



TECHNICAL INFORMATION

*CES-150
10/18 SUPERSEDES 05/17*

INSTALLATION SPECIFICATION FOR PENNGUARD™ HP EPOXY PRIMER

1.0 SCOPE

This specification shall cover the following materials: PENNGUARD HP Epoxy Primer as outlined on the most current version of data sheet CE-314.

- 1.2 PENNGUARD HP Epoxy Primer is an industrial lining system most typically used as one of the components of the PENNGUARD Block Lining System. Consult Corrosion Engineering document CES-350 covering the installation of the PENNGUARD Block Lining System for further details on the installation of the other components of the system.

2.0 SURFACE PREPARATION

- 2.1 All welds shall be continuous. Intermittent or spot welding shall not be permitted.
- 2.2 All weld spatter slag and old anchor welds shall be removed from the substrate, and the area ground flush with the parent metal.
- 2.3 Gross pinholes, pits, blind holes, porosity, undercutting, or similar depressions should not exist in the finished surface of the weld before or after blast cleaning.
- 2.4 All edges and fillets and similar abrupt contours shall be rounded off smoothly by grinding or machining. A 1/8" (3 mm) radius is preferable. Smooth ripple finished welds are acceptable.
- 2.5 Plates welded together shall be properly aligned; butt welded joints are preferred.

SPECIFICATION FOR INSTALLATION OF PENNGUARD™ HP EPOXY PRIMER
SPECIFICATION CES-150
10/18 SUPERSEDES: 05/17 Page 2 of 6

- 2.6 Lap welded joints should be avoided wherever possible. If lap-welded joints are used, they must be fully welded on the inside.
- 2.7 All connections to the equipment being lined shall be flanged.
- 2.8 Structural reinforcing members should be installed on the vessel exterior, if possible. However, if such members are installed internally, they should be fabricated of simple shapes such as smooth round bars or pipe for ease of applying the lining material. The use of angles, channels, I-beams, and other complex shapes should be avoided. If they must be installed internally, these members shall be fully seal welded and edges ground.
- 2.9 Unless otherwise specified in writing by Corrosion Engineering or its representative, a near white metal finish (as specified by most current revisions of SSPC-SP10, NACE #2, ISO 8501-1 or SA 2.5) is required for preparing carbon steel surfaces to receive the lining. The resultant surface profile after grit blasting to achieve the near white finish typically falls in the range of 1.5-2.0 mils (38-50 microns), but this is not a hard and fast specification requirement. Variability with the size, shape, and composition of available local blast media may result in the achievement of the required cleanliness standard, while simultaneously producing a blast profile that may fall outside of this range.
- 2.10 For priming of stainless steel, titanium, and nickel alloys (metal surfaces) consult your PENNGUARD Block Lining System representative. A different Primer may be required.
- 2.11 All abrasives and dust must be removed from the substrate in accordance with the most recent revision of ISO 8502-3 prior to priming. The use of a power vacuum is recommended.

3.0 MIXING INSTRUCTIONS

- 3.1 Mixing instructions: PENNGUARD HP Epoxy Primer is mixed in a normal ratio of 4.0 Parts "A" to 1.0 Part "B." It is packaged in pre measured containers. The Part "A" component is packaged in a 1.0 gallon pail and the "B" component is packaged in a separate smaller container for optimized shipping purposes. Both components should be emptied into a separate larger mixing vessel.
- 3.2 Thoroughly mix the contents of the Part "A" component to reconstitute any solids that may have settled during shipping and storage. Thoroughly mix

SPECIFICATION FOR INSTALLATION OF PENNGUARD™ HP EPOXY PRIMER
SPECIFICATION CES-150
10/18 SUPERSEDES: 05/17 Page 3 of 6

the contents of the Part "B" component.

- 3.3 Pour the entire contents of the Part "A" container into the separate mixing container. Add the Part "B" component. Thoroughly mix the combined Part A/B mixture.
- 3.4 Allow mixed material to stand for an induction period of 15 minutes.
- 3.5 Thoroughly re-stir the mixture one final time before starting application.
- 3.6 The primer has a pot-life of 4-6 hours at 75°F (24°C). Mix only enough primer that can be used during this period.
- 3.7 Spray application is preferred, although brush or roller application is acceptable. When installing by brush, use a nylon/polyester or natural bristle. When applying by roller, use a 3/8" (9.0 mm) woven roller with a phenolic core.

4.0 APPLICATION

- 4.1 Application shall be performed within a temperature range of 50°F to 95°F (10°C-35°C). Temperatures must be maintained at least 5°F (3°C) above the moisture dew point, and relative humidity must be maintained below 85%. Work environment of the job site shall be controlled within this range.
- 4.2 Application should be accomplished in a single wet pass with a 50% overlap.
- 4.3 Hold the spray gun at right angles to the surface.
- 4.4 Primer can be applied at varying coverage rates, varying from a rate of 230 sf/gal (7.0 mils/175 µm WFT) to 530 sf/gal (3.0 mils/75 µm WFT). For most applications where a 38-50 µm (1.5-2.0 mils) blast profile has been achieved, it is suggested primer be installed at a nominal thickness of 3.0-6.0 mils (75-150 µm) WFT.
 - 4.4.1 The WFT/DFT thickness of the applied primer has a relationship to its performance and cost. Variables such as the profile of the prepared steel can be impacted by the media used, regardless of the cleanliness standard specified. All of these factors must be considered in advance of the commencement of work to establish agreed QA standards and methodologies.

