

SELECTION & SPECIFICATION DATA

Type	Flake filled chlorendic polyester
Description	Penncoat 350 Lining is a flake filled chlorendic polyester lining system with excellent resistance to chromic and nitric acids, chlorine and oxidizing solutions. It incorporates a 1 oz. mat reinforcement into the primer layer to reduce crack transmission.
Features	<ul style="list-style-type: none"> • Resistant to chromic and nitric acids, chlorine and oxidizing solutions • Flake filled to reduce permeability • Chopped strand mat in the primer layer of Penncoat 350 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
Colors	Gray, Beige
Film Thickness	20 to 32 mils WFT recommended to yield 15 to 25 mils DFT, target of 18 mils DFT per coat. Use 2 coats when MR reinforcing layer is not used.
Solids Content	100% reactive

SUBSTRATES & SURFACE PREPARATION

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

Ratio	1 gallon Part A resin: 2-3 fluid ounces Part B hardener. Hardener dosage rate 1.5 to 2.25% by weight.		
Mixing	Power mix Part A to produce a homogenous mixture. Add measured quantity of MEKP Hardener to resin and power mix thoroughly. Thinning is not recommended without first consulting with ErgonArmor.		
Pot Life	50°F (10°C) 90 minutes	75°F (24°C) 60 minutes	90°F (32°C) 30 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 Conditions	Ideal material temperature during application is 70°F (21°C). Consult ErgonArmor for advice when temperatures are below 50°F (10°C) or above 80°F (27°C). Do not apply if humidity is above 90% or the surface temperature is less than 5°F above the dew point of the air in the work area.
Airless Spray	30:1 to 56:1 pump 0.027- to 0.033-inch tip
Brush & Roller	Brush: Clean, medium length, natural bristle brush Roller: Short to medium nap phenolic core roller 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 reseal 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 (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 surfaces exceed 95°F (35°C) or are exposed to direct sunlight, overcoat 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 & HANDLING

Product	Code	Packaging
Penncoat 350 Resin Gray	29681	4.0 gal (42 lb) in a 5-gal pail
Penncoat 350 Resin Beige	29680	4.0 gal (42 lb) in a 5-gal pail
MEKP Hardener Clear	29682	8.0 fl. oz. bottle
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 50 to 70 square feet per mixed gallon applied at 20 – 32 mils (508 – 813 microns) WFT per coat will yield 15 – 25 mils (381 – 635 microns) DFT. 2 coats required. Target is 18 mils (457 microns) DFT per coat.

For Penncoat 350 MR Lining, allow 1 gallon of Penntrowel Vinyl Ester 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 6 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	10.7 lb/gal (1.28 kg/L)
Viscosity, mixed material	3,750 ± 250 cps
VOC content by weight	0.12 lb/gal (14 g/L)
Abrasion resistance, ASTM D4060	80 mg loss per 1,000 cycles with 1,000-gram (CS-17) wheel
Maximum dry service temperature	350°F (177°C)

Temperature limitations will vary with chemical service. Consult ErgonArmor Technical Service for guidance.

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