

# 3M™ Scotchkote™

## Intumescent Coating SPX 760

### Data Sheet and Application Guide

#### Product Description

Scotchkote Intumescent Coating SPX 760 is a water borne thin film intumescent coating which has been specifically developed to provide enhanced fire resistance to structural steel sections for up to 1 hour.

#### Product Features

- Combines good application characteristics with high build capability enabling the appropriate film thickness to be applied in the minimum number of coats.
- Is a genuine waterborne intumescent and is therefore safe to store, handle and apply and eliminates traditional health hazards during use.
- Tested and assessed in accordance with BS EN 13381-8:2010

#### General Application Steps

1. Remove oil, grease and loosely adhering deposits.
2. Abrasive blast clean the surface to NACE No. 2/SSPC-SP10 near white metal ISO 8501:1, Grade SA2½ .
3. Apply 3M™ Scotchkote™ Epoxy Primer EA9 or other approved primer.
4. Apply Scotchkote Intumescent Coating SPX 760 to the required film thickness
5. Allow to dry.
6. Inspect the coating for defects.
7. Check dry film thickness.
8. Repair all defects.

#### Properties

Property	Value
Colour	White
<b>Drying &amp; Cure times at 20°C (68°F)</b>	
Touch Dry	4-6 hours
Hard Dry to handle	12 hours approx
Full Cure	7 days
Minimum Overcoating	4-6 hours
Volume Solids	65%
Specific Gravity	1.4
V.O.C Content	Nil
Film Thickness	Refer to product loading tables
Theoretical Coverage Rate	0.65 sq metres per litre at 1000 microns dft. 1.3 sq metres per litre at 500 microns dft.



# Application Procedures for 3M™ Scotchkote™ Intumescent Coating SPX 760

## Surface Preparation

Steel Surfaces – steel surfaces should be abrasive blasted to NACE No. 2/SSPC-SP10 near white metal, ISO 8501:1, Grade SA2½. Surfaces should then be primed with 3M™ Scotchkote™ Epoxy Primer EA9 or other approved primer

## Application Procedures

The product should not be applied when the relative humidity exceeds 80% or where surfaces are less than 3°C above the dew point. The product should not be applied at temperatures below 7°C. Product should be slowly agitated or mixed prior to use.

Application can be by brush or airless spray, with airless spray being the preferred method.

- Airless Spray Minimum 45:1 pump ratio
- Recommended Tip Size 21-27 thou orifice;
- Minimum Tip pressure 2500 psi (175 bar)

When airless spray is being used, excessively high tip spraying pressures should be avoided. The minimum pressure at the pump conducive with good atomisation should be used. When using the tips stated above a 60 mesh filter is recommended. Due to the nature of the material the filter should be checked regularly and cleaned as necessary.

When applied by airless spray, dry film thickness of up to 1000 microns (1540 microns wft) may be applied in a single coat. Higher dry film thicknesses should be achieved by the application of two or more separate coats of approximately equal thickness.

## Handling and Safety Precautions

Read all health hazard, precautionary and first aid statements found in the Material Safety Data Sheet, and/or product label prior to handling or use.

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**Corrosion Protection Products**  
**3M United Kingdom plc**  
23 Standard Way Industrial Estate  
Northallerton  
North Yorkshire DL6 2XA  
United Kingdom  
Phone: +44 (0)1609 780170  
Fax: +44 (0)1609 780438  
www.3M.co.uk/scotchkote

**Corrosion Protection Products**  
**3M United Kingdom plc**  
3M Centre  
Cain Road, Bracknell  
Berkshire RG12 8HT  
Phone: 01344 858000  
Fax: 01344 857970  
www.3M.co.uk

For application by brush good quality brushes should be used, however in order to ensure an even coating thickness the desired thickness is best achieved by the application of successive coats of no more than 300 microns dft (460 microns wet per coat).

Clean all equipment immediately after use with clean water followed by 3M™ Scotchkote™ 3000 Cleaner.

Scotchkote Intumescent Coating SPX760 is designed for use in enclosed internal situations. Where exposure to moisture is likely a 3M approved topcoat should be applied. For further guidance contact the Technical Department at Northallerton.

## Packaging and Storage

Supplied in 20 litre units.

Use within 6 months of date of manufacture. Store in original sealed containers at temperatures between 5°C and 30°C.

ALWAYS PROTECT FROM FROST DURING STORAGE AND USE.

## Ordering Information/Customer Service

For ordering, technical and product information or to request a copy of the Material Safety Data Sheet, call +44 (0)1609 780170 or fax +44 (0)1609 783762 (Sales) or 788718 (Technical).

For emergencies, please contact +44 (0)1344 858000.

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