



## PRODUCT INFORMATION

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CE-314  
10/18 Supersedes 09/16

### ***PENNGUARD™ HP Epoxy Primer***

#### **DESCRIPTION**

PENNGUARD HP Epoxy Primer is a high solids two component polyamide epoxy primer consisting of PENNGUARD HP Epoxy Primer - Part "A" and PENNGUARD HP Epoxy Primer Hardener Part "B". Spray application is recommended, but it can be brush or roller applied. Typical dry film thickness is 1.5-3.0 mils (38-75 µm). **Consult Corrosion Engineering specification CES-150 entitled "Specification for Installation for PENNGUARD HP Epoxy Primer" for complete installation details.**

#### **AREAS OF USE**

PENNGUARD HP Epoxy Primer is designed for application onto cleaned and blasted carbon steel substrates to prevent rusting before installation of the PENNGUARD Block Lining System, TUFCEM™ II Membrane and PENNCHEM™ 97 Membrane.

It is intended to prevent re-rusting of blasted steel during the period of time between completion of blasting and application of the subsequent lining system. For priming on alloy substrates consult your PENNGUARD Block Lining System representative.

#### **OUTSTANDING FEATURES**

- Prevents formation of flash rust on previously blasted steel surfaces.
- Greater film build offers longer term protection before installation of subsequent linings.
- Provides for maximum adhesion of Corrosion Engineering lining systems.
- Easy to use with conventional spray equipment.
- Cures quickly at 75°F (24°C). Dries to touch in approximately 2 hours.
- VOC Compliant (<3.5 lb/gal, 0.42 kg/l)
- Lead and chromate free.

**TYPICAL PHYSICAL PROPERTIES**

PROPERTY	PART A	PART B	MIXED
Color	Grey	Clear/ Amber	Grey
Mix Ratio by volume	4.0	1.0	-
Viscosity cps			650 Cps, reacted
Density lbs/gallon (Kg/l)			12.5 lb/gal (1.5 kg/l)
Pot Life @ 75°F (24°C)	-	-	4-6 hrs
Induction period before using	-	-	15 minutes
Dry time to touch 75°F (24°C)			2 hours
Dry time to recoat 75°F (24°C)			4 hours
Solids Content % by volume (ASTM D2369)			50% +- 2%
VOC Lbs/gal (gm/l) (ASTM 3960)			<3.5 lb/gal (0.4 kg/l)
Shelf Life if kept below 70-80°F (21-27°C)	1 year	1 year	-

**ESTIMATING/PACKAGING \*THEORETICAL QUANTITIES – NO OVERAGE ALLOWANCE**

PRODUCT	CODE	PACKAGING	*THEORETICAL COVERAGE*
PG HP Epoxy Primer Part A	29643	1.0 gallon can	1 x 1.0 gallon of PG HP Epoxy Primer Part A, combined with 1 x 1 qt can of PG HP Epoxy Primer Part B will yield 1.25 mixed gallons (4.7 l). Application thickness can range from 3-7 mils WFT (75-175 µm) per coat. A nominal 3-6 mil WFT (75-150 µm) coat is suggested for most applications.  A 1.25 gallon (4.7 l) unit will *theoretically cover 667 sf at a 3.0 mil (62 sm @ 75 µm) thickness, 401 sf @ 5.0 mils (37.5 sm @ 125 µm), and 286 sf @ 7.0 mils (26.5 sm @ 175 µm). Film reduction during curing will reduce the DFT thickness by a factor of approximately 50%.
PG HP Epoxy Primer Part B	29651	1 quart can	

\*Theoretical coverage is a calculation based on 100% yield assuming a perfectly flat surface which is not achievable. The PENNGUARD System requires an SSPC-SP10 (SA 2.5) surface cleanliness. The blast media used to achieve this standard can vary, and this in turn may affect the resultant profile of the steel. A typical finish with a 1.5 to 2.0 mil (38-50 µm) profile will reduce primer practical coverage. Other variables affecting the amount of coverage reduction include loss during mixing, expertise of the applicator, overspray, spillage, and pail residual. Due to potential for variability, coverages cannot be guaranteed.

**SAFETY PRECAUTIONS / DISCLAIMER**

Mixes and applications of this product present a number of hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and material safety data sheets before using. While all statements, technical information, and recommendations contained herein are based on information our company believes to be reliable, nothing contained herein shall constitute any warranty, express or implied, with respect to the products and/or services described herein and any such warranties are expressly disclaimed. We recommend that the prospective purchaser or user independently determine the suitability of our product(s) for their intended use. No statement, information or recommendation with respect to our products, whether contained herein or otherwise communicated, shall be legally binding upon us unless expressly set forth in a written agreement between us and the purchaser/user.

