

SELECTION & SPECIFICATION DATA

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| Type | Flake filled novolac vinyl ester lining |
| Description | Penncoat 331 Lining is a flake filled novolac vinyl ester lining system with excellent resistance to organic and inorganic acids and many aliphatic solvents. Penncoat 331 MR Lining incorporates a 1 oz. mat reinforcement into the primer layer to reduce crack transmission. |
| Features | <ul style="list-style-type: none"> • Broad resistance to most acids, alkalis and aliphatic solvents • Flake filled for enhanced permeation resistance • Chopped strand mat in the primer layer of Penncoat 331 MR Lining reduces potential for concrete crack transmission • Installation by airless spray, roller or brush |
| Uses | <ul style="list-style-type: none"> • Tank linings • Steel structures • Chemical resistant floor coating • Chemical splash and spill areas • Secondary containment lining |
| Finish | Gloss |
| Typical Thickness | 14 – 16 mils (356 – 406 microns) WFT per coat to yield 12 – 14 mils (279 – 305 microns) DFT without MR reinforcing layer. |
| Solids Content | 100% reactive |

SUBSTRATES & SURFACE PREPARATION

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| All | Substrates must be clean, dry and free of contaminants |
| Steel | <p>Immersion: SSPC-SP 5 White Metal Blast with a minimum angular profile of 3 mils.</p> <p>Non-immersion: SSPC-SP 6 Commercial Blast with a minimum angular profile of 3 mils. SSPC-SP 2 Hand Tool or SSPC-SP 3 Power Tool Cleaning are suitable for mild environments.</p> <p>Self-priming on steel.</p> |
| Concrete or Concrete Masonry Units (CMU) | 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 Surface Preparation of Concrete. Voids in concrete may require filling. Mortar joints should be cured a minimum of 15 days. Prime with Penntrowel™ Vinyl Ester Primer. |

MIXING & THINNING

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|-----------------|---|---------------------------|---------------------------|
| Ratio | 1 gallon Part A resin: 2 – 3 fl. oz. Part B hardener | | |
| Mixing | Mix Part A with a power mixer to combine the entire contents into a homogenous mixture. Add CHP Hardener to resin at a rate of 2-3 fl. oz. per gallon (1.5 to 2.25% by weight) and mix thoroughly using a power mixer. Do not thin. | | |
| Pot Life | 50°F (10°C) 60 minutes | 75°F (24°C) 40 minutes | 90°F (32°C) 25 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

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| Installation Conditions | Penncoat 331 Lining is formulated for ideal handling at 70°F (21°C). Use when surface, air and material temperatures are between 50°F (10°C) and 110°F (43°C) and substrate temperature is at least 5°F (3°C) above the dew point. |
| Airless Spray | 30:1 to 56:1 Pump Tip range 0.027 – 0.033 |
| Roller | Multiple coats may be required to achieve specified film thickness. |
| Brush | Multiple coats may be required to achieve specified film thickness. |
| Work Stoppages | Do not leave material in hoses, guns or spray equipment. Thoroughly flush all equipment with appropriate cleaner. Do not reseat mixed material. Continue work until all mixed material is consumed. Material that has begun to gel cannot be recovered by adding fresh material. |

CURE TIME & RECOAT WINDOW

| Substrate Temperature | Initial Set | Minimum Recoat | Maximum Recoat | Full Cure |
|------------------------------|--------------------|-----------------------|-----------------------|------------------|
| 50°F | 5 hours | 12 hours | 7 days | 48 hours |
| 75°F | 2 hours | 4.5 hours | 7 days | 24 hours |
| 90°F | 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 the coating may be walked on or handled without marring in order to avoid intercoat adhesion issues.

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.

PACKAGING & ESTIMATING

| Product | Code | Packaging |
|---------------------------------|----------------|---|
| Penncoat 331 Resin Gray | 19578 21921 | 4.5 gal (46 lb) pail 4 x 1 gal cans/case (41.3 lb) |
| Penncoat 331 Resin Red | 29635 29603 | 4.5 gal (47 lb) pail 4 x 1 gal cans/case (41.3 lb) |
| Penncoat 331 Resin Off White | 19577 23099 | 4.5 gal (47 lb) pail 4 x 1 gal cans/case (41.3 lb) |
| CHP Hardener | 19552 21922 | 11.2 fl. oz. (0.7 lb) bottle 1 gal (8.3 lb) can |
| 1.0-oz Chopped Strand Glass Mat | 19639 | 50-inch x 375-foot (1,500 square foot) roll |
| 1.5-oz Chopped Strand Glass Mat | 19640 | 50-inch x 264-foot (1,056 square foot) roll |

Theoretical Coverage

100 – 115 square feet per mixed gallon applied at 14 – 16 mils (356 – 406 microns) WFT per coat will yield 11 – 12 mils (279 – 305 microns) DFT. 2 coats required. Target is 23 mils (584 microns) DFT for 2 coats.

For Penncoat 331 MR Lining, allow 1 gallon of Pennrowel VE Primer per 50 square feet of Chopped Strand Glass Mat as saturant.

Storage & Shelf Life

Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 4 months when stored in a dry area at 70°F (21°C). Actual shelf life may vary with storage conditions. Storage at 40°F (4°C) will significantly extend shelf life.

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

TYPICAL PHYSICAL PROPERTIES

| Property | Typical Value |
|---|---|
| Wet density | |
| Gray | 10.3 lb per gallon |
| Red | 10.3 lb per gallon |
| Off White | 10.6 lb per gallon |
| Viscosity, mixed material | 2,000-5,000 cps at 75°F (24°C) |
| VOC content by weight | 0.12 lb/gal |
| Abrasion resistance, ASTM D4060 | 75 mg loss/1,000 cycles with 1,000-gram (CS-17) wheel |
| Moisture permeability, ASTM E96 | 0.0015 perm-inch |
| Maximum dry service temperature | 280°F (137°C) |
| Temperature limitations will vary with chemical service. Consult ErgonArmor Technical Service for guidance. | |

Rev. 04/2025

TERMS AND CONDITIONS OF SALE

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