VpCI®-368M Solvent Based Temporary Coating

DESCRIPTION
VpCI®-368M 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.

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

PACKAGING & STORAGE
VpCI®-368M is available in 5 gallon (19 liter) pails, 55 gallon (208 liter) metal drums, liquid totes, and bulk.

Product shelf life is 1 year.

CHARACTERISTICS/TECHNICAL DATA

<table>
<thead>
<tr>
<th>Characteristic</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Volume Solids</td>
<td>52.30%</td>
</tr>
<tr>
<td>Gloss (ASTM D532)</td>
<td>NA</td>
</tr>
<tr>
<td>VOCs (ASTM D2369)</td>
<td>2.9 lbs/gal (347 g/l)</td>
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<tr>
<td>Viscosity</td>
<td>60-70 sec+ Zahn#3</td>
</tr>
<tr>
<td>Pencil Hardness (ASTM D3363)</td>
<td>NA</td>
</tr>
<tr>
<td>Spreading Rate</td>
<td>838 sq.ft./gal @ 1.0 mils DFT (20.5 sq.m/l @ 25 μm)</td>
</tr>
<tr>
<td>Weight per Gallon</td>
<td>7.63 lbs/gal (0.91 kg/l)</td>
</tr>
<tr>
<td>Flash Point</td>
<td>158°F (70°C)</td>
</tr>
<tr>
<td>Recommended DFT</td>
<td>2.0-3.0 mils (50-75 μm)</td>
</tr>
<tr>
<td>Recommended WFT</td>
<td>4.0-6.0 mils (100-150 μm)</td>
</tr>
<tr>
<td>Dry to Touch</td>
<td>30 min</td>
</tr>
<tr>
<td>Dry to Handle</td>
<td>60 min</td>
</tr>
<tr>
<td>Recoat Time</td>
<td>NA</td>
</tr>
<tr>
<td>Force Dry</td>
<td>15-20 min @ 150°F (65°C)</td>
</tr>
<tr>
<td>Full Cure</td>
<td>3-7 days</td>
</tr>
<tr>
<td>Salt Spray (ASTM B117)</td>
<td>1500 hrs</td>
</tr>
<tr>
<td>Humidity (ASTM D1748)</td>
<td>2500 hrs</td>
</tr>
<tr>
<td>Adhesion (ASTM D3359)</td>
<td>NA</td>
</tr>
<tr>
<td>Flexibility (ASTM D522)</td>
<td>1/2&quot; mandrel (1.27 cm)</td>
</tr>
</tbody>
</table>

*All tests performed after a 7 day cure at ambient temperature
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® Technical Services 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. VpCI®-368M 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 ¼” (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 Butyl Acetate when coating is still wet. When dry, use Butyl Cellusolve or MEK. Follow mfg’s safety recommendations when using any solvent.