

# Technical Data

## PENGUARD EXPRESS



### Product description

Penguard Express is a fast drying, high solids two-pack epoxy coating which may be applied in high film thickness and at lower temperatures.

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### Recommended use

As an anti corrosive primer and/or intermediate coating for corrosion protection of steel and other substrates in atmospheric exposure where fast dry-to-recoat and/or dry-to-handle times are desired. Can be used alone or in various systems of primers and topcoats.

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### Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry ( $\mu\text{m}$ )	75	250	125
Film thickness, wet ( $\mu\text{m}$ )	100	340	170
Theoretical spreading rate ( $\text{m}^2/\text{l}$ )	9,9	3	5,9

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### Physical properties

Colour	Grey, Red, Buff, Light Red, Turquoise
Solids (vol %)*	74 $\pm$ 2
Flash point	32°C $\pm$ 2 (Setaflash)
VOC	230 gms/ltr UK-PG6/23(97). Appendix 3
Gloss	Flat
Gloss retention	Fair
Water resistance	Very good
Abrasion resistance	Very good
Solvent resistance	Excellent
Chemical resistance	Excellent
Flexibility	Good

\*Measured according to ISO 3233:1998 (E)

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### Surface preparation

All surfaces should be clean, dry and free from contamination. The surface should be assessed and treated in accordance with ISO 8504.

#### Bare steel

Cleanliness: Blast cleaning to Sa 2½ (ISO 8501-1:1988). Roughness: using abrasives suitable to achieve grade Fine to Medium G (30-85  $\mu\text{m}$ , Ry5) (ISO 8503-2)

#### Shopprimed steel

Clean, dry and undamaged approved shopprimer.

#### Coated surfaces

Clean, dry and undamaged compatible primer. Please contact your local Jotun office for more information.

#### Other surfaces

For aluminium and galvanized surface; degreasing, light abrading or sand sweeping.

The coating may be used on other substrates. Please contact your local Jotun office for more information.

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### Condition during application

The temperature of the substrate should be minimum -5°C and at least 3°C above the dew point of the air, temperature and relative humidity measured in the vicinity of the substrate. Good ventilation is required in confined areas to ensure proper drying. The coating should not be exposed to oil, chemicals or mechanical stress until cured.

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### Application methods

Spray Use airless spray

Brush Recommended for stripe coating and small areas, care must be taken to achieve the specified dry film thickness.

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### Application data

Mixing ratio (volume) 4 parts Comp. A (base) to be mixed thoroughly with 1 part Comp. B (curing agent)

Mixing 10 min prior to use.

Pot life (23°C) 2 hours. (Reduced at higher temp.)

Thinner/Cleaner Jotun Thinner No. 17

Guiding data airless spray

Pressure at nozzle 15 MPa (150 kp/cm<sup>2</sup>, 2100 psi)

Nozzle tip 0.46 - 0.69 mm (0.018-0.027")

Spray angle 40 - 80°

Filter Check to ensure that filters are clean.

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### Drying time

Drying times are generally related to air circulation, temperature, film thickness and number of coats, and will be affected correspondingly. The figures given in the table are typical with:

- \* Good ventilation (Outdoor exposure or free circulation of air)
- \* Typical film thickness
- \* One coat on top of inert substrate

Substrate temperature	-5°C	0°C	5°C	10°C	23°C
Surface dry	16 h	11 h	4 h	2 h	1 h
Through dry	38 h	24 h	10 h	6 h	3 h
Cured	-	21 d	13 d	8 d	4 d
Dry to recoat, minimum	24 h	14 h	8 h	4 h	2 h
Dry to recoat, maximum <sup>1</sup>					

Substrate temperature	40°C
Surface dry	0,5 h
Through dry	2 h
Cured	3 d
Dry to recoat, minimum	1 h
Dry to recoat, maximum <sup>1</sup>	

1. Provided the surface is free from chalking and other contamination prior to application, there is normally no overcoating time limit. Best intercoat adhesion occurs, however, when the subsequent coat is applied before preceding coat has cured. If the coating has been exposed to direct sunlight for some time, special attention must be paid to surface cleaning and mattening/removal of the surface layer in order to obtain good adhesion

The given data must be considered as guidelines only. The actual drying time/times before recoating may be shorter or longer, depending on film thickness, ventilation, humidity, underlying paint system, requirement for early handling and mechanical strength etc. A complete system can be described on a system sheet, where all parameters and special conditions could be included.

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## Typical paint system

Barrier	1 x 50 µm	(Dry Film Thickness)
Penguard Express	1 x 150 µm	(Dry Film Thickness)
Hardtop AS/Hardtop XP	1 x 50 µm	(Dry Film Thickness)
or		
Penguard Express	2 x 125 µm	(Dry Film Thickness)
Hardtop AS/Hardtop XP	1 x 50 µm	(Dry Film Thickness)

Other systems may be specified, depending on area of use

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## Storage

The product must be stored in accordance with national regulations. Preferred storage conditions are to keep the containers in a dry space provided with adequate ventilation. The containers should be sealed tightly.

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## Handling

Handle with care. Stir well before use.

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## Packing size

16 litres Comp. A (base) in a 20 litre container and 4 litres Comp. B (curing agent) in a 5 litre container and  
4 litres Comp. A (base) in a 5 litre container and 1 litres Comp. B (curing agent) in a 1 litre container.

Packing may vary from country to country according to local requirements.

## Health and safety

Please observe the precautionary notices displayed on the container. Use under well ventilated conditions. Do not breathe or inhale 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.

For detailed information on the health and safety hazards and precautions for use of this product, we refer to the Material Safety Data Sheet.

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### DISCLAIMER

*The information in this data sheet is given to the best of our knowledge based on laboratory testing and practical experience. However, as the product is often used under conditions beyond our control, we cannot guarantee anything but the quality of the product itself. We reserve the right to change the given data without notice.*

Footer - English

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