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CASE MOUTH VARNISH

Product description

Bitumen based varnish, solvent based one-layer varnish.
Sealing between cartridge case neck and the bullet (case mouth sealing).

Properties:	air drying, drying time adjustable starting from 4min
Application:	sealing between cartridge case neck and the bullet (case mouth sealing) accordings NATO AEP-97
Colours:	black
Gloss:	glossy (DIN EN ISO 2813-2)
Packing units:	1, 2, 5, 10, 20 ,25 kg drums

Technical datas

Total solids:	40% (spraying); 50% (brushing)
Density / 20°C:	approx. 0,85 - 1,0 g/cm³
Viscosity:	30-50 sec DIN 4mm cup (DIN53211)
Flash point:	27 °C , 80 °F (DIN EN ISO 1523)
Temperatur resistance:	-55 °C to 220 °C (-67 °F to 428 °F)

Approved according:
NATO AEP-97
STANAG 4147
MIL-C-450
MIL-C-13783

Product USP

Drying time adjustable up from 4 min, long shelf life guarantee according NATO AOP-4172 chapter 19a and AEP-97 Vol 13 climatic storage test (-55 °C) passed all bullet pull-out strength tests (ISO10123) passed the watertightness test according AEP-97 for all calibre sizes

Special advices

Safety instruction: see material safety data sheet (MSDS)
Storage: when stored dry and cool, 1 year, closed drums longer

Contact us:
info@andre-industrial.com | +41 41 6110822

www.andre-industrial.com

PRIMER VARNISH

Product description

Solvent based nitrocellulose one-layer varnish.

Properties:	air drying within 3 minutes
Application:	sealing the primer groove
Colours:	red, green, blue, pink, clear, fluorescent as option for inline inspection
Gloss:	high gloss
Packing units:	1, 2, 5, 10, 20, 25 kg drums

Technical datas

Total solids:	24% (depending on colour, adjustable)
Density / 20°C:	approx. 0,9 g/cm³
Viscosity:	30-90 sec DIN 4mm cup (DIN53211)
Flash point:	-8°C - 50°C (DIN EN ISO 1523), 17 °F to 122 °F

Product USP

Drying time adjustable, long shelf life guarantee according NATO AOP-4172 chapter 19a and AEP-97 Vol 13 climatic storage test (-55 °C, -67 °F) passed the Watertightness test according AEP-97 for all calibre sizes. Different RAL colours and fluorecent for optical inline inspection.

Special advices

Safety instruction: see material safety data sheet (MSDS)
Storage: when stored dry and cool, 1 year, closed drums longer

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EXTERNAL SEALANTS

Product description

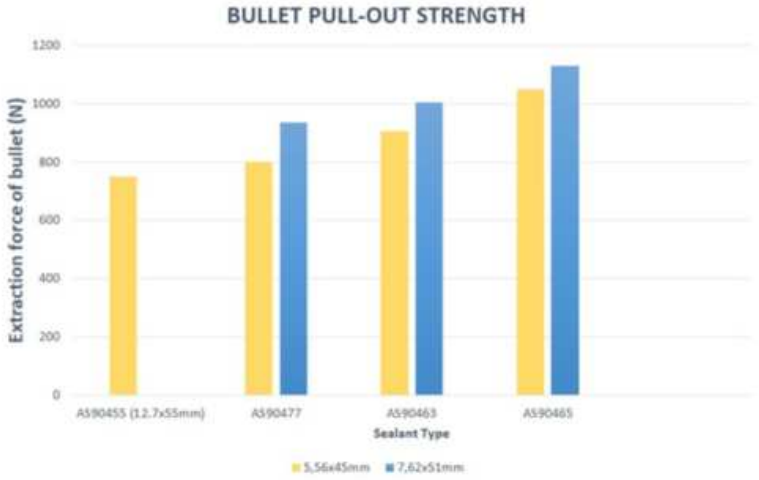
The external sealants from the Andre Industrial product range are designed to seal the projectile and primer from the outside. After the projectile is inserted, the annular gaps between the bullet and the case mouth are sealed using an anaerobic, UV-curing adhesive.

