



TURCOAT[®] 6846

WATER-BORNE, ALKALINE REMOVABLE PROTECTIVE COATING

DESCRIPTION:

TURCOAT 6846 is a quick drying transparent green water-borne alkaline removable protective coating. This low VOC product is especially formulated to protect aluminum surfaces from abrasion, scuffing and corrosion during in-pant processing and storage.

Because of its low VOC, TURCOAT 6846 may be used on certain plastic surfaces. Spot testing is recommended prior to using.

Formulated to meet requirements of Boeing BAC 5034, Type I; BMS 15-12, Type I, Class I.

USE INSTRUCTIONS:

Precleaning: Parts to be coated must be free of dirt, grease, forming lubricants, and oils. Your TURCO Sales Engineer can recommend suitable TURCO cleaners based on your production needs. Surfaces should be dry prior to coating applications.

Spray Application: Mix well before using. TURCOAT 6846 sprays like a lacquer. Use a standard pressure pot, or siphon cup equipment such as Binks stainless steel 2001 gun with 563A fluid needle, 63B nozzle, and 63PJ air-caps. 50-psi line pressure with 3-8 psi pot pressure. Cold airless equipment such as Graco 28:1 President pump. Reflex gun, and spray tips such as 163-617, 163-621 or 163-817 may also be used. An air line pressure of 80 psi min; a fluid line pressure of 2000 psi is recommended. Binks HVLP (BBR) 95 P tip (40-80 psi line pressure). Several box coats may be necessary to obtain the desired dry film thickness. Water can be used to clean gun, lines and pumps immediately after spraying.

TURCOAT 6846 dries to handle in 45-80 minutes depending on the ambient temperature, or it may be force dried at 160°F (71°C) with ventilation in 5 to 10 minutes.

Removal: TURCO FABRIFILM REMOVER EA has been especially formulated for quick removal of TURCOAT 6846. This viscous liquids clings to vertical, and overhead surfaces, and can remove TURCOAT 6846 even after the film has been aged, or exposed to heat. After application, allow remover to dwell on the surface 15 to 30 minutes. Rinse coating and remover from parts with high-pressure water.

Removal can also be accomplished with solvent type removers and wiping with a clean cloth.

LIQUID PROPERTIES:

Viscosity #3 Zahn Cup	30 + 5 sec
Color	Pale Green
VOC (SCAQMD)	84 g/l
Flash Point	None to boiling
Weight per gallon	8.5
PH	8.0 - 9.0
Storage Life	1 yr @ 35°-95°F (2°-35°) (Keep from freezing)

DRY FILM PROPERTIES:

(0.0015 inches)

Appearance:	Green, transparent
Dry-to-touch Time @ 77°F (25°C):	45-80 minutes
Block resistance (after 3 days drying):	Pass
Adhesion Tape Test: (After 3 days drying) (7 days immersion in distilled water @ room temperature after 4 hrs. recovery):	Pass
Bend test, 3/16" mandrel:	Pass
Direct impact, 20 inch-pounds	Pass
Reverse impact, 20 inch-pounds	Pass
Removable after 12 hrs @ 160°F (71°C):	Pass
Weather resistance, 3 months outdoors:	Pass
Pencil Hardness:	HB

Above tests were performed using 2024 clad aluminum

DISPOSAL INFORMATION:

Dispose of spent solution per local, state and regional regulations. Refer to your TURCO MATERIAL SAFETY DATA SHEET for additional disposal information.

Protective clothing is not usually necessary, but NIOSH approved respirator is recommended when spraying.

Store and ship in closed containers at temperatures 35°F - 95°F (2°C-35°C)

Before using this product refer to container label and TURCO MATERIAL SAFETY DATA SHEET for additional precautionary, handling and first aid information.

NOTICE:

The above information and recommendations concerning this product are based upon our laboratory tests and field use experience. However, since conditions of actual use are beyond our control, any recommendations or suggestions are made without warranty, express or implied. Manufacturer's and seller's sole obligation shall be to replace that portion of the product shown to be defective. Neither shall be liable for any loss, damage, or injury, direct or consequential, arising out of the use of this product.

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