

# ac products, inc.

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AC-WB LINE SEALER (JW5-33 Clear)

## PRODUCT DESCRIPTION

AC-WB Line Sealer (JW5-33 Clear) is a water based air or forced cure coating that provides protection to prescribed knife and laser cut lines during the chemical milling process.

AC-WB Line Sealer (JW5-33 Clear) can also be used as a repair coat to seal minor maskant defects. Typical defects include air bubbles, grit particles and minor scrapes.

## PRODUCT PERFORMANCE

AC-WB Line Sealer (JW5-33 Clear) provides outstanding resistance to both caustic and acid solutions. When the maskant is properly cleaned prior to the application of the Line Sealer, prescribed lines are being successfully protected in aluminum Type II etchants at temperatures up to 220°F. for metal removal of 180 mils.

Many variations exist in the chemical makeup and operating temperatures used for aluminum etchants. It is recommended that the user carefully evaluate the AC-WB Line Sealer (JW5-33 Clear) prior to use on production parts. It is absolutely imperative that the Line Sealer be adequately dried prior to immersion into the etchant.

## PRODUCT CHARACTERISTICS - AS SHIPPED

APPEARANCE.....	Milky White Liquid
POUNDS PER GALLON.....	8.0 ± 0.2
STORAGE LIFE (Temperatures between 40 and 85°F.).....	2 Years

## PRODUCT PACKAGING

AC-WB Line Sealer (JW5-33 Clear) is furnished in 5 gallon plastic pails that are fitted with a resealable spout.

## PRODUCT PRECAUTIONS

**DO NOT TAKE INTERNALLY.** Avoid contact with skin and eyes. Should contact occur, wash off with copious amounts of water. **DO NOT FREEZE. KEEP OUT OF REACH OF CHILDREN. CONSULT MATERIAL SAFETY DATA SHEET FOR HANDLING AND SAFETY INFORMATION.**  
**STORE AT TEMPERATURES BETWEEN 40 AND 85°F. FOR OPTIMUM SHELF LIFE.**

## PRODUCT USE INSTRUCTIONS

GENERAL: The directions and recommendations given below are intended to serve as a guide and may require modification depending on shop conditions.

MIXING AND THINNING: Use as received. Mixing prior to use is not normally required.

## CLEANING THE MASKANT PRIOR TO APPLICATION OF THE LINE SEALER:

Clean the maskant prior to applying the AC WB Line Sealer (JW5-33 Clear). This may be done by high-pressure water washing or wiping the maskant with a water-wetted sponge similar to that supplied by Quikie available at Home Depot. If the Quikie sponge is used, while the surface is still wet, wipe dry with a Quikie terry cloth slip on towel. If high-pressure water washing is used, allow to dry prior to applying the Line Sealer. Further wiping of the maskant should not be required.

All forming lubricant must be removed from the maskant prior to line sealing. Depending on the lubricant, this may be accomplished by wiping the surface of the maskant with cheesecloth wetted with water, isopropyl alcohol, or acetone. Allow to dry.

APPLICATION: The laser scribed maskant film should be free of all powder, dust, dirt, and oils.

### Option 1: Brush Application

1. Apply 1 coat of AC-WB Line Sealer (JW5-33 Clear) as follows:

Brush a wet coat of AC-WB Line Sealer (JW5-33 Clear) over the prescribed lines using a high quality 1" brush. Flow the line sealer onto the scribe line; and, using the flat of the brush, level the applied material brushing lightly parallel to the scribed line. Do not brush repeatedly as brush lines will form.

2. Should testing determine that a second coat is required for adequate line protection, allow the first coat to dry until clear and free of the milky appearance. Repeat step 1.
3. Allow to dry at temperatures above 70°F. for 4 hours minimum. Shop experience will determine whether longer or shorter drying times may be used.