Key Considerations for Selecting the Ideal ammuntion external sealant:

When selecting the right sealant, there are critical criteria that are essential for optimal sealing of the projectile. There is a surface tension present between the different metal surfaces, which significantly affects the penetration of the sealant. Therefore, there are various sealant options that differ in the following ways:

1. The adhesive strength and the resulting bullet pull-out strength according to Nato AEP-97 (see diagram), which in turn affects the brittleness of the adhesive.
2. The viscosity and its associated property of better penetration into the gap. Smaller calibers, such as 5.56mm, require adhesives with lower viscosity to ensure complete sealing.
3. The surface tension of the different materials of the projectile and casing, as well as the cleanliness of the casings. In some cases, this surface tension must be broken to ensure uniform penetration of the adhesive (f.e. model AS90455, specifically designed for 0.50 BMG ammunition).

The following table will help you find the right adhesive for your application.



External Sealants

EXTERNAL SEALANTS

Technical datas

Colours:	red, green, blue, clear
Fluorescent:	Yes, blue under UV light for optical control
Drying:	anaerobic + UV-curing (365nm)
Drying time:	2-3 sec (5W/cm² LED lamp)
Anaerobic fixture time:	< 2 min (brass)
UV tack free time:	< 3 sec
Full strength time:	18 hours
Viscosity:	5-15 cP (mPas)
Surface tension:	26-29 mN/m
Temperature range:	-55 to 210°C (-65 to 410°F)
Specific gravity:	1.04
Hardness, Shore A ASTM D2240:	27-64

model for caliber size	application	bullet pull-out strenght	brittleness
AS90455N 12.7 mm	bullet sealing	medium	+
AS90465N up 7.62 mm	bullet sealing	very high	++
AS90463N all caliber	bullet + primer sealing	medium/high	++
AS90477 all caliber	bullet + primer sealing	medium	+
AS90100	blank ammo	seal the top of blank ammo	curing under the surface

Special advices

Safety instruction: see material safety data sheet (MSDS)
Storage: when stored dry and cool, 1 year, closed drums longer

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SEALING EQUIPMENT

Components

AdJet valve

- changeable dispensing nozzles
- control cable socket
- directly connectable to the PLC
- fast response time
- push fitting
- easy to clean with IPA
- easy to replace
- CE marking

AdJet controller

- 24VDC, 500mA
- cap rail 35
- control of 4 valves
- EMC interference resistance EN61000-6-2
- contacting by separable PCB connectors 4-pin screw connection
- CE marking

UV lamp

- 24VDC
- high power output 5W/cm² or 11W/cm²
- cures within 2 sec
- CE marking

Integration in existing machines

The individual sealing components allow for integration into existing systems. An independent PLC can be used without the need to interfere with existing controls.

before **after**

Sealing Equipment

Contact us:

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BLANK SEALANT

Product description

Blank ammo sealant has a higher viscosity, UV-curable compound formulated to provide high performance, fast curing and sealing of ammunition blank tips.
Dries even inside the sealant, not only on the surface.
5m distance paper witness test and burn-out test achieve perfect results. (tested on FN MAG and MINIMI)

Properties:
Application: sealing the blank top
Colours: red, green, blue, clear

Technical datas

Chemical Type:	Modified Acrylic Ester
Appearance:	Coloured, fluorescent
Viscosity:	600-800 cP (25°C)
Density:	1,01
Drying Time:	3-5 sec (tack-free)
Durometer Hardness:	70-80 Shore D

BLANK SEALANT

Product USP

The Andre Blank sealant cures very well even beneath the surface (up to 2.8mm). Standard UV lights (365nm with 5W/cm²) can be used.

Special advices

Safety instruction: see material safety data sheet (MSDS)
Storage: when stored dry and cool, 1 year, closed drums longer

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AMMUNITION TIP-ID

Product description

This system involves the marking of the tips of projectiles with specific colors or patterns to indicate the type of ammunition and its intended purpose. By understanding and recognizing these markings, users can ensure they are using the correct type of ammunition for their specific needs.

Properties:
Application: marking the top of bullets
Colours: all colours

Technical datas

Chemical Type:	Acrylate
Appearance:	Coloured
Viscosity:	600-800 cP (25°C)
Density:	1,01
Drying Time:	3-5 sec (tack-free)

Tip-ID

Product USP

A key advantage is the ability to adjust the necessary wavelength of the required UV light. (The standard is 365 nm). All colors can be produced.

Special advices

Safety instruction: see material safety data sheet (MSDS)
Storage: when stored dry and cool, 1 year, closed drums longer

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ANTIFRICTION VARNISH

Product description

Solvent based antifriction varnish.

