



Pennguard™ HP Epoxy Primer

SELECTION & SPECIFICATION DATA

Type	Polyamide epoxy primer
Description	Pennguard HP Epoxy Primer is a 2-component polyamide epoxy holding primer.
Uses	Holding primer for freshly cleaned and grit blasted carbon steel surfaces designated to receive the Pennguard Block Lining System or other compatible Armor lining systems.
Features	<ul style="list-style-type: none">• Prevents formation of flash rust on freshly prepared carbon steel substrates• Holds the blast profile until the lining is installed• Enhances adhesion to the lining• Suitable for brush, roller or conventional single-leg airless spray application• Quick cure• Lead and chromate free
Limitations	Not for use beyond its chemical resistance or thermal capabilities. Consult Armor with specific questions.

INSTALLATION GUIDANCE

Reference Specifications	CES-150	Armor Specification for Installation of Pennguard HP Epoxy Primer
Installation Conditions	Pennguard HP Epoxy Primer is formulated for use at temperatures between 50°F (10°C) and 95°F (35°C). Steel temperature must remain at least 5°F (3°C) above the dew point, and relative humidity must be held under 85%.	
Ratio	4 parts resin: 1 part hardener by volume	
Mixing	Pour measured quantity of resin into clean, dry mixing vessel. Slowly add measured quantity of hardener to resin and mix until thoroughly blended. Allow material to stand for a 15-minute induction period before use. Stir lightly after induction period before use.	
Pot Life	4-6 hours at 70°F (21°C)	
Cleanup	MEK	

CURE TIME

Temperature	Dry-to-Touch	Full Cure
70°F (21°C)	2 hours	18-24 hours

SAFETY

Safety	Mixes and applications of this product present a number of hazards. Read and follow the hazard information, precautions and first aid directions on the individual product labels and safety data sheets before using.
Ventilation	Provide thorough air circulation during and after application until the material has cured when used in enclosed areas.



Pennguard™ HP Epoxy Primer

PACKAGING, ESTIMATING & HANDLING

Product	Code	Packaging
Pennguard HP Epoxy Primer Part A Resin	29643 29563	1-gallon (3.8 l) can 4-gallon (15.2 l) pail
Pennguard HP Epoxy Primer Part B Hardener	29651 29566	1-quart (0.9 l) can 1-gallon (3.8 l) can
<p>A 1.25-gallon (4.7 l) unit consists of 1 x 1-gallon can of Part A Resin and 1 x 1-quart can of Part B Hardener. A 5.0-gallon unit consists of 1 x 4-gallon pail of Part A Resin and 1 x 1-gallon can of Part B Hardener.</p>		
Theoretical Coverage	534 sf (49.6 sm)/gallon at 3 mils (75µm) WFT 320 sf (29.7 sm)/gallon at 5 mils (125 µm) WFT 229 sf (21.3 sm)/gallon at 7 mils (175 µm) WFT Actual coverage rate will vary with steel roughness profile and is typically 400 sf (37.6 sm)/gallon on substrates with a 1.5-2 mil (38-50 µm) profile. Variances in the surface roughness will affect actual coverage rates, allow overage accordingly..	
Storage & Shelf Life	Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 2 years when stored in a dry area at 70°F (21°C). If there is any question with respect to the quality of the components, check reactivity prior to use. For assistance consult with Armor.	

TYPICAL PHYSICAL PROPERTIES

Property	Typical Value
Color	Gray
Density	12.5 lb/gallon (1.5 kg/liter)
Viscosity	650 cP
Solids content	50% ±2%
Shear strength carbon steel, ASTM D1002	>350 psi (1.7 MPa)
Pull off strength carbon steel ,ASTM D45441	>1,000 psi (6.9 MPa)
VOC	<3.5 lb/gallon (0.4 kg/liter)

Rev 11/2025

TERMS AND CONDITIONS OF SALE

While statements, technical information and recommendations contained herein are based on information our company believes to be reliable, nothing contained herein shall constitute any warranty, express or implied, with respect to the products and/or services described herein and any such warranties are expressly disclaimed. We recommend that the prospective purchaser or user independently determine the suitability of our product(s) for their intended use. No statement, information or recommendation with respect to our products, whether contained herein or otherwise communicated, shall be legally binding upon us unless expressly set forth in a written agreement between us and the purchaser/user. For all Terms and Conditions of Sale see armor-inc.com.