

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

Volume Solids	52.30%
Gloss (ASTM D532)	NA
VOCs (ASTM D2369)	2.9 lbs/gal (347 g/l)
Viscosity	60-70 sec+ Zahn#3
Pencil Hardness (ASTM D3363)	NA
Spreading Rate	838 sq.ft./gal @ 1.0 mils DFT (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)	1/2" 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 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 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 Butyl Acetate when coating is still wet. When dry, use Butyl Cellusolve or MEK. Follow mfg's safety recommendations when using any solvent.

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