Properties:	oven drying, 200°C for 20 min (390 °F)
Application:	exterior of steel or brass cartridges
Colours:	clear, glossy colours available
Gloss:	glossy
Packing units:	1, 2, 5, 10, 20, 25 kg drums

Technical datas

Total solids:	30-40%
Density / 20°C:	approx. 1,0 g/cm³
Viscosity:	25-30 sec DIN 4mm cup (DIN53211)
Flash point:	-27°C (DIN EN ISO 1523), 80 °F

Product USP

Some types of ammunition, such as the FN 5.7 mm rounds, are modified with a non-stick coating. This coating is applied to enhance the performance of the ammunition by reducing friction and improving feeding reliability in firearms. The non-stick finish helps prevent the buildup of residue and fouling, which can occur during firing. As a result, this modification can lead to smoother operation, increased accuracy, and easier maintenance of the firearm. The use of non-stick coatings in ammunition is part of ongoing advancements in ammunition technology aimed at improving overall efficiency and effectiveness.

Special advices

Safety instruction: see material safety data sheet (MSDS)
Storage: when stored dry and cool, 1 year, closed drums longer

Contact us:
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www.andre-industrial.com

STEEL CASE COATING

Product description

The external coating on steel ammunition serves practical purposes that enhance its performance, durability, and usability.
Corrosion resistance, improved handling, reduced friction and , aesthetic appeal.

Solvent based as one-layer or 2-C baking exterior varnish.

Properties: oven drying, high surface slip, anticorrosive, chemical resistance
Application: outside from steel cartridges
Colours: all colours

Technical datas

Total solids:	approx. 35-55%
Density / 20°C:	0,6 to 1,01 g/cm³
Viscosity:	30 - 75 sec adjustable DIN 4mm cup (DIN53211)
Temperatur resistance:	after drying through 250 °C short time stress 160 °C permanent stress

Application

Substrate pre treatment:	clean from dirt and dust
Application:	spraying, dipping, drum paint

Special advices

Safety instruction: see material safety data sheet (MSDS)
Storage: when stored dry and cool, 1 year, closed drums longer

Contact us:
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ANTIFRICTION VARNISH

Product description

Antifriction varnish for steel cartridges to reduce friction values and avoit material crack. Approved according TL8010.

Solvent based one-layer baking exterior varnish.
Properties: oven drying, high surface slip, anticorrosive, chemical resistance
Application: outside from phosphatiued steel cartridges
Colours: green, grey and many more
Gloss: flat / semi gloss

Technical datas

Total solids:	approx. 46%
Density / 20°C:	approx. 1,02 g/cm³
Viscosity:	50 - 60 sec DIN 4mm cup (DIN53211)
Flash point:	27°C
Temperatur resistance:	after drying through 250 °C short time stress 160 °C permanent stress

Application

Substrate pre treatment: clean from dirt and dust

Special advices

Safety instruction: see material safety data sheet (MSDS)
Storage: when stored dry and cool, 1 year, closed drums longer

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PRIMER LACQUER

Product description

Nitrocellulose based lacquer protect over the foil and anvil of ammunition primer after anvil seating operation.

Technical datas

Chemical Type:	Nitrocellulose lacquer
Appearance:	red, green
Solid:	30 -35 %
Viscosity:	40-50 cP
Drying Time:	3-5 minutes

MIL-L-46075A Lacquer
TT-T266D Thinner

Primer lacquer

Special advices

Safety instruction: see material safety data sheet (MSDS)
Storage: when stored dry and cool, 1 year, closed drums longer

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SEALING MACHINES

Table Sealing Machine

- Stand-alone for test trails
- Sealing of primer and bullet
- Product capacity 70 pcs/min
- Siemens PLC, micro tik support
- Remote access
- AdJet high precision valves
- 1.4x0.6x1.5 m, 130 kg
- CE marking and safety system

Dynamic Sealing Machine

- Product capacity 120 pcs/min
- Sealing primer and bullet by AdJet dispenser
- UV curing station
- Camery control
- Not OK eject station
- Siemens PLC
- CE marking

Primer Inserting + Sealing

- Primer inserting and sealing station
- carousel machine - two rotating tables sealing process
- 250 pcs/min, 125 pcs/min each station
- remote control PLC + Micro Tik support
- Siemens, Festo
- CE marking

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REFERENCES

- Nammo
- BAE Systems
- Baretta Group
- CSG
- Colt
- Rheinmetall
- CBC
- IMI
- Igman
- Edge Group
- Igman
- worldwide Ordnance factories
- and many more....

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