



Metal Finishing Systems

Birchwood Laboratories, Inc.  
7900 Fuller Road  
Eden Prairie, MN 55344 USA  
Tel: 952/937-7931  
Fax: 952/937-7979

[www.birchwoodcasey.com](http://www.birchwoodcasey.com)

## CLEARLOK® Polyurethane Sealant

### Operating Instructions

#### PRODUCT DESCRIPTION

CLEARLOK® Polyurethane sealant is a water emulsion blend of urethane and acrylic polymers that dries to a clear protective film with excellent toughness and corrosion resistance. Supplied as a liquid concentrate, CLEARLOK sealant can be diluted with water and applied by immersion or applied full-strength by brush-on techniques. When dry, the CLEARLOK coating forms a durable topcoat that resists humidity, abrasion, and corrosion.

CLEARLOK sealant is recommended for use over all BIRCHWOOD CASEY colored conversion coatings on steel, aluminum, nickel, zinc or pewter. It can also be used on other finishes such as phosphates, sulfides and oxides, as well as directly over all plated surfaces such as nickel or zinc. CLEARLOK sealant provides a continuous film that seals out corrosion and enhances the wear resistance of the surface.

#### OPERATING CONDITIONS

Bath Makeup	50% by volume in tap water.
Bath Operating pH	8-9
Operating Temperature	70-120° F. Use de-rated heaters.
Equipment Construction	Tanks, racks: plastic, stainless steel.
Film Thickness	Approx. 0.2 mils.
Coverage	Approx. 1,000 square feet per gallon.
Corrosion Resistance	200+ hours @ 100% humidity.

## **BATH MAINTENANCE**

The CLEARLOK bath should be maintained at the correct concentration and pH. During normal operation, both the concentration and pH will gradually drop. Periodic additions of fresh CLEARLOK concentrate can be used to maintain proper levels. Do not allow the pH to drop below 7.5. If this occurs, the pH should be adjusted by adding small amounts of ammonia or monoethanolamine. Please consult with your BIRCHWOOD CASEY representative for further guidance on maintaining the bath.

## **COATING REMOVAL**

The CLEARLOK coating can be removed by alkaline soak cleaners, if necessary. Removal is a function of the concentration of the cleaner, immersion time and degree of agitation. Ammonium hydroxide helps to solubilize the film.

## **PACKAGING**

5 and 55 gallon non-returnable plastic containers. Store in closed container. Do Not Freeze.

***Before Using This Product – Please Read, Understand and Follow all the Precautions shown on the Product Label and on the Material Safety Data Sheet.***

The Material Safety Data Sheet can be found on our website: [www.birchwoodcasey.com](http://www.birchwoodcasey.com)

**Apply Appropriate Labels to any Container used to Store or Apply this Product.**

**NOTE:** The information contained herein is provided in good faith and is believed to be correct as of the date hereof. However, Birchwood Laboratories, Inc. makes no representation as to the comprehensiveness or accuracy of the information. It is expected that individuals receiving the information will exercise their independent judgment in determining its appropriateness for a particular purpose. Accordingly, Birchwood Laboratories, Inc. will not be responsible for damages of any kind resulting from the use of or reliance upon such information.