



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

Material Processing & Handling Information

Material: GELFLEX® 1115
Material Type: Fast Set Spray Polyurea Coating
Application: Various Substrates
Application Process: High pressure heated equipment with impingement purge gun

Process Equipment:	Pumps	Dispensing Gun
	Graco: EXP-2 (Electric) EXP-3 (Pneumatic) H-XP2 (Hydraulic) H-XP3 (Hydraulic) E10-HP (Electric)	Probler P2: (Air Purge) - Tip - 0.021" - 0.031" orifice, Mix Chamber – AA, Mix Chamber Insert - AA Fusion AP: Tip 0.021" – 0.031", Mix Chamber-AW 2222 Fusion MP: Tip FTM 624 or 424, Chamber XF 1818
	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), low output only: Module 295338, Tip-297841 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), PCD Round Pattern 0.024
	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)	Up to 1.75 gpm, 9.5 lpm
	Diaphragm:	
	• 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
Process Temperature:	150° F optimum (110°F min., 160°F max)	

Process Pressure:	2,500 psi optimum (2,000 – 3,000)		
Gel Time:	~2 minutes		
Tack Free:	~8 minutes		
Light Traffic:	1 hour		
Moisture Content:	Calcium Chloride test: 3 lb./24 hr./1,000 ft ² Concrete: 5% maximum as per ASTM F2170 & F2420		
Application Temperature:	20°F and higher Note that GELFLEX 1115 will cure at sub-freezing temperatures, but the effects may impact the application in a variety of ways. It is recommended that material and equipment ambient temperatures be kept at 50°F and above.		
Dew Point:	Substrate temperature must be 5°F above dew point and rising before application of coating materials.		
Surface Prep:	Minimum acceptable preparation levels for proper adhesion are SSPC-SP 6. Generally used with an aromatic basecoat. Concrete – CSP of 3 to 5. Metal – 3 to 5 mil profile (SSPC SP 10). Fiberglass/plastic – 2 to 3 mil profile.		
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		
Surface Primer:	Substrate Dependent: May apply VersaFlex VF15 or VF20 (5 to 6 wet mils): Two-component primer as required. Consult VersaFlex .		
Adhesion Testing:	600 psi on resurfaced fiberglass.		
Coating Application:	Single coat application to desired thickness. Smaller plural component spray equipment units may be used to process GELFLEX other than those listed above; however following the recommendations regarding spray gun and tip is recommended for best results.		
Place Back to Service:	Dry exposure, minimum of 4 hours. Wet exposure (immersion), minimum of 48 hours		
	Storage Temp.	Storage	Special Handling
'A' Side	45°F min. 95°F	Keep dry. Keep from freezing. Store in covered temperature controlled environment if possible.	Use dry air desiccant for intake vent on drum.
'B' Side	45°F min. 95°F	Keep dry. Keep from freezing. Store in covered temperature controlled environment if possible.	Mix well with mixer to re-disperse any settled pigment.
	Safety:	Please consult product SDS for full details. Safety glasses, rubber gloves, protective clothing, organic vapor or fresh air respirator.	