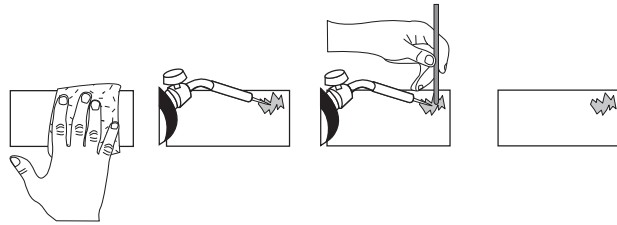


# 3M

# Scotchkote™

## Hot Melt Patch Compounds – 226P

### Instructions



#### Product Description

3M Scotchkote™ Hot Melt Patch Compounds, (H.M.P.C.) are heat bondable polymeric coatings in stick form designed for plant and field repair of Scotchkote Fusion Bonded Epoxy Coatings. Scotchkote Hot Melt Patch Compounds are ideal for repairing minor pinholes and abrasions. Scotchkote 226P H.M.P.C. is colormatched to Scotchkote 226N and 6233.

226P can be used on surfaces up to 25 mm. The following 3M two part epoxies should be used for bare steel areas larger than 25 mm, depending on the functional and application properties required:

Scotchkote 323  
Scotchkote 323i  
Scotchkote 352  
Scotchkote 327

#### Features

- Easy to apply
- Usable in all weather conditions
- Quick setting for immediate installation and handling
- No solvents
- No mixing, metering, or pot life problems
- Flexible
- Color matched to Scotchkote fusion bonded epoxy coatings
- Maximum operating temperature 122°F/50°C

#### Handling and Safety Precautions

Read all Health Hazard, Precautionary, and First Aid statements found in the Material Safety Data Sheet, and/or label prior to handling or use of this product.

#### Important Notice

All statements, technical information, and recommendations related to 3M's products are based on information believed to be reliable, but the accuracy or completeness is not guaranteed. Before using this product, you must evaluate it and determine if it is suitable for your intended application. You assume all risks and liability associated with such use. Any statements related to the product which are not contained in 3M's current publications, or any contrary statements contained on your purchase order shall have no force or effect unless expressly agreed upon, in writing, by an authorized officer of 3M.

# 3M

#### Corrosion Protection Products

6801 River Place Blvd.  
Austin, TX 78726-9000  
<http://www.3M.com/corrosion>

#### General Application Steps

1. The coating surface must be abraded and clean. To ensure good adhesion, roughen area using sandpaper and wipe to remove all dust.
2. Care must be taken when using patch sticks. Preheat of the FBE coating surface is required. Avoid heat application directly to the patchstick while prewarming the coating surface. Heat should be applied in a manner that avoids burning or charring of the epoxy coating. Slight browning of the parent coating is acceptable, but charring or blistering is not. The use of a noncontaminating heat source, such as portable hand held butane torches, is required.
3. Continue to heat the cleaned area until the coating surface is at the desired temperature at which point the patchstick begins to melt. The heat source maintains the temperature of the coating and melts the stick. While continuing to expose stick to heat source, apply the patch compound by rubbing the stick in a circular motion on the area to be repaired. This will achieve a smooth neat appearing patch, which has a thickness of at least 15 mils (380 microns) greater than the parent coating.
4. Allow the patch to cool before handling.

#### Ordering Information/Customer Service

For ordering information, technical information, product information or to request a copy of the Material Safety Data sheet:

Phone: 800/722-6271 or 512/984-9385

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

#### Warranty; Limited Remedy; Limited Liability.

This product will be free from defects in material and manufacture for a period of one (1) year from the time of purchase. **3M MAKES NO OTHER WARRANTIES INCLUDING, BUT NOT LIMITED TO, ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE.** If this product is defective within the warranty period stated above, your exclusive remedy shall be, at 3M's option, to replace or repair the 3M product or refund the purchase price of the 3M product. **Except where prohibited by law, 3M will not be liable for any indirect, special, incidental or consequential loss or damage arising from this 3M product, regardless of the legal theory asserted.**



40% Pre-consumer waste paper  
10% Post-consumer waste paper

Litho in USA.

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