



CORTEC
CORPORATION

Environmentally Safe VpCI®/MCI® Technologies

VpCI®-395 Water-Based Epoxy Primer

DESCRIPTION

VpCI®-395 is a fast drying, 2K water-based epoxy one coat system (primer) that can be applied DTM (Direct to Metal) and 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 for immersion type conditions. Can be used as a topcoat for interior only applications (those not exposed to UV light). Can be matched to most custom colors.

UFI:

- 44E0-907Y500F-V313 (Light Grey Part A)
- D7E0-S0XC-F00X-HEM5 (White Part A)
- J2E0-S0JJ-U00X-6RF1 (Part B)

PACKAGING & STORAGE

VpCI®-395 is available in 5 gallon (19 L) kits: Part A - 4 gallons, Part B - 1 gallon.

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

Shelf life: 1 year



CHARACTERISTICS/TECHNICAL DATA

Volume Solids	48.60%
Gloss (ASTM D532)	15-25
VOCs (ASTM D3960)	0.2 lbs/gal (24 g/L)
Viscosity	50-60 sec+Zahn#3
Pencil Hardness (ASTM D3363)	H
Spreading Rate	779 sq.ft/gal @ 1.0 mils DFT (mixed) (19.2 sq.m/L @ 25.0 µm)
Weight per Gallon	11.88 lbs/gal (1.42 kg/L)
Flash Point	122 °F (50 °C)
Recommended DFT	1.5-3.0 mils (37.5-75 µm)
Recommended WFT	3.0-6.0 mils (75-150 µm)
Dry to Touch	20-30 min
Dry to Handle	1-2 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)	1000 hrs
Humidity (ASTM D1748)	500 hrs
Adhesion (ASTM D3359)	5B
Flexibility (ASTM D522)	½" mandrel (1.27 cm)

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® Technical Service 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 (12.5-25.0 microns) is recommended before applying the VpCI®-395 to aluminum, galvanized or plated substrates. When solvent based topcoats are applied over VpCI®-395, compatibility must be checked.

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

Mix Ratio

White Base	Clear Base
4 Parts - Part A: 4 gal (15 L)	3.5 Parts - Part A: 3.5 gal (13/25 L)
1 Part - Part B: 1 gal (3.8 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®-395 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.

Typical Equipment Set Ups

HVLP / Conventional Spray

Tip: 0.009"-0.021" (0.23-0.53 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). Pot should always have dual regulation and be kept at same elevation as spray gun.

Air Assisted Airless / Airless

Tip: 0.015"-0.035" (0.38-0.89 mm) 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 water 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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