Corrosion Engineering
A Division of ErgonArmor

PRODUCT INFORMATION

CE-314
11/13 Supersedes 12/08

PENNGUARD® Epoxy Primer

DESCRIPTION

PENNGUARD Epoxy Primer is a two component epoxy primer consisting of PENNGUARD Epoxy Primer - Part "A" and PENNGUARD Epoxy Primer - Part "B". Spray application is recommended, but it can be brush or roller applied. Typical dry film thickness is 0.9 mils. **Consult Corrosion Engineering specification CES-350, entitled "Specifications for Installation for PENNGUARD Block Lining System" for complete installation details.**

AREAS OF USE

PENNGUARD Epoxy Primer is designed for application onto sandblasted metal substrates before installation of the PENNGUARD Block Lining System, TUFCHEM® II Membrane and PENNCHEM® 97 Membrane.

PENNGUARD Epoxy Primer is designed for priming carbon steel, some stainless steels & non-ferrous substrates in stacks, ducts, breaching and vessels. It is intended to prevent re-rusting of sandblasted steel during the period of time between completion of sandblasting and application of the subsequent lining system.

With application onto certain alloy substrates, PENNGUARD Epoxy Primer improves adhesion of PENNGUARD Adhesive/Membrane, TUFCHEM II Membrane, and PENNCHEM 97 Membrane.

OUTSTANDING FEATURES

- Prevents formation of flash rust on previously sandblasted steel surfaces.
- Provides for maximum adhesion of Corrosion Engineering lining systems
- Easy to use with conventional spray equipment
- Cures quickly at 72ϛF (22.2ϛC) – it takes approximately 5 hours.
- VOC Compliant (310 g/L, 2.6 lb/gal)
- Lead and chromate free

TYPICAL PHYSICAL PROPERTIES

PROPERTY	PART A	PART B	MIXED
Color	Red	Clear/ Amber	Red
Mix Ratio by weight	5.0	1.0	-
Mix Ratio by volume	3.0	1.0	-
Viscosity # 2 Ford cup, sec (ASTM D1200)	30 sec (max)	61 sec (max)	40 sec (max)
Density lbs/gallon (Kg/l)	11.97 (1.43)	7.6 (0.91)	10.9 (1.31)
Pot Life @ 75°F (23.8°C)	-	-	4 hrs
Flash point Setaflash CC (ASTM D3278)	22°C (72°F)	26°C (79°F)	22°C (72°F)
Tack Free @ 75°F (24°C)	-	-	5 hours
Recoat Window: May be recoated after primer is tack free (5 hrs min @77°F, 25°C). Do not allow primer to cure more than 18 hours before recoating to avoid adhesion failure of successive coats			
Solids Content % by weight (ASTM D2369) Solids Content % by volume (ASTM D2369)	74 58	80 78	75 63
VOC Lbs/gal (gm/l) (ASTM 3960)	3.11 (373)	1.5 (180)	2.6 (310)
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 Epoxy Primer Part A	29563	4 x 0.75 gal cans/case	1 case of PG Epoxy Primer Part A combined with 1 case of PG Epoxy Primer Part B will yield 4 mixed gallons, which will theoretically* cover 4400 SF @ 1.4-1.5 mils WFT (0.9 mils DFT). (0.049 kg per sm, wft)
PG Epoxy Primer Part B	29564	4 x 0.25 gal cans/case	

* A carbon steel surface prepared to a SSPC-SP10 finish with a 1½ to 2 mil profile may reduce primer practical coverage to about 2800 / ft^2 / 4 mixed gallons @ 1.4-1.5 mils wet thickness. Due to surface texture 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.

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