

VpCI®-384 Solvent Based Urethane Topcoat

DESCRIPTION

VpCI®-384 is a solvent-based 2K urethane one coat system (topcoat) that provides protection in harsh, outdoor, unsheltered applications. The complex mixture of non-toxic, organic inhibitors offers protection that competes with most paints and zinc-rich primers. Provides multi-metal protection. Excellent UV resistance. Can be matched to most custom colors.

PACKAGING & STORAGE

VpCI®-384 is available in 4 gallon (15.1 liter) kits, 3 gallons Part A, 1 gallon Part B.

Product shelf life is 1 year.



CHARACTERISTICS/TECHNICAL DATA

Volume Solids	50 - 55%
Gloss (ASTM D532)	85+
VOCs (ASTM D3960)	3.5 lbs/gal (419 g/l)
Viscosity	70-75 Ku
Pencil Hardness (ASTM D3363)	H-2H
Spreading Rate	816 sq.ft/gal @ 1.0 mils DFT (mixed) (20 sq.m/l @ 25 um)
Weight per Gallon	9.33 lbs/gal (1.12 kg/l)
Flash Point	72°F (22°C)
Recommended DFT	1.5-3.0 mils (37.5-75 um)
Recommended WFT	3.0-6.0 mils (75-150 um)
Dry to Touch	30 minutes
Dry to Handle	1.5-2 hrs
Recoat Time	Dry to touch - 72 hrs, sand thereafter
Force Dry	15-20 min @ 150°F (65°C)
Full Cure	3-7 days
Salt Spray (ASTM B117)	336 hrs
Humidity (ASTM D1748)	500 hrs
Adhesion (ASTM D3359)	5B
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 production line applications, use VpCI®-440 or similar phosphatizing pre-treatment. 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.

A wash primer such as VpCI®-373 green applied at 0.5-1.0 mils (12.5-25 microns) is recommended before applying the VpCI®-384 to aluminum, galvanized or plated substrates. Other recommended primers include VpCI®-395 and 396 depending on coating requirements.

Note: Make sure dew point is more than 5°F (2°C) less than air temperature for application.

Mix Ratio

3 Part Part A (3 gal (11.3 l))
1 Part Part B (1 gal (3.8 l))

Power agitate to a uniform consistency using a "squirrel cage" type mixer, hand-held drill mixer, or other equivalent method. VpCI®-384 can be applied by spray, roll, brush, or dip. When mixing using a pressure pot setup, allow 15-30 minutes of sweat-in time prior to application. Pot life is 2-3 hours. Super Accelerator S can be used to accelerate cure time at 6 oz. per gallon max.

Typical Equipment Set Ups

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.

Clean Up

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

**FOR INDUSTRIAL USE ONLY
KEEP OUT OF REACH OF CHILDREN
KEEP CONTAINER TIGHTLY CLOSED
NOT FOR INTERNAL CONSUMPTION
CONSULT SAFETY DATA SHEET FOR MORE
INFORMATION**

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