

## SELECTION & SPECIFICATION DATA

<b>Type</b>	Graphite filled novolac vinyl ester lining
<b>Description</b>	Penncoat 332 is a 30-40 mil thick, graphite filled, novolac vinyl ester resin lining.
<b>Color</b>	Dark Grey
<b>Uses</b>	<ul style="list-style-type: none"> <li>• Topcoat for troweled polymer mortars and laminate systems in concrete trenches, sumps, and secondary containment areas.</li> <li>• Chemical resistant coating for floors subject to foot and light forklift traffic.</li> <li>• Tank lining</li> <li>• Steel structure coating.</li> </ul>
<b>Features</b>	<ul style="list-style-type: none"> <li>• Outstanding chemical resistance.</li> <li>• Resists hydrofluoric acid, fluorosilicic acid, and hydrofluorosilicic acid.</li> <li>• Quick turn around for service.</li> </ul>
<b>Limitations</b>	<p>Penncoat 332 is not intended to be used as a cosmetic finish and color stability will not be achievable.</p> <p>Contact with the surface may result in some of the graphite filler transferring from the surface, however, this does not affect performance.</p>

## SUBSTRATE & SURFACE PREPERATION

<b>All</b>	Substrate must be clean, dry and free of contaminants including soluble salts.
<b>Steels</b>	<p>Immersion: SSPC-SP 5/NACE No. 1, White Metal Blast Cleaning with jagged, angular profile 3.0 to 5.0 mils.</p> <p>Non-Immersion: SSPC-SP 6/NACE No. 3, Commercial Blast Cleaning with jagged, annular profile 3.0 to 5.0 mils.</p>
<b>Concrete</b>	<p>Concrete: Concrete must be cured 28 days at 75°F (24°C) and 50% relative humidity or equivalent. Prepare surfaces in accordance with SSPC-SP 13/NACE 6, Surface Preparation of Concrete. Required surface profile is CSP 3-5. Voids and damaged concrete surfaces shall be repaired.</p> <p>Prime steel and concrete with Penntrowel Vinyl Ester Primer.</p> <p>When working outside or in direct sunlight, concrete outgassing may occur when the surface temperature rises due to sunlight or increased ambient temperature. This can cause bubbles or holes in the applied floor, lining or coating. When this problem occurs shade the surface from sunlight and/or apply the material in the cooler evening or at night so the initial cure can take place without air outgassing from the concrete.</p>

## MIXING & THINNING

<b>Ratio</b>	1 gallon Part A resin : 2.0 -2.5 fl. oz. Part B hardener		
<b>Mixing</b>	Mix resin for 1 minute to loosen. Continue mixing while slowly adding the hardener into the center vortex, and mix thoroughly for 3 minutes, moving the mix blade up, down and around the pail to catch all the edges.		
<b>Thinning</b>	Do not thin.		
<b>Pot Life</b>	50°F (10°C) 60 minutes	75°F (24°C) 30 minutes	90°F (32°C) 15 minutes
	Pot life is shorter at higher temperatures. A larger volume of mixed material will have a shorter pot life than a smaller volume.		
<b>Cleanup</b>	Methyl ethyl ketone or lacquer thinner		

## APPLICATION GUIDANCE

<b>Installation Specification</b>	CES-259 Installation Specification for Penncoat 331 and 340 Linings
<b>Installation Conditions</b>	Penncoat 332 Lining is formulated for ideal handling at 70°F (21°C). Materials and substrate should be acclimated to the air temperature prior to installation, and the air temperature should be between 50°F (10°C) and 90°F (32°C) during installation and cure.
<b>Brush</b>	Brush application in small areas
<b>Roller</b>	Short nap or mohair phenolic core roller
<b>Spray</b>	30:1 to 56:1 Pump Tip range 0.036 – 0.045

## CURE TIME & RECOAT WINDOW

<b>Substrate Temperature</b>	<b>Initial Set</b>	<b>Minimum Recoat</b>	<b>Maximum Recoat</b>	<b>Full Cure</b>
50°F (10°C)	5 hours	12 hours	7 days	48 hours
75°F (24°C)	2 hours	4.5 hours	7 days	24 hours
90°F (32°C)	1.5 hours	3 hours	3 days	8 hours

When surface temperatures exceed 95°F (35°C) or are exposed to direct sunlight, overcoating should take place as soon as coating may be walked on or handled without marring in order to avoid intercoat adhesion issues.

**PACKAGING, ESTIMATING & HANDLING**

Product	Code	Packaging
Penncoat 332 Resin	29451	1.0 -gal (9 lb) can
	29452	4.5 - gal (44 lb) pail
CHP Hardener	19552	11.2 fl. oz. (0.7 lb) bottle
	21922	1 gal (8.3 lb) can

A 1.0-gal unit consists of 1 x 9 lb can and 1 x 0.7 lb bottle hardener.

4.5-gal unit consists of 1 x 44-lb pail resin and 1 x 0.7 lb bottle hardener.

**Theoretical Coverage** 79 ft<sup>2</sup> to 105 ft<sup>2</sup> (7.3 m<sup>2</sup> to 9.8 m<sup>2</sup>) yields 18 – 24 mils (457 – 610 microns) WFT per coat equivalent to 15 – 20 mils (381 – 508 microns) DFT per coat. 2 coats are recommended for immersion service.

**Storage & Shelf Life** Maintain products in original packaging and sealed until ready for use. Estimated shelf life of resin is 6 months and hardener is 1 year when stored in a dry area at 70°F (21°C). Actual shelf life may vary with storage conditions.

If there is any question with respect to the quality of the components, check reactivity prior to use. For assistance consult with ErgonArmor.

**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.

**TYPICAL PHYSICAL PROPERTIES**

Property	Typical Value
Color	Grey
Gloss	Not applicable
Density	10.1 lb/gallon (1.21 kg/L)
Solids content	100% reactive

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**TERMS AND CONDITIONS OF SALE**

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