

CE-366 Page 1 of 2 Penncoat[™] 332

SELECTION & SPECIFICATION DATA

Туре	Graphite filled novolac vinyl ester lining			
Description	Penncoat 332 is a nominal 25 mil thick, graphite filled, novolac vinyl ester resin lining.			
Features	 Outstanding chemical resistance Resists hydrofluoric acid, fluorosilicic acid, and hydrofluorosilicic acid Quick return-to-service 			
Uses	Corrosion protection lining or chemical resistant topcoat for concrete and steel structures in phosphoric acid and phosphate fertilizer plants exposed to phosphoric acid containing fluoride compounds.			
Limitations	Penncoat 332 is not intended to be used as a color stable, cosmetic finish.			
	Some of the graphite might rub off on objects that touch the surface of the cured lining. This graphite transfer does not indicate the lining is defective or deteriorating.			

SUBSTRATE & SURFACE PREPARATION

Substrate must be clean, dry and free of All contaminants including soluble salts. Immersion: SSPC-SP 5/NACE No. 1 White Metal Steel Blast with angular profile of 3.0 to 5.0 mils. Non-Immersion: SSPC-SP 6/NACE No. 3 Commercial Blast with annular profile of 3.0 to 5.0 mils. Prime with Penntrowel[™] Vinyl Ester Primer. Concrete must be cured 28 days at 75°F (24°C) Concrete 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 in concrete surfaces will require filling. Apply Penntrowel[™] Vinyl Ester Primer when concrete is cooling or shaded to prevent pinholes due to outgassing.

MIXING & THINNING

Ratio	1 gallon Part A resin : 2.0 fl. oz. Part B hardener. Use up to 3.0 fl. oz. Part B hardener to speed cure under cool conditions.				
Mixing	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.				
Thinning	Do not thin.				
Pot Life	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.				
Cleanup	Methyl ethyl ketone or lacquer thinner				
APPLICATION GUIDANCE					
Installation Specification	CES-259 Installation Specification for Penncoat 332 and 340 Linings				
Installation Conditions	Penncoat 332 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.				
Brush	Brush application in small areas				
Roller	Short nap or mohair phenolic core roller				
Airless Spray	Pump size: 30:1 to 56:1 Tip size: 0.036-inch to 0.045-inch				

CURE SCHEDULE & RECOAT WINDOW

SUBSTRATE TEMPERATURE	INITIAL SET	MINIMUM RECOAT	MAXIMUM RECOAT	FULL CURE
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 temperature exceeds $95^{\circ}F$ ($35^{\circ}C$) or the surface is exposed to direct sunlight, overcoat 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 29451 1.0-gal (9 lb) can 4.5-gal (44 lb) pail 29452 **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 resin and 2-3 fl. oz. hardener. 4.5-gal unit consists of 1 x 44-lb pail resin and 1 x 0.7 lb bottle hardener. 100 - 115 ft² (9.3 - 10.7 m²) per gallon per coat at Theoretical 14 - 16 mils (356 - 406 microns) WFT to yield 12 -Coverage 14 mils (279 - 305 microns) DFT per coat. Minimum 2 coats recommended for immersion service Maintain products in original packaging and Storage & sealed until ready for use. Estimated shelf life of Shelf Life resin is 6 months and hardener is 1 year when stored in a dry area at 70°F (21°C). Store resin between 55°F (13°C) and 65°F (18°C) to maximize shelf life. 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. Mixes and applications of this product present a Safety 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.

CE-366 Page 2 of 2 Penncoat[™] 332

Rev 05/2023

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 ergonarmor.com.

Division of Ergon Asphalt & Emulsions, Inc. | P.O. Box 1639, Jackson, MS 39215-1639 | 601-933-3381 Fax | 601-933-3595 Phone | 877-98ARMOR Toll-Free | ergonarmor.com

TYPICAL PHYSICAL PROPERTIES

Typical Value

Dark Gray

Not applicable

100% reactive

10.1 lb/gallon (1.21 kg/L)

Property Color Gloss Density Solids content