

VpCI®-368 Solvent Based Temporary Coating

DESCRIPTION

VpCI®-368 is a fast drying, solvent-based temporary wax-like 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

VpCI®-368 is available in 5 gallon (19 liter) pails, 55 gallon (208 liter) 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	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)	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. Cortec® recommends a minimum of a SSPC-SP1 over painted surfaces. For bare metal applications, Cortec® recommends a NACE #3/ SSPC-SP6. 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. VpCI®-368 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" (0.38-0.89 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.

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

Cleanup

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

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