



PRODUCT DESCRIPTION

AC-850-CH-TOLUENE TAN is an air curing, hand peelable coating that provides protection to metallic surfaces during chemical processing, metal bonding, and chemical milling.

AC-850-CH-Toluene TAN is a ready to use product designed to be applied by immersion dip tank, airless spray, or brush application.

PRODUCT PERFORMANCE

- Formulated to provide low adhesion to surfaces that normally create high adhesion, such as chromate conversion coating, anodize, and grit blasted surfaces.
- Boeing BAC 5772 Chemical Milling of Aluminum Alloys
- Has excellent resistance to chemical solutions used in metal bonding, chemical milling, anodizing, and plating.
- Can easily peel after bake or autoclave cycles of 250°F and 350°F.

Do not immerse AC-850-CH-TOLUENE 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

PRODUCT CHARACTERISTICS - AS SHIPPED

APPEARANCE	Tan Viscous Liquid
FLASH POINT (T.O.C.)	45°F
WARRANTY	Storage Life (Ambient Temperatures) 2 Years in Sealed Containers
SOLVENT SYSTEM	Toluene



PRODUCT USE INSTRUCTIONS

GENERAL:	The following directions and recommendations are intended to serve as a guide and may need modification to meet local conditions.
MIXING:	AC-850-CH-TOLUENE TAN should be thoroughly mixed and remixed at least once per eight hour shift. Avoid introducing air into the coating during mixing. Intermittent mixing is necessary in a dip tank to prevent surface skinning. Parts must be clean and dry before coating for optimum performance.
THINNING:	Use as received. Mixing is not required. Should the material thicken during use due to evaporation, thin with toluene.
RECOMMENDED DRY FILM THICKNESS:	6-15 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 temperatures allow additional curing time. An oven cure for 60 minutes at 135°F may be used after air drying for one hour to speed processing. Optimum performance in plating and anodizing may be obtained by baking at 200°F for 30 to 60 minutes after the initial air dry or forced cure. The user should determine if the 200°F final bake is necessary.

PRODUCT PRECAUTIONS

WARNING! CONTAINS 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-850-CH-TOLUENE TAN is furnished in 5 gallon pour spout pails and 55 gallon 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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