

PRODUCT DESCRIPTION

AC-828-77-TAN is an air curing, general purpose, hand peelable coating that provides protection to metallic surfaces during mechanical fabrication and chemical processing.

AC-828-77-TAN is supplied as a concentrate, ready to use product for brush application or thinned when it is to be applied by immersion dip tank or airless spray.

PRODUCT PERFORMANCE

- ▮ Provides excellent performance when used as a chemical milling maskant.
- ▮ Provides excellent performance when used as an anodizing maskant or plating stop off. Use as received for brush application.
- ▮ Maintains uniform low adhesion to most alloys during and after chemical or mechanical processing.
- ▮ Has outstanding bubble breaking properties, making it an ideal choice for dip tank application.
- ▮ Resists the solutions used in the pre-bond metal cleaning line and performs satisfactorily in both the 250°F metal bonding processes.
- ▮ Not recommended for outdoor storage of masked parts.

Do not immerse AC-828-77-TAN in solvents or vapor degreasers as they will dissolve the coatings.

SPECIFICATIONS

- ▮ Boeing BAC 5772 Chemical Milling of Aluminum Alloys
- ▮ Boeing BAC 5555 Phosphoric Acid Anodizing of Aluminum for Structural Bonding
- ▮ Boeing BAC 5034-1

PRODUCT CHARACTERISTICS - AS SHIPPED

APPEARANCE	Tan Viscous Liquid
COVERAGE (SQ. FEET/MIL DRY FILM/GAL)	580 (53.9 square meters)
FLASH POINT (PENSKY MARTENS)	109°F (42.8°C)
WARRANTY	Storage Life (Ambient Temperatures) 2 Years in Sealed Containers
SOLVENT SYSTEM	XYLENE, VM&P NAPHTHA, AND TOLUENE

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. Parts must be clean and dry before coating for optimum performance.
MIXING:	AC-828-77-TAN should be thoroughly mixed prior to use and remixed at least once per eight hour shift. Avoid introducing air into the coating during mixing. Parts must be clean and dry before coating for optimum performance.
THINNING:	Thin AC-828-77-TAN with Toluene for dip tank or airless spray application per the AC-828-77 Application Bulletin. Use as received for brush application.
RECOMMENDED DRY FILM THICKNESS:	8-12 mils, depending on the process requirements. AC-828-77-TAN may be used at 5-6 mils as an in-shop protective coating.
CURE CYCLE:	Allow the film to air cure for 4 hours minimum at 80°F (27°C). or above. At lower temperatures allow additional curing time. AC-828-77-TAN films may be baked at 150°F (65°C) for 30 to 60 minutes after an initial air cure of 1 to 2 hours should faster processing be required.

PRODUCT PRECAUTIONS

DANGER! FLAMMABLE! CONTAINS XYLENE, VM&P NAPHTHA, AND TOLUENE. HARMFUL OR FATAL IF SWALLOWED. VAPOR HARMFUL IF INHALED. KEEP OUT OF REACH OF CHILDREN. Avoid prolonged or repeated breathing of vapor. Use with adequate ventilation. Keep away from heat, sparks, hot glowing surfaces, and open flame. Keep container closed when not in use. Avoid prolonged or repeated contact with skin. **DO NOT TAKE INTERNALLY.** Consult **SAFETY DATA SHEET** for handling and safety information.

PRODUCT PACKAGING

- ▶ AC-828-77-TAN is furnished in 5 gallon pails and 55 gallon F.O.T. nonreturnable steel drums

Seller makes no warranty of any kind, express or implied, as to the merchantability, fitness for any particular purpose, or any other matter with respect to this product. Since conditions of use are beyond seller's control, buyer assumes all risk of use of this product. Under no circumstances will seller be liable for consequential or incidental damages arising out of the use of this product. Seller's sole obligation shall be to replace the product if found to be defective. It is the user's responsibility to determine the suitability for use of this product under the conditions present at the time of application. S.D.S. available upon request.

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