



**CORTEC**  
CORPORATION

*Environmentally Safe VpCI®/MCI® Technologies*

# VpCI®-391 Water Based Temporary Coating

## DESCRIPTION

VpCI®-391 is a fast drying, water-based temporary coating that provides protection in harsh, outdoor, unsheltered applications. Provides multi-metal protection. Excellent UV resistance. Can be matched to some custom colors. Provides a hazy, dry, non-tacky film. Use of VpCI®-391 on weld joints does not negatively impact weld geometry or mechanical properties of the weld. It can be used to keep surfaces corrosion-free prior to welding.

UFI: SD40-N0UF-W00Y-D8KH

## PACKAGING & STORAGE

VpCI®-391 is available in 5 gallon (19 L) pails, 55 gallon (208 L) 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	41%
Gloss (ASTM D523)	NA
VOCs (ASTM D3960)	0.4 lbs/gal (48 g/L)
Viscosity	1,000-7,000 Centipoise
Pencil Hardness (ASTM D3363)	NA
Spreading Rate	658 sq.ft/gal @ 1.0 mils DFT (16.1 sq.m/L @ 25 µm)
Weight per Gallon	8.4 lbs/gal (1.00 kg/L)
Flash Point	212 °F (100 °C)
Recommended DFT	2-3 mils (50-75 µm)
Recommended WFT	4.9-7.3 mils (124-185 µm)
Dry to Touch	30-60 min
Dry to Handle	1-2 hrs
Recoat Time	NA
Force Dry	15-20 min @ 150 °F (65 °C)
Full Cure	3-7 days
Salt Spray (ASTM B117)	250 hrs
Humidity (ASTM D1748)	1400 hrs
Adhesion (ASTM D3359)	NA
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 (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.

***Note: Make sure dew point is more than 5 °F (2 °C) less than air temperature for application. Power agitate to a uniform consistency using a "squirrel cage" type mixer, hand-held drill mixer, or other equivalent method. VpCI®-391 can be applied by spray, roll, brush, or dip.***

### Typical Equipment Setups

#### **HVLP / Conventional Spray**

- Tip 0.011"-0.019" (0.28-0.48 mm) dependent upon pressures and viscosity
- Air Pressure 45-55 psi
- Fluid Pressure 10 psi
- Fluid hose should be  $\frac{3}{8}$ " (0.95 cm) I.D. with a maximum length of 50 feet (15.2 m).  $\frac{1}{4}$ " (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  $\frac{3}{8}$ " (0.95 cm) I.D. minimum, but a  $\frac{1}{4}$ " (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 water when coating is still wet. For removal of VpCI®-391 applied to a metal surface, use a VpCI®-41x Series alkaline cleaner/ degreaser. Follow mfg's safety recommendations when using any solvent.

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Cortec® Corporation warrants Cortec® products will be free from defects when shipped to customer. Cortec® Corporation's obligation under this warranty shall be limited to replacement of product that proves to be defective. To obtain replacement product under this warranty, the customer must notify Cortec® Corporation of the claimed defect within six months after shipment of product to customer. All freight charges for replacement products shall be paid by customer.

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