

Pennguard™ HP Epoxy Primer

SELECTION & SPECIFICATION DATA

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| Type | Polyamide epoxy primer |
| Description | Pennguard HP Epoxy Primer is a 2-component polyamide epoxy holding primer. |
| Uses | Holding primer for freshly cleaned and grit blasted carbon steel surfaces designated to receive the Pennguard Block Lining System or other compatible ErgonArmor lining systems. |
| Features | <ul style="list-style-type: none"> • Prevents formation of flash rust on freshly prepared carbon steel substrates • Holds the blast profile until the lining is installed • Enhances adhesion to the lining • Suitable for brush, roller or conventional single-leg airless spray application • Quick cure • Lead and chromate free |
| Limitations | Not for use beyond its chemical resistance or thermal capabilities. Consult ErgonArmor with specific questions. |

INSTALLATION GUIDANCE

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| Reference Specifications | CES-150 | ErgonArmor Specification for Installation of Pennguard HP Epoxy Primer |
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| Installation Conditions | Pennguard HP Epoxy Primer is formulated for use at temperatures between 50°F (10°C) and 95°F (35°C). Steel temperature must remain at least 5°F (3°C) above the dew point, and relative humidity must be held under 85%. |
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| Ratio | 4 parts resin: 1 part hardener by volume |
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| Mixing | Pour measured quantity of resin into clean, dry mixing vessel. Slowly add measured quantity of hardener to resin and mix until thoroughly blended. Allow material to stand for a 15-minute induction period before use. Stir lightly after induction period before use. |
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| Pot Life | 4-6 hours at 70°F (21°C) |
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| Cleanup | MEK |
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CURE TIME

| Temperature | Dry-to-Touch | Full Cure |
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| 70°F (21°C) | 2 hours | 18-24 hours |

SAFETY

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| Safety | 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 safety data sheets before using. |
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| Ventilation | Provide thorough air circulation during and after application until the material has cured when used in enclosed areas. |
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Pennguard™ HP Epoxy Primer

PACKAGING & ESTIMATING

| Product | Code | Packaging |
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| Pennguard HP Epoxy Primer Part A Resin | 29643 | 1 gallon can |
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| Pennguard HP Epoxy Primer Part B Hardener | 29651 | 1 quart can |
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A 1.25-gallon (4.7 l) unit consists of 1 x 1 gallon can of part A resin and 1 x 1 quart can of part B hardener.

Theoretical Coverage

534 sf/gal at 3 mils (76µm) WFT
320 sf/gal at 5 mils (127µm) WFT

3-5 mils (76-127µm) WFT will yield about 1.5-2.5 mils (38-64µm) DFT.

Actual coverage rate is typically 267-534 sf/gal on substrates with a 1.5-2 mil (38-50µm) profile. Variances in the surface roughness will affect actual coverage rates.

Storage & Shelf Life

Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 2 years when stored in a dry area at 70°F (21°C).

If there is any question with respect to the quality of the components, check reactivity prior to use. For assistance consult with ErgonArmor.

TYPICAL PHYSICAL PROPERTIES

| Property | Typical Value |
|----------------|-------------------------------|
| Color | Gray |
| Density | 12.5 lb/gallon (1.5 kg/liter) |
| Viscosity | 650 cP |
| Solids content | 50% ±2% |
| VOC | <3.5 lb/gallon (0.4 kg/liter) |

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