



**Corrosion
Engineering™**

AN ERGONARMOR COMPANY

TECHNICAL INFORMATION

CES-294

04/00 SUPERSEDES 08/98

CORROSION ENGINEERING SPECIFICATION FOR INSTALLATION

PENNTROWEL® 250 SB AND SBR FLOORING SYSTEMS

NOTE: PENNTROWEL 250 SB and SBR is a sophisticated lining system and should only be installed by industrial contractors familiar with industrial lining practices.

1. SURFACE PREPARATION

- 1.1 Concrete surfaces onto which PENNTROWEL SB or SBR system is to be installed shall be prepared in accordance with the latest edition of ASTM C811 - "Standard Practice for Surface Preparation of Concrete for Application of Chemical-Resistant Resin Monolithic Surfacing".

2. APPLICATION

- 2.1 Mix PENNTROWEL Epoxy Primer as per labels on the containers and apply to the prepared concrete substrate with a stiff brush. If a roller is used, hard pressure must be exerted on the roller to ensure the surface is well wetted. Do not leave excess primer on the surface.
- 2.2 For PENNTROWEL SBR system only, proceed by laying 1 oz. chopped strand glass mat into wet primer applied in 2.1 above, being sure to smooth out all wrinkles as work proceeds. Wet the cloth out thoroughly by flooding cloth with catalyzed PENNTROWEL Resin/Hardener, insuring no dry spots remain. After the primer coat or primer coat with mat reinforcement has cured dry to touch proceed with Step 2.3. Do not allow more than 48 hours after hardening of primer before proceeding with step 2.3.
- 2.3 PENNTROWEL 250 Resin and Hardener shall be combined in recommended ratio in a clean, dry container and mixed thoroughly. Add TUFCEM® Grout Filler as per mix ratios specified on product data sheet CE-294 until a homogeneous and uniform colored mixture is reached. This

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should be reached after 1 - 2 minutes of mixing. (A mechanical mixer where the mixing container rotates at a constant slow speed of 30 - 60 rpm, while a stationary mixing blade that provides both radial and axial action, and scrapes the sides and bottom of the pail, has been found very suitable for batch mixing of the slurry.)

- 2.4 While mixing, slowly add the recommended quantity of aggregate Filler. The mixed slurry should be a uniform consistency, free from lumps, with as little air entrained as possible.
- 2.5 Never add water, Portland cement, solvents, or any other adulterants to the mix.
- 2.6 Pour the mixed slurry onto the primed concrete and use a pin (gauge) rake, steel trowel or float, to spread the wet mixture to the specified thickness.
- 2.7 Using a spiked (porcupine) roller or a loop roller, lightly roll the surface to remove any trowel marks or other surface imperfections.
- 2.8 Within 10 - 15 minutes after completing Step 2.7, uniformly broadcast to excess "Flint Silica No. 12" onto the wet surface.
- 2.9 Upon hardening, any unbonded aggregate is to be removed by sweeping.
- 2.10 Top coat the slurry with a mixture of the PENNTROWEL 250 Resin and Hardener, and roll onto the surface.
- 2.11 The applied PENNTROWEL 250 SB/SBR Flooring System should be protected for a minimum of 24 hours at 70°F.
- 2.12 Where expansion/contraction joints, control joints, construction joints, isolation joints or cracks exist in the concrete substrate, contact Corrosion Engineering for details on how to best handle.

3. SAFETY PRECAUTIONS AND DISCLAIMER

- 3.1 PENNTROWEL 250 Resin, Hardener, TUFCEM® Grout Filler, and PENNTROWEL Epoxy Primer components and mixes of them 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.
- 3.2 The statements, technical information and recommendations contained

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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 CONCERNING THE GOODS DESCRIBED OR THE INFORMATION PROVIDED HEREIN. The information provided herein relates only to the specific product designated and may not be applicable when such product is used in combination with other materials or in any process. The user should thoroughly test any application before installation. Nothing contained herein should be taken as an inducement to infringe any patent and the user is advised to take appropriate steps to be assured that any proposed use of the product will not result in patent infringement.

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

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