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## Material Processing & Handling Information

Material:	PW-1	
Material Type:	Primer	
Application:	Steel/Metal Surfaces	
Application Process:	Airless or Pump Spray, Roll or Brush	
Process Equipment:	Pump D	Dispensing Gun
Graco:	Ultra 395 Airless Sprayer (or C similar)	ontractor Gun (or similar)
Process Temperature:	Ambient	
Process Pressure:	500 to 1,000 psi	
Hand Process:	1/4" or 3/8" nap roller or bristle brush (small areas only)	
Application Temperature:	35°F and higher. Cure times will be longer in colder temperatures.	
Dew Point:	Substrate temperature must be 5°F above dew point and rising before application of coating materials.	
Surface Prep:	<b>Steel:</b> Minimum acceptable preparation levels for proper adhesion are SSPC SP 6.	
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	
Adhesion Testing:	Adhesion to steel: Minimum 500 psi.	
Application:	Apply in one coat using spray, roller or brush. Avoid ponding of material on horizontal surfaces. Excess materials should be wiped dry with a clean cotton rag.	
Application Rates:	<b>Steel:</b> Apply at rate of 400-500 square feet per gallon. Maximum overcoat time: 24 hours, after which a light recoat is required (1 to 2 wet mils).	
Storage Temperature	Storage	Special Handling
50°F minimum 70°F optimum	Keep dry. Keep from freezing. in covered temperature contro environment if possible.	Store Keep containers closed and protected from atmospheric contamination.