



**Corrosion  
Engineering™**

AN ERGONARMOR COMPANY

**TECHNICAL INFORMATION**

**CES-144**

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## **CORROSION ENGINEERING SPECIFICATION FOR INSTALLATION**

### **PENNCOAT® 600 SHEET MEMBRANE**

#### **1. SURFACE PREPARATION**

##### **1.1 Steel:**

1.1.1 Steel surfaces should be abrasive blasted in accordance with Steel Structures Painting Council Specification SSPC-SP-10 with a nominal 2.5 mil profile.

##### **1.2 Concrete:**

1.2.1 Concrete surfaces should exhibit a minimum surface tensile bond strength of 200 psi when tested in accordance with ACI 503R-89 Appendix A.1. Mechanical methods such as abrasive blasting or scarifying are the preferred methods. Chemical methods such as acid etching and detergents should be utilized to remove latence, oil and grease or when mechanical methods cannot be utilized.

1.2.2 Applicable ASTM Standards for surface preparation are:  
D4258 - Practice for Surface Cleaning Concrete for Coating  
D4259 - Practice for Abrading Concrete  
D4260 - Practice for Etching Concrete  
D4261 - Practice for Surface Cleaning Concrete Unit Masonry for Coating  
D4262 - Test Method for pH of Chemically-Cleaned or Etched Concrete Surfaces  
D4263 - Test Method for Indicating Moisture in Concrete by the Plastic Sheet Method  
D4285 - Method for Indicating Oil or Water in Compressed Air

**2. PENNCOAT 600 PRIMER**

- 2.1 Do not attempt application if substrate temperature is within 5°F of dew point, if relative humidity is greater than 95%, or below temperatures of 40°F.
- 2.2 Application
  - 2.2.1 Mixing: Stir PENNCOAT 601 Primer thoroughly prior to application. Do not thin. Observe all safety guidelines as outlined on product labels and MSDS sheets.
  - 2.2.2 Application: PENNCOAT 601 Primer should be applied with a stiff brush or roller, and worked into the surface with a strong scrubbing action so as to thoroughly wet into and penetrate the concrete surface. Excess primer should be removed from the surface. Do not allow puddling.
  - 2.2.3 Allow primer to dry to touch before proceeding with installation of PENNCOAT 600 Sheet Membrane. Any area that have dried beyond 24 hours should be re-primed. A tack free state should be reached in 60 minutes at 70°F.

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**3. PENNCOAT 600 SHEET MEMBRANE APPLICATION**

- 3.1 PENNCOAT 600 Sheet Membrane is ready for application onto primed surface with no special additional preparation.
- 3.2 Apply PENNCOAT 600 Sheet Membrane onto primed surface, peeling back release film from back side of sheet membrane as work progresses.
- 3.3 Press PENNCOAT 600 Sheet Membrane tight into primer by use of even firm force applied with hard rollers. Remove any entrapped air bubbles as work progresses.
- 3.4 Precutting and dry fitting of membrane into smaller sizes is recommended for pump pads, changes of direction, and any areas where tight or confining space limits access.
- 3.5 PENNCOAT 600 Sheet Membrane has a 3" wide specially designed leading

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edge to allow sheet edges to be evenly aligned and butted together. After fitting sheet seams together, apply low temperature “yellow” heat (not higher temperature blue flame) from a an open flame source such as a propane torch. Carefully melt seams together so as to create a seamless joint.

- 3.6 All melted seams shall then be further treated by an application of PENNCOAT 602 pressure sensitive seam tape, which is firmly pressed into the hot membrane, and rolled smooth.

**4. CURE TIME**

- 4.1 PENNCOAT 600 membrane is ready for application immediately after application of seam tape, and cooling of seams.

**5. CLEAN-UP**

- 5.1 Rollers and other tools should be cleaned immediately after use. Solvents recommended for clean-up are methyl ethyl ketone or lacquer thinner. When using these materials read and follow the supplier's material safety data sheets.

**6. STORAGE AND SHELF LIFE**

- 6.1 PENNCOAT 600 membrane components should be stored in a cool, dry, area and out of direct sunlight. PENNCOAT 600 sheet membrane and 602 tape has an indefinite shelf life PENNCOAT 601 Primer should be checked for suitability before using after 1 year.

**7. SAFETY PRECAUTIONS AND DISCLAIMER**

- 7.1 PENNCOAT 600 Membrane, 601 Primer, and 602 tape present a number of hazards. Read before using and follow the hazard information, precautions, and first aid directions on the individual product labels and Material Safety Data Sheets.
- 7.2 The statements, technical information and recommendations contained herein are believed to be accurate as of the date hereof. Since the conditions and methods of use of the product and of the information referred to herein are beyond our control, corrosion engineering expressly disclaims any and all liability as to any results obtained or arising from any use of the product or reliance on such information; NO WARRANTY OF FITNESS FOR ANY PARTICULAR PURPOSE, WARRANTY OF MERCHANTABILITY OR ANY OTHER WARRANTY, EXPRESS OR IMPLIED, IS MADE

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- 7.3 Please contact Corrosion Engineering for specific recommendations at +1-610-833-4000 or fax +1-610-833-3040.

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