



Penncoat™ 332 Lining

SELECTION & SPECIFICATION DATA

Type	Graphite filled novolac vinyl ester lining
Description	Penncoat 332 is a 30 - 40 mil thick, graphite filled, novolac vinyl ester resin corrosion protection lining.
Color	Dark Gray
Uses	<ul style="list-style-type: none">• Topcoat for troweled polymer mortars and laminate systems in concrete trenches, sumps, and secondary containment areas.• Chemical resistant coating for floors subject to foot and light forklift traffic.• Tank lining• Steel structure coating.
Features	<ul style="list-style-type: none">• Outstanding chemical resistance.• Resists hydrofluoric acid, fluorosilicic acid, and hydrofluorosilicic acid.• Quick turn-around for service.
Limitations	<ul style="list-style-type: none">• May discolor in certain chemical exposure.• Graphite filler at coating surface may transfer onto other objects.

SUBSTRATES & SURFACE PREPARATION

All	Substrate must be clean, dry and free of contaminants including soluble salts. Prime with Penntrowel™ Vinyl Ester Primer.
Steel	Immersion: SSPC-SP 5/NACE No. 1, White Metal Blast Cleaning with jagged, angular profile 3.0 to 5.0 mils. Non-Immersion: SSPC-SP 6/NACE No. 3, Commercial Blast Cleaning with jagged, annular profile 3.0 to 5.0 mils.
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 prior to application.

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 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
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APPLICATION GUIDANCE

Installation Specification	CES-259 Installation Specification for Penncoat 331 and 340 Linings
Installation Conditions	Penncoat 332 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.
Brush	Brush application in small areas
Roller	Short nap or mohair phenolic core roller
Spray	30:1 to 56:1 Pump Tip range 0.036 - 0.045

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

Theoretical Coverage 79 ft² to 105 ft² (7.3 m² to 9.8 m²) yields 18 - 24 mils (457 - 610 microns) WFT per coat equivalent to 15 - 20 mils (381 - 508 microns) DFT per coat. Two (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). Warmer resin storage conditions will dramatically reduce shelf life. Store resin between 55°F (13°C) and 65°F (18°C) for maximum 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 Armor.

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
Color	Dark gray
Gloss	Not applicable
Density	10.1 lb/gallon (1.21 kg/L)
Solids content	100% reactive

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