

# Technical Data Sheet

## 95-1000AC ANAEROBIC IMPREGNATION SEALANT

### Product Description

Godfrey & Wing's 95-1000AC impregnation sealant is designed to seal porosity in cast and powdered metal components. 95-1000AC is completely removed from the surface of components in city or de-ionized water. Once polymerized the hardened resins exhibit superior chemical resistance and elevated temperature stability.

When used prior to plating or painting processes, 95-1000AC eliminates failures due to out-gassing or to absorption of plating materials that could later bleed out of pores causing finishes to discolor, bleed, pit or peel. Sealed powdered metal parts exhibit better machinability, enhanced tool life and better dimensional control.

95-1000AC is anaerobic, curing in the absence of air where confined, to form a durable, thermoset polymer. Several factors influence the cure rate of the 95-1000AC including chemical, thermal and ionic activity.

### Product Certification

MIL-I-17563 Rev. C - Class 1 and 3

### Typical Applications

95-1000AC is well suited to nearly all applications as its high resistance to heat and chemicals cover a wide range of uses in automotive, defense and aviation components. It is widely used to seal powdered metal components prior to plating or painting.

Other common uses include engine and powertrain components, fuel handling systems, hydraulic systems, refrigeration and air compressors.

Typical Properties (Uncured)	Value
Chemical Type	Methacrylate blend
Appearance	Amber fluorescent liquid
Viscosity	9 cps or mPa.s @ 22 °C (72 °F)
Density	1.022 gms/cc @ 22 °C (72 °F)
Surface Tension	33.4 dynes/cm or mN/m
Flash Point	>93 °C (>200 °F) Cleveland Open Cup
Vapor Pressure	<1mm Hg

Typical Properties (Cured)	Value
Hardness, Shore D	79
Density	1.21 gms/cc @ 22 °C (72 °F)
Coefficient of Thermal Expansion	2.5 x 10 <sup>-4</sup> in/in/°C
Compressive Strength	9668 psi
Compressive Modulus	38672 psi
Operating Temperature	-40 °C to 163 °C (-104 °F to 325 °F)



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#### Chemical/Solvent Resistance

95-1000AC has passed all requirements of MIL-I-17563 Rev. C and also exhibits excellent resistance to a wide range of acids, caustics, hydrocarbons and solvents. Please contact your Godfrey & Wing Sales Engineer for specific chemical or solvent compatibility.

#### General Information

This product is not recommended for use in pure oxygen and/or oxygen rich systems. For safe handling information on this product, consult the Material Safety Data Sheet (MSDS).

#### Disposal of Waste

Any effluent generated from the rinse waters in the impregnation process may, in general, be disposed of in accordance with the municipal waste water regulations or treated within existing in-plant WWT facilities. Since both the circumstances of use and local waste disposal requirements vary, consult your Godfrey & Wing Sales Engineer for recommendations.

#### Storage

95-1000AC should be stored in a cool, dry location in unopened containers at a temperature between 40°F to 80°F (4°C to 27°C) unless otherwise labeled. To prevent contamination of unused material, do not return any material to its original container.

95-1000AC that has been activated in an impregnation system has unlimited pot life if recommended controls are maintained, including temperature controls and aeration.

#### Impregnation Equipment & Sealants

Godfrey & Wing designs and manufactures a complete line of innovative vacuum impregnation equipment and sealants. All impregnation systems are engineered to maximize productivity, economize sealant usage and conserve resources. The impregnation sealants are field-tested and proven over decades of use. We support our sealant and equipment with a global network of factory-trained technicians and process engineers, enabling our customers to optimize their impregnation equipment, sealants and processes.

*For more information, contact Godfrey & Wing at 1-800-241-2579 or visit [www.godfreywing.com](http://www.godfreywing.com)*

This information is based on data which Godfrey & Wing believes to be reliable and accurate. It remains the responsibility of the operator to ensure that any and all environmental, mechanical, safety and other factors are considered in a specific application when establishing its own practices and procedures. Godfrey & Wing shall not be liable for any damage, loss, or injury, direct or consequential, arising out of the use of products supplied by Godfrey & Wing or the implementation of any recommendation contained herein.



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(Revised 3/12)