

## Penguard Primer

### Product description

This is a two component, polyamide cured, high molecular weight epoxy coating. Designed as a primer for new construction. Can be used as primer as a part of a complete system in atmospheric and immersed environments. Suitable for properly prepared carbon steel, stainless steel, aluminium, concrete, galvanised steel, shop primed steel and thermally sprayed zinc substrates.

### Typical use

Suitable for structural steel and piping to be exposed to corrosive environments up to very high and immersed. Recommended for offshore environments, refineries, power plants, bridges, buildings and mining equipment.

### Approvals and certificates

When used as part of an approved scheme, this material has the following certification:

- Low Flame Spread in accordance with EU Directive for Marine Equipment. Approved in accordance with parts 5 and 2 of Annex 1 of IMO 2010 FTP Code, or Parts 5 and 2 of Annex 1 of IMO FTPC when in compliance with IMO 2010 FTP Code Ch. 8

- Grain, Newcastle Occupational Health

Consult your Jotun representative for details.

Additional certificates and approvals may be available on request.

### Colours

grey, red

### Product data

Property	Test/Standard	Description
Solids by volume	ISO 3233	51 ± 2 %
Gloss level (GU 60 °)	ISO 2813	matt (0-35)
Flash point	ISO 3679 Method 1	25 °C
Density	calculated	1.3 kg/l
VOC-US/Hong Kong	US EPA method 24 (tested) (CARB(SCM)2007, SCAQMD rule 1113, Hong Kong)	440 g/l
VOC-EU	IED (2010/75/EU) (theoretical)	456 g/l
VOC-China	GB/T 23985-2009 (tested)	415 g/l
VOC-Korea	Korea Clean Air Conservation Act (tested) (Max. thinning ratio included)	424 g/l

The provided data is typical for factory produced products, subject to slight variation depending on colour.

All data is valid for mixed paint.

Gloss description: According to Jotun Performance Coatings' definition.

## Film thickness per coat

### Typical recommended specification range

Dry film thickness	40 - 60	µm
Wet film thickness	80 - 120	µm
Theoretical spreading rate	12.8 - 8.5	m <sup>2</sup> /l

## Surface preparation

To secure lasting adhesion to the subsequent product all surfaces shall be clean, dry and free from any contamination.

### Surface preparation summary table

Substrate	Surface preparation	
	Minimum	Recommended
Carbon steel	St 2 (ISO 8501-1)	Sa 2½ (ISO 8501-1)
Stainless steel	The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface.	Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile.
Aluminium	The surface shall be hand or machine abraded with non-metallic abrasives or bonded fibre machine or hand abrasive pads to impart a scratch pattern to the surface.	Abrasive blast cleaning to achieve a surface profile using non-metallic abrasive media which is suitable to achieve a sharp and angular surface profile.
Galvanised steel	The surface shall be clean, dry and appear with a rough and dull profile.	Sweep blast-cleaning using non-metallic abrasive leaving a clean, rough and even pattern.
Shop primed steel	Dry, clean and intact shop primer.	Sweep blasted or alternatively blasted to Sa 2 (ISO 8501-1) of at least 70 % of the surface.
Coated surfaces	Clean, dry and undamaged compatible coating	Clean, dry and undamaged compatible coating
Concrete	Moisture content maximum 5 %. Mechanically prepare the existing concrete surface by scabbling, needle gun, mechanical disc grinding.	Minimum 4 weeks curing. Moisture content maximum 5 %. Prepare the surface by means of enclosed blast shot or diamond grinding and other appropriate means to abrade the surrounding concrete and to remove laitance.

Optimum performance, including adhesion, corrosion protection, heat resistance and chemical resistance is achieved with recommended surface preparation.

## Application

### Application methods

The product can be applied by

- Spray: Use airless spray.
- Brush: Recommended for stripe coating and small areas. Care must be taken to achieve the specified dry film thickness.

