



**CORTEC**  
CORPORATION

Environmentally Safe VpCI®/MCI® Technologies

## CorShield® VpCI®-368 HB Open Atmosphere Temporary Coating

### DESCRIPTION

CorShield® VpCI®-368 HB is a fast drying, solvent-based temporary coating that provides protection in harsh, outdoor, unsheltered applications yet is easily removed with alkaline cleaners such as VpCI®-414. Provides multi-metal protection. Can be matched to some custom colors.

Commercial equivalent to MIL – PRF – 16173E (Grades 1 & 2); NATO 6850-66-132-5848, 6099; NSN 8030-00-062-6950, 231-2345, 244-1300, 470-2601.

### PACKAGING & STORAGE

CorShield® VpCI®-368 HB is available in 5 gallon (19 L) pails, 55 gallon (208 L) metal drums, liquid totes, and bulk.

To ensure best product performance, store in original packaging, indoors, and out of direct sunlight at 40-100 °F (4-38 °C).

Shelf life: 2 years



### CHARACTERISTICS/TECHNICAL DATA

|                              |  |
|------------------------------|--|
| Volume Solids                | 52.30%   |
| Gloss (ASTM D532)            | NA   |
| VOCs (ASTM D3960)            | 2.9 lbs/gal (347 g/L)                                  |
| Viscosity                    | 68 sec+ Zahn#3   |
| Pencil Hardness (ASTM D3363) | NA   |
| Spreading Rate               | 838 sq.ft./gal @ 1.0 mils DFT<br>(20.5 sq.m/L @ 25 µm) |
| Weight per Gallon            | 7.63 lbs/gal (0.91 kg/L)                               |
| Flash Point                  | 158 °F (70 °C)   |
| Recommended DFT              | 2.0-3.0 mils (50-75 µm)                                |
| Recommended WFT              | 4.0-6.0 mils (100-150 µm)                              |
| Dry to Touch                 | 30 min   |
| Dry to Handle                | 60 min   |
| Recoat Time                  | NA   |
| Force Dry                    | 15-20 min @ 150 °F (65 °C)                             |
| Full Cure                    | 3-7 days   |
| Salt Spray (ASTM B117)       | 1500 hrs   |
| Humidity (ASTM D1748)        | 2500 hrs   |
| Adhesion (ASTM D3359)        | NA   |
| Flexibility (ASTM D522)      | ½" mandrel (1.27 cm)                                   |

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## APPLICATION

### Surface Preparation

Substrate should be free of grease, oil, dirt, fingerprints, drawing compounds, rust inhibitors (except Cortec® approved), or any other surface contamination that could affect adhesion. For production line applications, use VpCI®-440 or similar phosphatizing pre-treatment. Cortec® recommends a minimum of a SSPC-SP1 over painted surfaces. For bare metal applications, Cortec® recommends a minimum of a NACE #3/ SSPC-SP6 commercial blast clean. Consult Cortec® Technical Service and/or test system adhesion prior to full scale application.

Power agitate to a uniform consistency using a “squirrel cage” type mixer, hand-held drill mixer, or other equivalent method. CorShield® VpCI®-368 HB can be applied by spray, roll, brush, or dip.

### Typical Equipment Setups

#### HVLP / Conventional Spray

- Tip 0.02”-0.11 (0.5-2.8 mm)\* 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). 1/4” (0.64 cm) I.D. fluid hose can be used but pressures may need to be adjusted. Pot should always have dual regulation and be kept at same elevation as spray gun.

#### Air Assisted Airless / Airless

- Tip 0.015”-0.035” (0.38-0.89mm)\* 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.

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

## Cleanup

Clean tools/equipment immediately after use with butyl acetate when paint is still wet. When dry, use butyl cellulose or MEK. Follow mfg’s safety recommendations when using any solvent.

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### LIMITED WARRANTY

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Cortec® Corporation warrants Cortec® products will be free from defects when shipped to customer. Cortec® Corporation's obligation under this warranty shall be limited to replacement of product that proves to be defective. To obtain replacement product under this warranty, the customer must notify Cortec® Corporation of the claimed defect within six months after shipment of product to customer. All freight charges for replacement products shall be paid by customer.

Cortec® Corporation shall have no liability for any injury, loss or damage arising out of the use of or the inability to use the products.

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