

SELECTION & SPECIFICATION DATA

Type	Flake filled novolac vinyl ester lining
Description	Penncoat 340 Lining is a high build, flake filled novolac vinyl ester lining formulated for brush, roller or airless spray application.
Features	<ul style="list-style-type: none"> • Sag-resistant to 60 mils WFT per coat • Formulated for brush, roller, or airless spray application • Broad resistance to most acids, alkalis and aliphatic solvents • Resistant to chlorine dioxide with and without pulp in pulp bleaching processes • For steel or concrete corrosion protection • Suitable for chemical immersion or secondary containment service • Flake filled to enhance permeation resistance
Uses	<ul style="list-style-type: none"> • Tank linings • Steel structures • Concrete structures • Chemical resistant floor coating • Chemical splash and spill areas • Secondary containment lining • Corrosion barrier under urethane membrane and brick linings in pulp bleaching equipment
Finish	Gloss, Textured
Typical Thickness	60 to 80 mils (1524 - 2032 microns) WFT per coat to yield 54 - 72 mils (1372 - 1829 microns) DFT.
Solids Content	90%

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 Pentrowel™ Vinyl Ester Primer.

MIXING & THINNING

Ratio	1 gallon Part A resin : 2 fl. oz. Part B hardener. Increase dosage of hardener to 3 fl. oz. per gallon of resin to speed cure in cool conditions.
Mixing	Mix Part A with a power mixer at a slow speed to combine the entire contents into a uniform mixture. Add CHP Hardener to resin and mix slowly and 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 GUIDELINES

Installation Conditions	Penncoat 340 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. The temperature of concrete to be lined should be stable (indoors) or falling (outdoors) and shaded from direct sunlight to prevent blisters or pinholes due to outgassing.
Airless Spray	30:1 to 56:1 Pump Tip range 0.035 - 0.043
Brush & Roller	Multiple coats may be required to achieve specified film thickness. Brushing and rolling will leave an unsmooth surface.
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	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 surfaces are exposed to direct sunlight, overcoat as soon as coating may be walked on or handled without marring to avoid intercoat adhesion issues.

PACKAGING, ESTIMATING & HANDLING

PRODUCT	CODE	PACKAGING
PENNCOAT 340 Resin Gray	27078	4.5 gal (48 lb) in a 5-gal pail
CHP Hardener	19552 21922	11.2 fl. oz. (0.7 lb) bottle 1 gal (8.3 lb) can

Theoretical Coverage 24 - 50 square feet per mixed gallon applied at 30 - 60 mils (762 - 1524 microns) WFT per coat will yield 27 - 54 mils (686 - 1372 microns) DFT.

Storage & Shelf Life Maintain products in original packaging and sealed until ready for use. Estimated shelf life is 12 months for hardener and 6 months for resin when stored in a dry area at 70°F (21°C). Actual shelf life may vary with storage conditions. For maximum resin shelf life, store between 55°F (12°C) and 65°F (18°C).

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

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.

TYPICAL PHYSICAL PROPERTIES

PROPERTY	TYPICAL VALUE
Wet density	10.7 lb/gal (1.2 kg/l)
Viscosity, mixed material	14,000 cP at 75°F (24°C)
VOC content by weight	0.12 lb/gal (14 g/l)
Abrasion resistance, ASTM D4060	75 mg loss/1,000 cycles with 1,000-gram (CS-17) wheel
Maximum dry service temperature	280°F (137°C)
Temperature limitations will vary with chemical service. Consult ErgonArmor Technical Service for guidance.	

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