



PolyVers International  
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## **Material Processing & Handling Information**

**Material:** PV 320

**Material Type:** Fast Set Spray Polyurea Coating

**Application:** Metal substrates

**Application Process:** High pressure heated equipment with impingement gun

Process Equipment:	Pumps	Dispensing Gun
<b>Graco:</b>	EXP-1 (Electric) EXP-2 (Electric) EXP-3 (Pneumatic) H-XP2 (Hydraulic) H-XP3 (Hydraulic) H-VR (Hydraulic)	Fusion AP (Air Purge) Fusion MP (Mechanical Purge)
<b>Gusmer:</b>	FF 2500 (Hydraulic) FF 3500 (Hydraulic) H-20/35 (Pro Hydraulic)	GX-7 400 (Mechanical Purge) GX-7 DI (Mechanical Purge) GAP Pro (Air Purge)
<b>GlasCraft</b>	MX, MXII (Pneumatic) MH, MHII, MHIII (Hydraulic)	Probler (Air Purge)
<b>Process Temperature:</b>	77°C (170°F) optimum (66°C min, 88°C max)-(150°F min, 190°F max)	
<b>Process Pressure:</b>	2,000 - 2,500 psi optimum (1,700 psi min, 3,500 psi max)	
<b>Gel Time:</b>	10 seconds	
<b>Tack Free:</b>	15 seconds	
<b>Moisture Content:</b>	Visibly dry	
<b>Application Temperature:</b>	<p>-29°C (-20°F) and higher.</p> <p>Note that <b>PV 320</b> will cure at these temperatures, but the effects from these conditions will impact the application in a variety of ways. It is recommended that material and equipment ambient temperatures be kept at 10°C (50°F) or above. Frozen concrete substrates with high moisture content will affect coating adhesion and long-term performance.</p>	
<b>Dew Point:</b>	Substrate temperature must be -15°C (5°F) above dew point and rising before application of coating materials.	
<b>Surface Prep:</b>	Minimum acceptable preparation levels for proper adhesion are SSPC SP 6.	

<b>Surface contaminates:</b>	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 Sulphates            10 immersion, 20 non-immersion
<b>Substrate Parging:</b>	Formed walls with honeycombing or concrete surfaces with large exposed aggregate. Recommended that the surface is rubbed or parged to eliminate surface defects. Use Five Star Structural Concrete.
<b>Surface Primer:</b>	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).
<b>Adhesion Testing:</b>	Light service:    500 psi Heavy service:   750 psi
<b>Coating Application:</b>	Coating thickness will vary by substrate profile and intended use. Consult VersaFlex Incorporated for specific information.

	<b>Storage Temp</b>	<b>Storage</b>	<b>Special Handling</b>
<b>A Side</b>	10°C (50°F) min 21°C (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>B Side</b>	10°C (50°F) min 21°C (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.

<b>Safety:</b>	Please consult product MSDS for full details.  Safety glasses, Rubber gloves, Protective clothing, Organic vapor or fresh air respirator.
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