



800 324 9584 | 3333 R. ARRINGTON N. • BHAM, AL 35234

TECHNICAL DATA

ARMORGUARD P 14 EPOXY PRIMER

COATING DATA

DESCRIPTION:

A two component, polyamide cured epoxy, high build, rust inhibitive primer. This product is formulated for excellent resistance to abrasive and corrosive environments. It will cure to provide excellent barrier and inhibitive properties when applied to properly prepared steel and iron surfaces. This product meets the requirements of ANSI/AWWA D102-03 Outside System No. 5 for first coat.

Armorguard P 14 Epoxy Primer

- Lead and chromate free.
- Complies with U.S. EPA National Volatile Organic Compound (VOC) Emission Standards for industrial maintenance coatings effective September 13, 1999.
- High film build capabilities.
- Excellent chemical resistance.
- Very high performance. See Armorguard System Data Sheet Number 320.
- Performs well in many aggressive environments including the following substrates:
 - Structural steel
 - Piping
 - Equipment and machinery
 - Bridges
 - Storage tanks

Armorguard P 14 Primer Salt Fog Testing:

One coat Armorguard P 14 Primer applied at 3.0-5.0 mil dry film thickness to sandblasted steel.

Exposure—2,000 hours

Results—Red rust at scribe. Undercutting at scribe < 1/8 in.—No blisters

USE:

Use where a high solids, lead and chromate free chemical and corrosion resistant coating is required. Use to protect ferrous metals exposed in a variety of aggressive environments including abrasion, immersion in water, brines, caustic, aliphatic solvents or spillage of aromatic solvents, or dilute acids. This primer may be topcoated with Induron epoxies or Indurethane.

LIMITATIONS:

Do not use on surface temperatures above 200°F (93°C).

SURFACE PREPARATION:

Steel (Non-Immersion)—For best results, SSPC-SP 6 Commercial Blast and Remove all surface contaminants. **Steel (Immersion)**—Use SSPC-SP 10 Near White Blast and remove all surface contaminants. **Ductile Iron**—Remove all surface contaminants by blasting. Do not coat surfaces previously coated with asphalt.

COVERAGE:

Theoretical—821 ft² per gallon at 1.0 mil dry film thickness.

DRY FILM THICKNESS:

2.0 to 5.0 mils per coat.

WET FILM THICKNESS:

3.9 to 9.8 mils.

APPLICATION DATA**BLEND RATIO:**

One part Armorguard Base to one part Armorguard Polyamide Epoxy Blending Resin. Power agitate until components are thoroughly mixed. Allow mixed components to stand fifteen minutes prior to application.

POT LIFE:

Six hours at 80°F, decreasing at higher temperature.

APPLICATION:

Airless Spray—Use .015-.019 tip; 60 mesh filter; 30:1 pump ratio at 60-100 psi operating air pressure.

Conventional Spray—Follow instructions of equipment manufacturer for the application of epoxy paints.

Roll—Use lambswool cover. Additional coats may be required to achieve desired film thickness. **Brush**—Use natural bristle brush. Additional coats may be required to achieve desired film thickness.

THINNING:

If required, thin up to 10% with K-1066 Reducer. Clean equipment with K-1066 Reducer.

CLIMATE:

Use this product only if the substrate temperature and ambient air temperature is above 40°F and is expected not to decrease for at least two hours after application. Also, the substrate temperature must be 5°F above the dewpoint for a period of at least two hours after application to avoid condensation occurring on wet paint.

DRY TIME:

TO HANDLE—7 hours at 80°F.

TO RECOAT—50°F or higher, overnight; 40°F-50°F, second day.

IMMERSION SERVICE—50°F or higher, seven days with proper ventilation; 40°F-50°F, 14 days with proper ventilation. Ventilation during application and after must be in accordance with AWWA D102-97 Section 4.7.3.

Note: High film thickness, low temperature and/or poor ventilation will retard dry time.

PHYSICAL DATA:

VOLUME SOLIDS: 51% ± 1%

SOLIDS BY WEIGHT: 64% ± 1%

WEIGHT PER GALLON: 10.0 ± .2 lbs/gallon

VOLATILE ORGANIC CONTENTS:

Mixed unthinned - < 3.5 lbs/gallon; < 420 grams/liter

Mixed thinned 10% - < 3.8 lbs/gallon; < 450 grams/lite

SAFETY DATA:

This product is formulated free of lead, mercury, and chromates. See individual product label for safety and health data information. Individual Material Safety Data Sheets are available upon request. 115