



AST-SEAL™ 91WS

LOW VISCOSITY / WICKING POROSITY SEALER

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Product Description

AST-SEAL™ 91WS is a Low Viscosity, Wicking Sealant and Porosity Sealer with a very low viscosity and high strength that allows the material to Wick into very small voids in welds, powder metal castings or to seal tight tolerance press fits and seal the voids and increases the strength of the assembly.

AST-SEAL™ 91WS also has the ability to function as a wicking Threadlocker in post assembly applications after the final torque has been achieved to help prevent vibration loosening.

AST-SEAL™ 91WS undergoes a chemical crosslinking only in the presence of metal and the absence of air. This is typically referred to as "curing". Curing begins right after assembly and reaches full cure in about 24 hours depending upon temperatures. In Colder Climates it may require more time and in Warmer Climates, less time. This ThreadSEALer is fluorescent under UV light for inspection purposes.

AST-SEAL™ 91WS works particularly well with softer more active metals such as Brass, Bronze, aluminum or steel. For Stainless Steel, Titanium, Alloys, plated fittings, fittings with a wide gap fill or if the material is being applied in very cold temperatures where a full cure is still needed then a primer may be required to ensure a full cure is achieved.

Cleaning

This product works best if the parts are clean and free of grease, oil, foreign material or old sealant. Normally cleaning with an appropriate solvent and / or wire brushing the parts to ensure they are clean is adequate preparation.

Application

AST-SEAL™ 91WS is normally applied by hand from the bottle directly to the part or assembly. For Fasteners you will need to have some threads exposed for the product to wick into the assembly. When you use it to seal porosity in castings or hairline cracks in parts, use a brush to work the Sealant into the part.

Storage and Shelf Life

For best results and a longer shelf life this product should be stored at moderate Temperatures under 80F. The shelf life is around 18 months if it is stored under these conditions. Storage at higher temperatures may shorten its shelf life or result in lower Prevailing Torque values

Typical Properties

Property	Value
Color	Green
Fixture Speed, no primer	10 minutes @ 76F
Fixture Speed with primer	We do not recommend using a primer
Full Cure Time	24 hr @ 70F
Typical Breakaway Strength	20 – 100 in. lbs
Typical Prevailing Strength	200 to 350 in lbs.
Viscosity	12 cps
Max. Operating Temp.	-65F to +300 F
MIL-S-46163	Type III, Grade R
RoHS	Compliant
Gap Fill	0.004"

Cautions

This product is not recommended for use in an oxygen system and not as a sealant for chlorine or other strong oxidizing materials. Read all information on labels and Safety Data Sheets prior to use. All products should be tested and evaluated for a particular purpose prior to use.

GHS compliant

[This product requires GHS pictograms on labels.](#)
[Refer to Label and SDS for GHS information.](#)

Product Limited Warranty

This information is based on information we believe to be reliable and accurate, but no guarantee of its accuracy is made for a particular application. We urge and recommend that Users pretest their application prior to incorporating the product into use and assume that the User will conduct such testing. Also see warranty statement on website.

Available In:

SIZE: 10 ml 50 ml 250 ml
P/N: 39911 39912 39913