

# Technical Data

## PENGUARD TIE COAT 100



### Product description

Penguard Tie Coat 100 is a two-pack corrosion preventing polyamide cured epoxy tie coat.

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### Recommended use

On steel structures for use as tie coat/sealer on top of inorganic zinc silicate.

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### Film thickness and spreading rate

	Minimum	Maximum	Typical
Film thickness, dry ( $\mu\text{m}$ )	30	50	35
Film thickness, wet ( $\mu\text{m}$ )	70	120	85
Theoretical spreading rate ( $\text{m}^2/\text{l}$ )	14	8,4	12

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### Physical properties

Colour	Red
Solids (vol %)*	42 $\pm$ 2
Flash point	25°C $\pm$ 2 (Setaflash)
VOC	480 gms/ltr UK-PG6/23(97). Appendix 3
Gloss	Semigloss
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.

#### Coated surfaces

Cured and clean inorganic zinc silicate primer (tested with MEK).

#### Other surfaces

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 usually 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 or conventional 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) 2 parts Comp. A (base) to be mixed thoroughly with 1 part Comp. B (curing agent)

Induction time 30 minutes.  
Pot life (23°C) 4 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 0.018" (0.46 mm)  
Spray angle 40-80°  
Filter Check to ensure that filters are clean.

Note Thinner should be added after mixing components. Extra thinner (up to 30%) may be added to avoid popping on difficult substrates.

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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

Normal hardener			
Substrate temperature	10°C	23°C	40°C
Surface dry	2 h	1 h	0,5 h
Through dry	14 h	6,5 h	3 h
Cured	14 d	7 d	3 d
Dry to recoat, minimum	18 h	6 h	3 h
Dry to recoat, maximum <sup>1</sup>			

1. The surface should be free from chalking and contamination prior to application of the subsequent coat.

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.

## Typical paint system

Resist 78 or Resist 86	1 x 60 µm	(Dry Film Thickness)
Penguard Tie Coat 100	1 x 35 µm	(Dry Film Thickness)
Jotamastic 87	1 x 200 µm	(Dry Film Thickness)
Hardtop AS	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. Storage conditions are to keep the containers in a dry, cool, well ventilated space and away from source of heat and ignition. Containers must be kept tightly closed.

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## Handling

Handle with care. Stir well before use.

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## Packing size

20 litre unit: 13 litres Comp. A (base) in a 20 litre container and 6.5 litres Comp. B (curing agent) in a 10 litre container

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

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## 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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