



HIGH PERFORMANCE VpCI® COATINGS

VpCI®-395



PRODUCT DESCRIPTION

VpCI-395 is a waterborne epoxy primer that provides excellent adhesion, salt spray, immersion, and long term corrosion protection to steel. VpCI-395 differs from other epoxy primers by minimizing long-term embrittlement and has a fast drying time (20-30 minutes dry to touch) as well as excellent corrosion resistance. Its water-based formulation makes it easier to comply with environmental regulations governing solvents and VOC limits. Clean up is easy by using soap and water.

FEATURES

- Provides long-term corrosion resistance in a corrosive atmosphere
- Water-reducible
- VOC compliant
- Fast drying
- Excellent adhesion
- Excellent immersion resistance
- Long pot life of 6-8 hours
- Works in HCl, H₂S, SO₂, and CO₂ vapor environments

MIXING

Mix 4 parts of Part A to 1 part of Part B. Mix until a uniform coating is obtained. After mixing, do not apply VpCI-395 for at least 30 minutes. The pot life of VpCI-395 is approximately 6-8 hours at 75°F (25°C). This value may change depending upon the temperature and size of the batch.

APPLICATION

VpCI-395 may be applied by spray or brush. A dry film thickness of 1.5-3 dry mils (37.5-75 microns) is recommended. The coating dries in about 20-30 minutes; however, it takes approximately one week before the coating is fully cured. Top coats can be applied between 30 minutes and 8 hours after the primer is applied, depending upon the type of top coat and drying conditions.

METALS PROTECTED

- Carbon steel
- Stainless steel
- Cast iron
- Galvanized **
- Aluminum **

** A wash primer such as VpCI®-373 green applied at 0.5-1.0 dry mils (12.5-25 microns) is recommended before applying the VpCI-395 to these substrates.

TYPICAL USES

- Structural steel
- OEM primer
- Equipment overhauls
- Immersed equipment
- Holding tanks

TYPICAL PROPERTIES

Part A	Aluminum
Appearance	Aluminum, liquid
NVC	50-60% by weight
Shelf Life	1 year
Density	10.0-10.5 lb/gal (1.19-1.26 kg/l)
Flash Point	>240°F (115°C)
pH	8.5-9.0 (Neat)
Viscosity	100-1000 cps
VOC (actual)	0.20 (24.07 g/l)
VOC (regulatory)	0.42 (50.17 g/l)



Part A

Appearance	Various colors, liquid
NVC	50-70% by weight
Shelf Life	1 year
Density	9.7-12.5 lb/gal (1.16-1.5 kg/l)
Flash Point	>240°F (115°C)
pH	7.0-8.5 (Neat)
Viscosity	200-10,000 cps
VOC (actual)	0.03-0.1 (3.20-11.9 g/l)
VOC (regulatory)	0.03-0.1 (3.20-11.9 g/l)

Part B

Appearance	Dark yellow liquid
NVC	38-44%
Shelf Life	1 year
Density	8.5-9.0 lb/gal (1.02-1.08 kg/l)
Flash Point	122°F (50°C)
pH	9.5-10.0 (Neat)
Viscosity	1000-1500 cps
VOC (actual)	1.62 (194.52 g/l)
VOC (regulatory)	3.05 (365.78 g/l)

Mixed Properties Aluminum

Density	9.8-10.2 lb/gal (1.17- 1.22 kg/l)
NVC	50-60%
VOC (actual)	0.52 (62.83 g/l)
VOC (regulatory)	1.07 (128.14 g/l)
Spread Rate	294-588 ft ² /gal (7.3-14.6 m ² /l)

FOR INDUSTRIAL USE ONLY**KEEP OUT OF REACH OF CHILDREN****KEEP CONTAINER TIGHTLY CLOSED****NOT FOR INTERNAL CONSUMPTION****CONSULT MATERIAL SAFETY DATA SHEET FOR MORE INFORMATION****Mixed Properties Colors, various**

Density	9.7-11.7 lb/gal (1.16-1.40 kg/l)
NVC	50-65%
VOC (actual)	0.44-0.6 (53.24-71.9 g/l)
VOC (regulatory)	0.58-0.8 (69.6-95.8 g/l)
Spread Rate	294-641 ft ² /gal (7.3-16 m ² /l)

PROPERTIES

Recommended dry film thickness
1.5-3.0 mils (37.5-75 microns)

Dry Time

Tack Free	20-30 minutes
Full Cure	7 days
Recoat	30 minutes -8 hours
Potlife	6-8 hours
Salt Spray Resistance	1500-2000 hours*
Humidity Resistance	400-500 hours*
Hardness (pencil)	H*
Adhesion	5B*
Flexibility (conical mandrel)	1/4" 100% pass*

*panels were air-dried for 7 days prior to testing

PACKAGING AND STORAGE

VpCI-395 part A is available in 5 gallon pail filled with 4 gallons (14.2 liters). VpCI-395 part B is available in a 1 gallon can (3.8 liters). A kit is 5 gallons total (19 liters). Do not allow product to freeze.

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