**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**

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

**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)  

### 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 ft²/gal (7.3-16 m²/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.

### 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**

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**Limited Warranty**

All statements, technical information and recommendations contained herein are based on tests Cortec Corporation believes to be reliable, but the accuracy or completeness thereof is not guaranteed. 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. Cortec Corporation shall have no liability for any injury, loss or damage arising out of the use of or the inability to use the products.

**Packaging and Storage**

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