



ALISEAL HWA ADDITIVE

ANODISING SEAL

INTRODUCTION

Aliseal HWA is a concentrated additive for use in hot water seals. It produces a smut free surface. Aliseal HWA can be used as part of a 2-stage sealing process or as a single stage hot water seal.

BENEFITS

- Smudge free finish.
- No staining.
- Enhanced curing after cold sealing.
- No effect on adhesion of organic coatings.
- Low concentration.
- Tolerant to minor contamination levels of aluminium, calcium, nickel

SOLUTION MAKE -UP

Aliseal HWA Additive

2ml/l with deionised water

OPERATING DATA

Concentration	2 ml/l
Temperature	70°C (post cold seal) 100°C (Hot water seal)
pH	5.5 – 7.0
Time	5 mins (post cold seal), 60 mins (Hot water seal)
Extraction	Recommended for steam removal

EQUIPMENT

Tanks	Polypropylene or Stainless-steel tanks.
Heaters	PTFE coated heaters with thermostatic control.

INSTALLATION

It is essential that the tanks to be used for Aliseal HWA are thoroughly cleaned and leached before any product is introduced.

If in any doubt as to the cleaning procedure, please contact PMD Technical Department.

1. Add the required volume of DI water.



2. Add the Aliseal HWA and stir.
3. Check the pH and adjust if required.
4. Heat to operating temperature.

PROCESS SEQUENCE

1. Soak Clean. Econoclense SAL.
2. Rinse.
3. Etch. EtchAL.
4. Rinse.
5. Acid dip. 50% nitric acid.
6. Rinse.
7. Anodise.
8. Rinse.
9. Rinse.
10. Dye.
11. Rinse
12. Rinse.
13. i) Seal. Aliseal HWA. 95-100°C or
14. ii) Seal Aliseal LT 30-40°C or Aliseal CS, followed by Aliseal HWA 70°C
15. DI rinse.
16. Dry.

MAINTENANCE AND CONTROL

pH should be checked on a frequent basis and corrected with either 10% acetic acid or 10% sodium hydroxide solution.

The solution should be discarded when sealing fails to be effective.

DISPOSAL

Dispose of in accordance with local authority requirements.

PRODUCT FAMILIES

The following products are referred to in this data sheet.

PRODUCT NAME	PRODUCT NUMBER
Aliseal HWA	251010
Aliseal LT	251002
Aliseal CS	251005
Econoclense SAL	206034
EtchAL	206044

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