



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

Material Processing & Handling Information

Material: SacriShield™

Material Type: Fast Set Spray Polyurea Strippable/Sacrificial Coating

Application: Plastic, Fiberglass, Porcelain and other non-porous substrates

Application Process: High pressure heated equipment with impingement gun

Process Equipment:	Pumps	Dispensing Gun
Graco:	EXP-1 (Electric) EXP-2 (Electric) 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)	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°-160° F optimum (140°F min., 170°F max.)	
Process Pressure:	2,000-2,500 psi optimum (1,700 psi min., 3,000 psi max.)	

Gel Time:	10-12 seconds		
Tack Free:	25-30 seconds		
Full Cure:	7 days		
Application Temperature:	-40°F and higher Note that SacriShield 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 60°F or above.		
Dew Point:	Substrate temperature must be 5°F above dew point and rising before application of coating materials.		
Coating Application:	<i>** Please review the Spray Gun Configuration Recommendation PDF for specific modules and tips.</i>		
	Storage Temp	Storage	Special Handling
'A' Side	60°F min. 70°F optimum	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. 70°F optimum	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 MSDS for full details. Safety glasses, rubber gloves, protective clothing, organic vapor or fresh air respirator.		