### Product mixing ratio (by volume)

Penguard Primer Comp A	4 part(s)
Penguard Comp B	1 part(s)

### Thinner/Cleaning solvent

Thinner: Jotun Thinner No. 17

### Guiding data for airless spray

Nozzle tip (inch/1000):	15-19
Pressure at nozzle (minimum):	150 bar/2100 psi

## Drying and Curing time

Substrate temperature	10 °C	23 °C	40 °C
Surface (touch) dry	2 h	1 h	30 min
Walk-on-dry	14 h	6.5 h	3 h
Dry to over coat, minimum	8 h	4 h	3 h
Dried/cured for service	14 d	7 d	3 d

For maximum overcoating intervals, refer to the Application Guide (AG) for this product.

Drying and curing times are determined under controlled temperatures and relative humidity below 85 %, and at average of the DFT range for the product.

Surface (touch) dry: The state of drying when slight pressure with a finger does not leave an imprint or reveal tackiness.

Walk-on-dry: Minimum time before the coating can tolerate normal foot traffic without permanent marks, imprints or other physical damage.

Dry to over coat, minimum: The recommended shortest time before the next coat can be applied.

Dried/cured for service: Minimum time before the coating can be permanently exposed to the intended environment/medium.

## Induction time and Pot life

<b>Paint temperature</b>	<b>23 °C</b>
Induction time	30 min
Pot life	8 h

## Heat resistance

	Temperature	
	Continuous	Peak
Dry, atmospheric	120 °C	140 °C
Immersed, sea water	50 °C	60 °C

Peak temperature duration max. 1 hour.

The temperatures listed relate to retention of protective properties. Aesthetic properties may suffer at these temperatures.

Note that the coating will be resistant to various immersion temperatures depending on the specific chemical and whether immersion is constant or intermittent. Heat resistance is influenced by the total coating system. If used as part of a system, ensure all coatings in the system have similar heat resistance.

## Product compatibility

Depending on the actual exposure of the coating system, various primers and topcoats can be used in combination with this product. Some examples are shown below. Contact Jotun for specific system recommendation.

Previous coat: epoxy, epoxy mastic, zinc epoxy, zinc silicate  
Subsequent coat: acrylic, epoxy, polyurethane, polysiloxane

## Packaging (typical)

	Volume (litres)	Size of containers (litres)
Penguard Primer Comp A	4/16	5/20
Penguard Comp B	1/4	1/5

The volume stated is for factory made colours. Note that local variants in pack size and filled volumes can vary due to local regulations.

## Storage

The product must be stored in accordance with national regulations. Keep the containers in a dry, cool, well ventilated space and away from sources of heat and ignition. Containers must be kept tightly closed. Handle with care.

### Shelf life at 23 °C

Penguard Primer Comp A	24 month(s)
Penguard Comp B	48 month(s)

In some markets commercial shelf life can be dictated shorter by local legislation. The above is minimum shelf life, thereafter the paint quality is subject to re-inspection.

### Caution

This product is for professional use only. The applicators and operators shall be trained, experienced and have the capability and equipment to mix/stir and apply the coatings correctly and according to Jotun's technical documentation. Applicators and operators shall use appropriate personal protection equipment when using this product. This guideline is given based on the current knowledge of the product. Any suggested deviation to suit the site conditions shall be forwarded to the responsible Jotun representative for approval before commencing the work.

### Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not inhale spray mist. Avoid skin contact. Spillage on the skin should immediately be removed with suitable cleanser, soap and water. Eyes should be well flushed with water and medical attention sought immediately.

### Colour variation

When applicable, products primarily meant for use as primers or antifoulings may have slight colour variations from batch to batch. Such products and epoxy based products used as a finish coat may chalk when exposed to sunlight and weathering.

Colour and gloss retention on topcoats/finish coats may vary depending on type of colour, exposure environment such as temperature, UV intensity etc., application quality and generic type of paint. Contact your local Jotun office for further information.

### Disclaimer

The information in this document is given to the best of Jotun's knowledge, based on laboratory testing and practical experience. Jotun's products are considered as semi-finished goods and as such, products are often used under conditions beyond Jotun's control. Jotun cannot guarantee anything but the quality of the product itself. Minor product variations may be implemented in order to comply with local requirements. Jotun reserves the right to change the given data without further notice.

Users should always consult Jotun for specific guidance on the general suitability of this product for their needs and specific application practices.

If there is any inconsistency between different language issues of this document, the English (United Kingdom) version will prevail.