

## Penguard Tie Coat 100

### Product description

This is a two component, polyamide cured, high molecular weight epoxy coating. Specially designed as holding primer, sealer and as a tie coat on top of inorganic zinc silicate primers, galvanized steel and thermally sprayed zinc. To be used as primer in a complete system in atmospheric environments.

### Typical use

Suitable for structural steel and piping exposed to highly corrosive environments. Recommended for offshore environments, refineries, power plants, bridges, buildings and mining equipment.

### Approvals and certificates

Pre-qualification testing in accordance with NORSOK M-501, Rev. 5, System 1, suitable for exterior exposure in offshore environment, below 250°F (120 °C).

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

Consult your Jotun representative for details.

Additional certificates and approvals may be available on request.

### Colors

red

### Product data

Property	Test/Standard	Description
Solids by volume	ISO 3233	42 ± 2 %
Gloss level (GU 60 °)	ISO 2813	semi gloss (35-70)
Flash point	ISO 3679 Method 1	77 °F (25 °C)
Density	calculated	1.4 kg/l
VOC-US/Hong Kong	US EPA method 24 (tested) (CARB(SCM)2007, SCAQMD rule 1113, Hong Kong)	4.19 lbs/gal

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

Gloss description: According to Jotun Performance Coatings' definition.

## Film thickness per coat

### Typical recommended specification range

Dry film thickness	1 mils (25 µm)	2 mils (50 µm)
Wet film thickness	2.4 mils (60 µm)	5 mils (120 µm)
Theoretical spreading rate	690 ft <sup>2</sup> /gal (17 m <sup>2</sup> /l)	340 ft <sup>2</sup> /gal (8.4 m <sup>2</sup> /l)

Higher film thickness may be required to entirely seal porous substrates.

## Surface preparation

### Surface preparation summary table

Substrate	Surface preparation	
	Minimum	Recommended
Galvanized 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.
Coated surfaces	Clean, dry and undamaged compatible coating	Clean, dry and undamaged compatible coating

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 air spray or 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 Tie Coat 100 Comp A	2 part(s)
Penguard Tie Coat 100 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

Temperatures:  
-10°C = 14°F / -5°C = 23°F / 0°C = 32°F / 5°C = 41°F / 10°C = 50°F / 15°C = 59°F / 23°C = 73°F / 35°C = 95°F / 40°C = 104°F / 100°C = 212°F

Substrate temperature	5 °C	10 °C	23 °C	40 °C
Surface (touch) dry	5 h	2 h	1 h	30 min
Walk-on-dry	24 h	14 h	6.5 h	3 h
Dried to over coat, minimum	24 h	18 h	6 h	3 h
Dried/cured for service	16 d	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

Temperatures: 15°C = 59°F / 23°C = 73°F

Paint temperature	23 °C
Induction time	30 min
Pot life	4 h

## Heat resistance

	Temperature	
	Continuous	Peak
Dry, atmospheric	120 °C	140 °C

Peak temperature duration max. 1 hour.

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

## 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: zinc silicate, epoxy  
Subsequent coat: acrylic, epoxy, polyurethane

## Packaging (typical)

	Volume (liters)	Size of containers (liters)
Penguard Tie Coat 100 Comp A	13	20
Penguard Tie Coat 100 Comp B	6.5	10

The volume stated is for factory made colors. 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 73°F (23 °C)

Penguard Tie Coat 100 Comp A 24 month(s)  
Penguard Tie Coat 100 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.

---

## Note

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.

---

## Color variation

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

Color and gloss retention on topcoats/finish coats may vary depending on type of color, 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.

---