



# 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, H<sub>2</sub>S, SO<sub>2</sub>, and CO<sub>2</sub> vapor environments
- UL Classified in accordance with ANSI/NSF Standard 61 for potable water (applies only to RAL 7046)

## 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.



Drinking Water System Component  
ANSI/NSF 61  
36AL

## 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	9.7-10.3 lb/gal (1.19-1.26 kg/l)
Flash Point	>240°F (115°C)
pH	8-9 (Neat)
Viscosity	800-2000 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 <sup>2</sup> /gal (7.3-14.6 m <sup>2</sup> /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 <sup>2</sup> /gal (7.3-16 m <sup>2</sup> /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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