



HIGH PERFORMANCE VCI COATINGS

VCI-365

PRODUCT DESCRIPTION

VCI-365 Cor-Mastic™ combines the best properties of the proven Cortec® open atmosphere Vapor Corrosion Inhibitors (VCI) with the well-known corrosion resistance of epoxies. This combination provides optimal corrosion protection for metals exposed to outdoor environments as well as metals immersed in fresh and salt water. VCI-365 Aluminum, Black and Tan remain flexible for good adhesion even when torsional twisting occurs.

FEATURES

- Provides long-term corrosion resistance in corrosive atmospheres
- Formulation of contact corrosion inhibitors boosts corrosion protection over that of common rust preventives and conventional epoxies
- High flash point minimizes fire hazard during application
- VOC** compliant
- Universal protection for ferrous and non-ferrous metals
- Replacement for coal tar epoxies

METHOD OF APPLICATION

VCI-365 may be applied by brush, spray or roller. Conventional or airless sprayers using hoses and fluid tips suitable for medium viscosity epoxies are recommended.

TYPICAL APPLICATIONS

Maintenance

- Mothballing refineries, power plants and chemical plants
- External surfaces of large machines, pipes, pumps, heat exchangers, etc., during standby field storage or operation
- Protection of structural plant and equipment

Marine and Utilities

- External and internal surfaces of offshore platforms and equipment
- Ballast tanks
- Storage and process vessels
- Castings
- Pumps and valves
- Compressors
- Heat exchangers
- Boilers
- Turbines and transformers
- Power line towers
- Relay stations

TYPICAL PROPERTIES

Appearance	Two-part system
Part A	Tan, aluminum or black viscous liquid
Part B	Clear slightly yellow viscous liquid
Coverage	1130-1190 ft ² /gal @ 1 mil (28-29 m ² /l @ 25 microns)
Dry film	3-5 mils (75-125 microns)
Wet film	4-7 mils (100-175 microns)
Pot life	3-4 hr. @ 75°F (24°C)
Drying time	16 hr. @ 75°F (24°C)
Cure time	7 days @ 75°F (24°C)*
Salt Spray Resistance on	Carbon Steel (1010) 2-3 mils (50-75 microns) 900-1400 hr.
VOC**	1.78 lb/gal (0.21 g/l)
Volume percent solids	69-74%
Non-volatile Content	
Aluminum Part A	74-80%
Black Part A	72-78%
Tan Part A	72-78%
Part B	78-82%
Density	
Aluminum Part A	9.3-9.5 lb/gal (1.11-1.14 kg/l)
Black Part A	8.7-9.1 lb/gal (1.04-1.09 kg/l)
Tan Part A	9.3-9.5 lb/gal (1.11-1.15 kg/l)
Part B	8.8-9.2 lb/gal (1.05-1.10 kg/l)

*Dry film remains slightly soft after full cure <6B hardness.

**Volatile Organic Compound content, per rule 24 of Environmental Protection Agency (EPA), ASTM D-3960.

MIXING AND APPLICATION INSTRUCTIONS

Mix 5 gallons (19 liter) of Part A with 2.5 gallons (9.5 liter) of Part B. This is a full kit. Do not mix partial quantities. A power mixer must be used for a minimum of 5 minutes. Add Cortec® S-25 thinner while mixing if needed. Thinner is added to adjust viscosity for the application. Each type of spray equipment or spray nozzle size may require adjustments in thinning. Wait 30 minutes after mixing before applying paint.

POT LIFE

Pot life is 3-4 hours at 75°F (24°C). Working time will be less at higher temperatures. Do not use materials after this time, even though it is still fluid.



APPLICATION EQUIPMENT

Conventional Spray*

Manufacturer	Gun Model	Tip-air Cap Combination
Devilbis	MBC or JGA	704E
Binks	#18 or #62	66PE

Airless Spray**

Manufacturer	Gun Model	Tip-air Cap Combination
Graco	205-591	Bulldog
Binks	500	Mercury 5C
Devilbis	JGN-501	QFA-519

Tip Size	Pressure
0.017"-0.021" (0.04-0.05 cm)	1700-2000 psi (117-138 bar)

*For low volume applications, smaller tip-air cap combinations may be suitable. The fluid hose should be 3/8" (9 mm) ID with a maximum length of 50' (15 m). For longer distances, use a 1/2" (13 mm) hose. A 25' (8 m) "whip" of 1/4" (6 mm) may be used. The pot should always have dual regulation and be kept at the same elevation as the spraygun.

**Nylon or Teflon¹ type packings are available from the pump manufacturer and are highly recommended. Equipment similar to the above is suitable. This listing is for reference purposes only.

¹Teflon is a trademark of E. I. DuPont.

SURFACE PREPARATION

VCI-365 may be applied directly to metal, but a primer such as VCI-373 or VCI-393 is recommended for direct to metal applications. Follow these recommended minimum surface preparation guidelines.

NACE	SSPC	ARS
3	SP3	High B2

NACE - National Association of Corrosion Engineers

SSPC - Steel Structure Painting Council

ARS - American Rust Standard Guide

DRY AND CURE TIME

Allow VCI-365 to dry a minimum of 4 hours at 75°F (24°C) between coats. VCI-365 may be topcoated even if tacky at 3-5 hours. Allow to cure 48 hours prior to use unless otherwise specified. The film will remain soft to the fingernail even when fully cured.

THINNING/CLEAN-UP

VCI-365 can be thinned up to 15% with Cortec® S-25 thinner. If this is not available, aromatic thinners such as xylene (xylol), toluene (toluol) or mineral spirits may be satisfactory. The flash point will be lowered if these are used. Do not use MEK (methyleneethylketone). Clean up with an epoxy solvent or one of the above.

PACKAGING AND STORAGE

Standard packaging is Part A (5 gallon/19 liter) and Part B (2.5 gallon/9.5 liter). Standard colors are Medium Tan, Aluminum and Black. Custom colors are available upon request. Part A must be stored in a tightly sealed container. Prolonged atmospheric exposure results in partial solidification of the coating. Shelf life is 12 months at 75°F (24°C).

Minimum storage temperature: 20°F (-7°C)

Maximum storage temperature: 120°F (49°C)

LIMITATIONS

- VCI-365 Black may fade to gray in direct sunlight (or high temperatures) with time
- Do not apply at 90-100% relative humidity
- Cure times at 50°F (10°C) will double to two weeks
- Cure time before water submersion is one week at 75°F (24°C)

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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printed on recycled paper  10% post consumer

Revised 10/12/00. Cortec Corporation 2000. All rights reserved. Supersedes: 6/26/99.

Distributed by:



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