### Option 2: Cheesecloth Application

1. Apply 1 coat of AC-WB Line Sealer (JW5-33 Clear) as follows:

Wear a plastic glove. Wad up a piece of cheesecloth until it is approximately 3 - 4 inches across. Saturate the cheesecloth in the AC-WB Line Sealer (JW5-33 Clear) so it is very wet. Wipe the AC-WB Line Sealer (JW5-33 Clear) over the prescribed line in circles. Apply a wet coat. While the AC-WB Line Sealer (JW5-33 Clear) is still wet, lightly rub the cheesecloth over the AC-WB Line Sealer (JW5-33 Clear) parallel to the scribed line to remove excess material and minimize bubbles. **Do not contaminate the AC-WB Line Sealer (JW5-33 Clear) by putting dirty cheesecloth back into the Line Sealer.**

2. Should testing determine that a second coat is required for adequate line protection, allow the first coat to dry until clear and free of the milky appearance. Repeat step 1.
3. Allow to dry at temperatures above 70°F. for four hours minimum. Shop experience will determine whether longer or shorter drying times may be used depending on the temperature and humidity at any given time.

### Option 3: Rollercoat Application

#### 1. Equipment required

- a. 9" by 3/4" Number 66 Slit foam roller manufactured by FoamPRO Mfg., P.O. Box 18888, Irvine, CA 92623-8888, [www.foampromfg.com](http://www.foampromfg.com) or equivalent.
- b. Paint tray with plastic insert
- c. Handle to support the paint roller
- d. KEEP THE PAINT TRAY AND ROLLER COVERED WITH PLASTIC WRAP WHEN NOT IN USE TO PREVENT THE MATERIAL FROM SKINNING AND DRYING ONTO THE ROLLER.

#### 2. Apply the first coat as follows:

- a. Wet the foam roller well with the AC-WB Line Sealer (JW5-33 Clear).
- b. Roll the Line Sealer over the areas to be protected applying enough pressure to push the Line Sealer into the laser or hand scribed lines using approximately a 25% overlap. Make sure that all areas are wetted thoroughly. Level the Line Sealer as you go using the roller to remove excess material by going lightly over the areas coated as you move down the part. Most users of the Line Sealer find it more efficient to roll the entire areas where scribe lines are present from the top of the part to the bottom of the part. In addition to providing protection to the scribed lines, additional protection is created in the areas surrounding the scribed lines. The approximate application time to coat an 11' x 5' part has been timed at 3 minutes.
- c. Allow to dry until clear and the milky color has disappeared. This will take 30 to 60 minutes depending on the shop temperature and humidity. Fans and/or warm air to 120°F. can be used to speed the drying to less than 30 minutes.
- d. Apply a second coat of Line Sealer by repeating b. above. The applied pressure is normally lighter when applying the second coat. A second coat must be applied to obtain satisfactory protection of the prescribed lines.
- e. Allow the rollercoated Line Sealer to dry a minimum of 2 hours at temperatures above 90°F. and for 4 hours minimum at 70° before immersing in the aluminum etchant. Shop experience will determine exactly how long the Line Sealer must dry to provide adequate protection. It is imperative that the Line Sealer be completely dried to provide protection.

### Option 4: Airless Spray Application

#### Equipment required:

- a. Airless spray unit 25 or 30:1 ratio, stainless steel on all wetted surfaces with an air regulator. Use a 100-mesh filter in the unit.
- b. 511 tip, this tip has a 10" fan when 12 inches away from the part. The orifice is .011" A reverse a clean tip is recommended.

#### Apply 1 coat of AC-WB Line Sealer (JW5-33 Clear) as follows:

Apply the sealer as received; the fluid pressure should be 2,000-2,500 psi. The spray overlap should be as needed to apply a wet continuous film over the entire surface area. Hold the spray gun approximately 12 to 16 inches from the part. Apply approximately 8 to 10 wet mils of Line Sealer.

Drying times: These will have to be determined based on shop experience. Overnight drying is recommended at temperatures above 70°F. for optimum performance.

**Forced Cure Time:**

Drying at elevated temperatures can accelerate the drying process. The air temperature should not exceed 125°F. (51°C.). When the sealer is force dried at 125°F., the part can be processed 60 minutes after the sealer dries to a clear condition.

**Maskant Removal:**

When peeling a sealed pocket, always pull away from the remaining maskant.

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. M.S.D.S. available upon request.