SPECIFICATION FOR INSTALLATION OF PENNGUARD™ HP EPOXY PRIMER
SPECIFICATION CES-150
10/18 SUPERSEDES: 05/17 Page 4 of 6

- 4.5 WFT (Wet Film Thickness) testing should be performed to monitor specified thicknesses as the job progresses. Film reduction during curing will reduce the DFT thicknesses of the cured lining when applied at the thicknesses above by a factor of approximately 50%.
- 4.6 Suggested spray equipment (or equivalent) as follows:
Gun: DeVilbiss MBC-510
Fluid tip: E
Pressure: 2800-3000 psi (19-20 Mpa)
Hose: 1/4" (6.0 mm) ID
Tip: 0.017"- 0.023" (430-580 µm)
Filter: 60 mesh
- 4.6.1 The above equipment specification is a suggested starting point only. Changes in pressure and tip sizes may be needed for proper atomization.
- 4.7 PENNGUARD HP Epoxy Primer is pre-thinned and further thinning is typically not required. If circumstances and the expertise of the painter deem that thinning may aid in the spraying of the material, PENNGUARD HP Epoxy Primer can be thinned up to 10 % by volume with MEK to assist in spraying if needed. Do not thin more than 10 %.

5.0 CURING AND RECOAT

- 5.1 PENNGUARD HP Epoxy Primer typically cures dry to touch in +/- 2.0 hours at temperatures of 75°F (24°C). High velocity air and good ventilation help to remove solvents and accelerate drying. High humidity slows curing. Primer will dry hard to allow handling in 2 to 4 hours depending on humidity and substrate temperature. Use a fingernail scratch test to insure Primer is cured hard before proceeding.
- 5.2 Recoat: PENNGUARD HP Epoxy Primer is designed to be installed in a single step to the desired thickness. In the event it becomes necessary to perform re-coating or touch-ups, PENNGUARD HP Epoxy Primer may require surface preparation before these operations can be completed. Material will reach approximately 80% of its full cure within 72 hours of application, with the remaining 20% attained over a period of 7-14 days. Recoating within the initial 72 hour period does not require any surface preparation other than dry rag wipe cleaning. Once the initial 72 hour period has passed, the coated surface shall be sanded with a 150-200 grit sandpaper to roughen the coating surface; thus providing a "tooth" that will aid the adhesion of subsequent topcoats.

SPECIFICATION FOR INSTALLATION OF PENNGUARD® HP EPOXY PRIMER
SPECIFICATION CES-150
10/18 SUPERSEDES: 05/17
Page 5 of 6

- 5.3 The Primer must dry hard to touch before commencing application of the PENNGUARD Block Adhesive/Membrane. Do not apply the PENNGUARD Block Lining System on wet or tacky Primer.
- 5.4 Primed components that remain exposed to the elements for excessive lengths of time require the resultant surface chalk to be removed before commencement of repriming or subsequent lining work. Wash affected components with clean water and allow to dry to touch before proceeding with installation of other components of the PENNGUARD Block System. Pressure washing may be more efficient to achieve this for larger areas and is acceptable.

6.0 SAGS AND RUNS

- 6.1 Sags and runs can occasionally be encountered during the installation of PENNGUARD HP Epoxy Primer. While sags and runs are aesthetically unpleasing, they are not necessarily detrimental to the purpose of the Primer, which is to protect the steel from re-rusting before subsequent Block lining work. A sag/run however with a thickness $>200 \mu\text{m}$ (0.008") could develop curing shrinkage stresses that minimizes bond in that area and shall be dealt with.
- 6.2 To assist in defining a standard for pass/fail for sags and runs the following is noted:
 - 6.2.1 A sag is defined as having a width greater than its height and a height not exceeding $200 \mu\text{m}$ (0.008"). A run is defined as singular bubble-shaped slumps of nominal 3 mm width or less and height of $200 \mu\text{m}$ (0.008") or greater.
 - 6.2.2 Sags and run shall be permitted, provided the DFT thickness is less than $200 \mu\text{m}$ (.008"). Runs should ideally be "worked out" during installation while the primer is still wet by using a paint brush or roller to knock down the peaks.
 - 6.2.3 In the event sags or runs in excess of $200 \mu\text{m}$ (.008") are discovered after the Primer has dried, they shall be sanded down so they are below $200 \mu\text{m}$ (.008").

7.0 CLEAN UP

- 7.1 Equipment should be thoroughly cleaned with MEK. Read and follow manufacturer's MSDS's and safety precautions when handling this chemical.

8.0 DISCLAIMER AND CONTACT INFORMATION

- 8.1 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.
- 8.2 Contact Corrosion Engineering for specific recommendations at +1-601-933-3000 or at contactus.corrosion@ergon.com.

www.pennguard.com