote coating 328 to see just how easy it is to apply!

3M™ Scotchkote™ Liquid Epoxy Coating 328

| Product Description | Stock Number | Contents | Billing Unit |
|--|----------------|--|--------------|
| Scotchkote Coating 328 1 Liter Kit – Part A | 80-6300-0330-1 | 4 × 0.75L Containers of Part A in One Case | Case |
| Scotchkote Coating 328 1 Liter Kit – Part B | 80-6300-0334-3 | 4 × 0.25L Containers of Part B in One Case | Case |
| Scotchkote Coating 328 3 Liter Kit – Part A | 80-6300-0331-9 | 4 × 2.25L Containers of Part A in One Case | Case |
| Scotchkote Coating 328 3 Liter Kit – Part B | 80-6300-0335-0 | 4 × 0.75L Containers of Part B in One Case | Case |
| Scotchkote Coating 328 17 Liter Pail – Part A | 80-6300-0332-7 | 1 × 17L Pail of 328 Part A (Order 3A:1B) | Each |
| Scotchkote Coating 328 17 Liter Pail – Part B | 80-6300-0333-5 | 1 × 17L Pail of 328 Part B | Each |
| Scotchkote Coating 328 190 Liter Drum – Part A | 80-6300-0250-1 | 1 × 190L Drum of 328 Part A (Order 3A:1B) | Drum |
| Scotchkote Coating 328 190 Liter Drum – Part B | 80-6300-0251-9 | 1 × 190L Drum of 328 Part B | Drum |
| Scotchkote Coating 328 1000ml-Cart | 80-6300-0371-5 | 1000 ml Cartridge | Each |

Traditional Corrosion Protection

3M™ Scotchkote™ Liquid Epoxy Coating 328 strongly adheres to both metal and fusion bonded epoxy (FBE). As a result, it can be used as a primary corrosion protection coating for directional drilling, rocky terrain or other situations that require a rugged coating. Scotchkote 328 demonstrates high, post-cure flexibility (greater than 4.0°/PD at 70°F/21°C) compared to traditional liquid epoxy coatings. With low cathodic disbondment values, Scotchkote 328 can also be used where long-term adhesion is critical.

Abrasion Resistant Coating

3M™ Scotchkote™ Liquid Epoxy Coating 328 is applied just like traditional two-part epoxy coatings, making it easier to protect factory-applied FBE coatings for directional drilling, thrust boring, river crossings or similar applications. Scotchkote 328 is also ideal for protecting field joints on pipe coated with a 3M™ Scotchkote™ Fusion Bonded Epoxy Dual Coating System 6352 or 6352HF.

Suggested corrosion protection coating applications:

- ✓ Field joints
- ✓ Coating rehabilitation
- ✓ Field patching

Suggested overcoat applications:

- ✓ Over FBE parent coating
- ✓ Field joints with parent coating
- ✓ ARO rehabilitation
- ✓ Field patching

3M™ Scotchkote™ Liquid Epoxy Coating 328

| Coating Properties | |
|---|--|
| Property | Results |
| Color | Blue-Green |
| Mix Ratio | 3A/1B By Volume 72.3/27.7 By Weight |
| Viscosity 70°F/21°C (cps) | Part A = 60,000 cps Part B = 14,000 cps |
| Shelf Life (unopened) | 24 months |
| Specific Gravity (g/cc) Part A Part B Part A & B Mixed | 1.34 1.48 1.38 |
| Coverage (ft ² /lb/mil)/(m ² /kg/mm) | 141/.724 |
| Minimum/Maximum Coating Thickness (as a primary corrosion protection coating) | 20/60 mils (500/1500 µm) |
| Minimum/Maximum Coating Thickness (as an ARO) | 40/100 mils (1000/2500 µm) |
| Gel Time 70°F/21°C (minutes) Dry to Touch Time 70°F/21°C (minutes) Hard Dry Time (Shore D>70) 70°F/21°C (minutes) | 23 120 180 |

3M™ Scotchkote™ Liquid Epoxy Coating 328

Test Properties

| Property | Test Description | | Typical Values |
|----------------------------|-----------------------------|---|-------------------------------|
| Cathodic Disbondment | CSA Z245.20-10 (Cl. 12.8) | 149°F/65°C, 28 days, 1.5V 176°F/80°C, 28 days, 1.5V 203°F/95°C, 28 days, 1.5V | 4.1 mmr 4.4 mmr 3.7 mmr |
| Hot Water Soak Adhesion | CSA Z245.20-10 (Cl. 12.14) | 167°F/75°C, 28 days 203°F/95°C, 28 days | Rating 1 Rating 1 |
| Dry Film Adhesion to Steel | ASTM D-4541 (IV) | 70°F/21°C | 6100 psi |
| Dry Film Adhesion to FBE | ASTM D-4541 (IV) | 70°F/21°C | 7200 psi |
| Flexibility | CSA Z245.20-10 (Cl. 12.11) | 70°F/21°C -22°F/-30°C | 4.0°/PD 1.2°/PD |
| Abrasion Resistance | ASTM D4060-07 | 5000 Cycles with 1000 g load | 375 mg |
| Impact Resistance | ASTM G-14 (MOD) | 14.0 J (40-60 mils) | Pass |
| Gouge Resistance | CSA Z245.20-10 (Smooth Bit) | 70 Kg | 23 mils gouge depth |
| Shore D Hardness | ASTM D785 | 70°F/21°C | 82 |

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