



Description

AC-854-GEL-NF is an air curing, hand peelable coating that provides protection to metallic surfaces during chemical processing, metal bonding, and chemical milling.

Product Performance

AC-854-GEL-NF has demonstrated excellent performance when used as a chemical milling maskant and an anodizing stop-off. A major breakthrough in the science of adhesion control has been incorporated into AC-854-GEL-NF. As a result, lower, more uniform adhesion is obtained both before and after processing regardless of the alloy or pre-coat cleaning method used.

AC-854-GEL-NF was specifically formulated as a gel for brush application.

AC-854-GEL-NF resists the solutions used in the pre-bond, cleaning line and performs well in both the 250°F. and 350°F. bonding processes.

Product Characteristics (as shipped)

Appearance	Light Blue Gel
Solids Content (% by weight)	26.0 ± 2.0
Solids Content (% by volume)	28.0 ± 2.0
Coverage (ft ² /mil of dry film/gal.)	450
Weight (Lbs./Gal.)	12.3 + 0.2
Flash Point (T.O.C.)	Above 200°F.
Storage Life (Ambient Temperatures)	1 year

Product Characteristics - Cured Film (Typical Results)

Resistance to Acid/Alkaline Solutions	Excellent
Adhesion (Typical values in oz./inch width) 7075-T6 bare aluminum, solvent wiped	8 oz. (before processing)

Product Precautions

WARNING! CONTAINS perchloroethylene and toluene. **VAPOR HARMFUL. HARMFUL OR FATAL IF SWALLOWED. KEEP OUT OF REACH OF CHILDREN.** Keep away from heat, sparks, and open flame. Keep container closed when not in use. Use only with adequate ventilation. Avoid prolonged or repeated breathing of vapor. Avoid prolonged or repeated contact with skin. **DO NOT TAKE INTERNALLY. FIRST AID:** If swallowed: **DO NOT INDUCE VOMITING. CALL A PHYSICIAN IMMEDIATELY.** In case of overexposure due to inhalation: Move victim to fresh air; if breathing is difficult, give oxygen; if not breathing, administer artificial respiration ... **CALL A PHYSICIAN IMMEDIATELY.** Contact with skin: Remove contaminated clothing; wash affected areas with soap and water. If irritation persists get medical attention. Decontaminate any affected clothing before reuse. See MSDS provided.



Packaging –

AC-854-GEL-NF is furnished in 5 gallon pails, and 55 gallon F.O.T. steel drums.

Product Use Instructions

General –

The directions and recommendations given below are intended to serve as a guide and may need modification to meet local conditions.

Mixing –

No mixing normally required. Parts must be clean and dry before coating for optimum performance.

Thinning –

Use as received.

Solvent Replacement Due to Evaporation -

Perchloroethylene.

Recommended Dry Film Thickness –

Six to twelve mils, depending on the process requirements.

Cure Cycle –

Allow the film to air cure for 4 hours minimum at 75°F. or above. At lower shop temperatures allow additional curing time. AC-854-GEL-NF films may be baked at 150 - 225°F. for 30 to 60 minutes after an initial air cure of 1 to 2 hours, should faster processing be required.

Brush Application -

Apply 1 to 2 brush coats of AC-854-GEL-NF to the part. Dry film build should be 6 mils minimum.

Warranty

The following warranty is made in lieu of all other warranties, either expressed or implied. This product is manufactured of selected raw materials by skilled technicians. Neither seller nor manufacturer has any knowledge or control concerning the purchaser's use of this product and no warranty is made as to the results of any use. The only obligation of either seller or manufacturer shall be to replace any quantity of this product, which is proved to be defective. Any claim of defective product must be received in writing within one (1) year from date of shipment. Neither seller nor manufacturer assumes any liability for injury, loss, or damage resulting from use of this product.

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