



Canadian Induracoat Corporation
 Vancouver - Calgary - Victoria
 Toll Free: 1.855.652.0812
 www.induracoat.com

Material Processing & Handling Information

Material: FSS 45DC-F
Material Type: Fast Set Spray Polyurea Coating
Application: Concrete, Tile, CMU Block, 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) 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: | | Master Gun (Air Purge) |
| Process Temperature: | 170° F optimum (150°F min, 190°F max) | |
| Process Pressure: | 2,000 - 2,500 psi optimum (1,700 psi min, 3,500 psi max) | |
| Gel Time: | 5 seconds | |
| Tack Free: | 12-15 seconds | |
| Light Traffic: | 60 minutes | |
| Full Cure: | 7 days | |
| Moisture Content: | Calcium chloride test: 3 lb/24 hr/1,000 ft ² Tramex concrete moisture meter: 5% maximum | |
| Application Temperature: | -40°F and higher. Note that FSS 45DC-F 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 55°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. | |

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| Surface Prep: | Abrasive blast per ICRI Technical Guideline No. 03732 or SSPC SP13. Achieve a concrete surface profile of ICRI CSP-3 to CSP-5. | | | | | | | | | | | | | | | | | | |
| Surface contaminates: | 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 concrete surfaces with large exposed aggregate. Recommended that the surface is rubbed or parged to eliminate surface defects. Use Five Star Structural Concrete. | | | | | | | | | | | | | | | | | | |
| Surface Primer: | <p>VersaFlex Quick Mender (8 to 10 wet mils): Two-component sealer and primer. Maximum overcoat time: 24 hours, after which a light recoat is required (2 to 4 wet mils).</p> <p>VersaFlex VF 20 (8 to 10 wet mils): Two-component primer. Maximum overcoat time: 72 hours, after which a light recoat is required.</p> | | | | | | | | | | | | | | | | | | |
| Adhesion Testing: | Adhesion to concrete: Minimum 150 psi. Cohesive failure of concrete is optimum. Pull values will vary depending on concrete strength. | | | | | | | | | | | | | | | | | | |
| Coating Application: | <p>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).</p> <p>The following chart gives approximate minimum coating thickness to achieve a continuous coating using the ICRI CSP standard.</p> <table border="1"> <tr><td>CSP-1 & CSP-2</td><td>45 – 55 mils</td></tr> <tr><td>CSP-3</td><td>55 - 60 mils</td></tr> <tr><td>CSP-4</td><td>60 – 65 mils</td></tr> <tr><td>CSP-5</td><td>65 – 70 mils</td></tr> <tr><td>CSP-6</td><td>70 – 75 mils</td></tr> <tr><td>CSP-7</td><td>75 – 80 mils</td></tr> <tr><td>CSP-8</td><td>80 - 85 mils</td></tr> <tr><td>CSP-9</td><td>85 – 90 mils</td></tr> </table> <p>** Please review the VersaFlex Spray Gun Configuration Recommendation PDF for specific modules and tips.</p> | | | 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 |
| 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 | | | | | | | | | | | | | | | | | | |
| | Storage Temp | Storage | Special Handling | | | | | | | | | | | | | | | | |
| 'A' Side | 50°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 | 50°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. | | | | | | | | | | | | | | | | | |

