



VersaFlex Incorporated
 686 S. Adams Street
 Kansas City, KS 66105
 (913) 321-9000
 (913) 321-1490 (fax)

Material Processing & Handling Information

Material: VF 380-F Elastomeric Polyurea

Material Type: Fast Set Spray Polyurea Coating

Application: Concrete, Tile, CMU, Geotextile, Wood and other porous substrates

Application Process: High pressure heated equipment with impingement gun

Process Equipment:	Pumps	Dispensing Gun
Graco:	EXP-1 (Electric) EXP-2 (Electric) EXP-3 (Pneumatic) H-XP2 (Hydraulic) H-XP3 (Hydraulic)	Fusion AP (Air Purge) Fusion MP (Mechanical Purge) GX-7 Standard (Mechanical Purge) GX-8 (Mechanical Purge) Probler (Air Purge) Probler P2 (Air Purge)
Gusmer:	FF 2500 (Hydraulic) FF 3500 (Hydraulic) H-20/35 (Pro Hydraulic)	GX-7 Standard (Mechanical Purge) GX-7 400 (Mechanical Purge) GX-7 DI (Mechanical Purge) GX-8 (Mechanical Purge) GAP Pro (Air Purge)
GlasCraft:	MX, MXII (Pneumatic) MH, MHII, MHIII (Hydraulic) SuperMaxi, Guardian A Series	Probler (Air Purge) Probler P2 (Air Purge)
Gama:	Evolution G-250H	GDI (Mechanical)
PMC:	PMC GH-40 (Hydraulic)	PMC A-P2 (Air Purge)
Pentech USA:		PalmGun or MG Gun (low output)
WIWA:	DuoMix 460 (Pneumatic)	Pentech MG (Mechanical)
Material Supply Pumps:	<u>Pump Type</u>	<u>Continuous delivery/output at 70°F/25°C</u>
Graco:	Standard 2:1 (T1) Diaphragm:	Up to 1.75 gpm, 9.5 lpm
	• Husky 515	Up to 5 gpm, 26 lpm
	• Husky 716	Up to 11 gpm, 61 lpm
IPM/Gusmer 2:1 (T2)		Up to 3.85 gpm, 21 lpm
IR/ARO (2:1)	(for fluids <1000 cps)	Up to 1.4 gpm, 7.6 lpm
Gama:		Master Gun (Air Purge)
Process Temperature:	150° F (optimum) to 160 ° F (max.)	
Process Pressure:	2,000 - 2,500 psi optimum (1,700 psi min, 3,500 psi max.)	
Gel Time:	7 - 12 seconds	
Tack Free:	60 – 100 seconds	

Light Traffic: 60 - 120 minutes

Moisture Content: Calcium chloride test: 3 lb./24 hr./1,000 ft²
Concrete: 5% maximum as per ASTM F2170 & ASTM F2420

Application Temperature: -40°F and higher

VF 380-F will cure at sub-freezing temperatures, but the effects from these conditions may impact the application in a variety of ways. It is recommended that material and equipment ambient temperatures be kept at 60°F or above. Frozen concrete substrates with high moisture content will affect coating adhesion and long-term performance.

Dew Point: Substrate temperature must be 5°F above dew point and rising before application of coating materials.

Surface Prep: Abrasive blast per ICRI Technical Guideline No. 310.2R-2013 or SSPC SP13. Achieve a concrete surface profile of ICRI CSP-3 to CSP-5.

Surface contaminants: Check for soluble salts on surfaces to be coated. Test with Chlor*Test. If amount of soluble salts exceeds recommended limits, treat with Chlor*Rid. Repeat process until acceptable limits are reached.
Maximum amounts of soluble salts (micrograms per square centimeter):
Chlorides - 3 immersion, 7 non-immersion
Nitrates - 5 immersion, 10 non-immersion
Sulfates - 10 immersion, 20 non-immersion

Substrate Parging: Formed walls with honeycombing, or voids/imperfections of concrete surfaces shall be repaired prior to coating.

Surface Primer: Concrete & other porous substrates: **VersaFlex** VF 15 or VF 20 (6 to 10 wet mils): Two-component sealer and primer. Follow recoat window on each: after which a light recoat is required (2 to 4 wet mils).

Steel only, if required: **VersaFlex** PW-1 (2 to 3 wet mils): Single component primer. Maximum overcoat time: 24 hours, after which a light recoat is required (1 to 2 wet mils).

Adhesion Testing: Adhesion to concrete: Minimum 150 psi. Cohesive failure of concrete is optimum. Pull values will vary depending on concrete strength.

Coating Application: **VF 380-F** can offer extended recoat windows depending on application/environment. Consult **VersaFlex** for details.

Coating thickness will vary depending on intended use, surface roughness and profile. The International Concrete Repair Institute (ICRI) has developed a standard for Concrete Surface Profile (CSP) ranging between 1 (smoothest) and 9 (Roughest).

The following chart gives approximate minimum coating thickness to achieve a continuous coating using the ICRI CSP standard.

CSP-1 & CSP-2	45 – 55 mils
CSP-3	55 - 60 mils
CSP-4	60 – 65 mils
CSP-5	65 – 70 mils
CSP-6	70 – 75 mils
CSP-7	75 – 80 mils
CSP-8	80 - 85 mils
CSP-9	85 – 90 mils

**** Please consult the VersaFlex Spray Gun Configuration Recommendation PDF for specific modules and tips.**

	Storage Temp	Storage	Special Handling
'A' Side	60°F min.	Keep dry. Keep from freezing. Store in covered temperature controlled environment if possible.	Use dry air desiccant for intake vent on drum.
'B' Side	60°F min.	Keep dry. Keep from freezing. Store in covered temperature controlled environment if possible.	Mix well with mixer to re-disperse any settled pigment.
<p>Safety: Please consult product MSDS for full details. Safety glasses, rubber gloves, protective clothing, organic vapor or fresh air respirator.</p>			