



TURCO® Form Mask 526 NF

Introduction

Turcoform Mask 526 NF is a one-package, protective coating, which possesses a superior degree of chemical resistance. This product gives outstanding protection against the corrosive action of hot alkaline and acid solutions, and was specially developed for use in the aluminum, magnesium, steel and titanium Chem-Mill Processes.

It is designed for use as a topcoat over Masks 522, 545 and 537-42 to provide these films with additional resistance to chemical milling etchants.

Its use is recommended with the particularly aggressive steel and titanium etchant solutions and will be of benefit in processing deep cuts in these metals.

Liquid properties

Viscosity, 5 Zahn Cup at 25 °C	18 - 22 sec.
Brookfield 4/30 at 25 °C	9 - 11 poise
Solids content, % by weight	10,6 - 11 %
Color	Transparent blue
Flash point	None

Precautions

Keep away from heat.

Keep container closed.

Use only with adequate ventilation.

Avoid prolonged breathing of vapor.

Avoid prolonged or repeated contact with skin.

Processes

Aluminum and Magnesium Processes

Air-cure schedule: After final coat of coating is tack-free, allow coating to cure overnight before etching.

Oven-cure schedule: Tack-free coating may be oven-cured for 60 minutes at 110°C to speed the curing cycle.

Steel and Titanium Processes

Air-cure schedule: Overnight air-cure, no oven necessary.

Oven-cure schedule: Oven-cure tack-free coating for 60 minutes at 110°C.

Directions for use

Directions below describe various methods of application. No mixing is necessary prior to use. Caution should be exercised to prevent air from being drawn into the coating by the mixing action, when thinning.

The coating should be diluted with per-chlore-ethylene, depending on local temperature/ humidity conditions. One or two dip or flow coats will provide adequate protection. A cured film thickness of 3 or 4 mils over TFM 522, TFM 545 and TFM 537-42 normally provides adequate protection against etching solutions.

The directions and recommendations given are intended to serve as a general guide to processors and may require modification, based on field experience, to meet local conditions.

Dip application:

1. Slowly immerse clean part into dip tank.
2. Remove part from dip tank. Do not permit direct drainage of excess coating into dip tank as this can trap air in the mask.
3. The coated part is allowed to dry until the surface is tack-free (15 to 45 minutes, depending on part size and atmospheric conditions), if a second coat is desired.

Flow application:

1. Flow coating onto clean part. Avoid flowing over the top of a part.
2. Allow part to dry until the mask is tack-free (15 to 45 minutes, depending on part size and atmospheric conditions), rotate 180 ° and recoat if desired.

Brush or roller applications:

1. Apply to clean part with brush or Flow-roller, as desired.
2. Allow part to stand until coating is tack-free. Atmospheric conditions may vary the time required to reach the tack-free state, from 15 to 60 minutes.
3. Apply desired number of coats, allowing coating to reach a tack-free condition before additional applications.

NOTICE:

The above information and recommendations concerning this product are based upon our laboratory tests and field use experience with this or similar products. 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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