



CORTEC
CORPORATION

Environmentally Safe VpCI®/MCI® Technologies

VpCI®-391 Water Based Temporary Coating

DESCRIPTION

VpCI®-391 is a fast drying, water-based temporary coating that provides protection in harsh, outdoor, unsheltered applications. Provides multi-metal protection. Excellent UV resistance. Can be matched to some custom colors. Provides a non-tacky film. Use of VpCI®-391 on weld joints does not negatively impact weld geometry or mechanical properties of the weld. It can be used to keep surfaces corrosion-free prior to welding.

PACKAGING & STORAGE

VpCI®-391 is available in 5 gallon (19 liter) pails, 55 gallon (208 liter) metal drums, liquid totes, and bulk. Keep product from freezing. Product shelf life is 1 year.



CHARACTERISTICS/TECHNICAL DATA

Volume Solids	34.40%
Gloss (ASTM D532)	NA
VOCs (ASTM D3960)	0.4 lbs/gal (48 g/l)
Viscosity	1,000-5,000 Centipoise
Pencil Hardness (ASTM D3363)	NA
Spreading Rate	551 sq.ft/gal @ 1.0 mils DFT (13.5 sq.m/l @ 25 µm)
Weight per Gallon	8.32 lbs/gal (1.00 kg/l)
Flash Point	212°F (100°C)
Recommended DFT	1.0-3.0 mils (25-75 µm)
Recommended WFT	2.9-8.75 mils (74-219 µm)
Dry to Touch	30-60 min
Dry to Handle	1-2 hrs
Recoat Time	NA
Force Dry	15-20 min @ 150°F (65°C)
Full Cure	3-7 days
Salt Spray (ASTM B117)	250 hrs
Humidity (ASTM D1748)	1400 hrs
Adhesion (ASTM D3359)	NA
Flexibility (ASTM D522)	1/2" mandrel (1.27cm)

*All tests performed after a 7 day cure at ambient temperature

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APPLICATION

Surface Preparation

Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, rust inhibitors, or any other surface contamination that could affect adhesion. For structural steel applications, Cortec® recommends a minimum of a NACE #3/SSPC-SP6 commercial blast clean. Consult Cortec® and/or test system adhesion prior to full scale application.

Note: Make sure dew point is more than 5°F (2°C) less than air temperature for application. Power agitate to a uniform consistency using a "squirrel cage" type mixer, hand-held drill mixer, or other equivalent method. VpCI®-391 can be applied by spray, roll, brush, or dip.

Typical Equipment Setups

HVLP / Conventional Spray

- Tip .009"-.021" *dependent upon pressures and viscosity
- Air Pressure 45-55 psi
- Fluid Pressure 10 psi
- Fluid hose should be 3/8" (0.95 cm) I.D. with a maximum length of 50 feet (15.2 m). Pot should always have dual regulation and be kept at same elevation as spray gun.

Air Assisted Airless / Airless

- Tip .015"-.035" *dependent upon pressures and viscosity
- Pressure 1800-2500 psi
- Hose should be 3/8" (0.95 cm) I.D. minimum, but a 1/4" (0.64 cm) I.D. whip end section may be used for ease of application. A maximum length of 100 feet (30.5 m) is suggested.

Cleanup

Clean tools/equipment immediately after use with water when coating is still wet. When dry, use Butyl Cellusolve or MIBK. Follow mfg's safety recommendations when using any solvent.

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