

# CS 3204 WT20 Weld Through Sealant

Chem Seal

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## PRODUCT DESCRIPTION

Meets MIS-31868C

CS 3204 WT20 is a fuel resistant faying surface weld through sealant for metal parts joined by resistance welding. The cured CS 3204 WT20 may be subjected to aircraft fuels, lubricants, oils, water and/or weathering.

CS 3204 WT20 is a two-part; polysulfide synthetic rubber compound with aluminum powder mixed in the base compound forming the conductive component. CS 3204 WT20 cures at room temperature to a flexible resilient rubber with excellent adhesion to aluminum, magnesium, titanium, steel, and numerous other materials.

## SURFACE PREPARATION

To obtain good adhesion, remove all traces of oil, wax, grease, dirt, or other contamination. The solvent blend selected should address the contamination present on the substrate to receive the sealing compound. The solvent blend should not leave a residue on the surface to which the sealing compound is to be applied.

## MIXING INSTRUCTIONS

CS 3204 WT20 Parts A and B are carefully matched at the time of manufacture to provide optimum performance during application and when cured. The container labels identify which part A to use with which Part B.

When material is supplied in 50 gallon drums or 5-gallon pails to be utilized with a Graco Hydra-mate (or equal) proportioning and dispensing machine, the mix ratio by volume is 8.3 parts curing compound to 100 parts of the conductive base compound. Prior to placing the curing agent pail on the dispensing equipment the curing agent should be stirred. The dispensing equipment manufacturer recommendations for correct operation of the equipment should be followed.

When material is hand mixed a ratio of 10 parts curing compound to 100 parts of the conductive base compound is used. The material should be mixed in a clean container alternately scraping down the sides to insure dispersion of the curing agent. Mix until a uniform aluminum color is obtained. The mixed material should be free of black streaks. The part B curing compound should be stirred before weighting out the necessary amount.

Typical Properties	MIS-31868C	CS 3204 WT20
Color:		
Base Compound		Aluminum
Curing Agent		Black
Mixed		Aluminum
Mixing Ratio:		
Weight	7.8/10:100	10/100
Volume	N/A	8.3/100
Non Volatile	75%	80%
Viscosity Mixed	100-180 PS.a	116 PS.a
Homogeneity	11.4% ± 2%	12.5%
Extrudability	Extrudable	Pass
Application Life	5 grams min.	90 grams
Squeeze Out	N/A	20 hours
Hardness (Shore A)		
120 Hrs. @24C ± 1C	35 (min.)	50 (min.)
28 days @24C ± 1C	50 (min.)	60 (min.)
Shelf Life @ 28C± 1C	6 months	6 months
Flash Point	N/A	+ 15C

For a complete description of product properties and characteristics, refer to the MIS-31868C

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## APPLICATION

Apply CS 3204 WT20 to a surface free of contaminants and oxides resistance welding may proceed immediately following application of the sealant. There is no maximum interval.

## CURE

Application and cure schedules are based on standard conditions of 77F and 50% RH. Increased temperatures and relative humidity will reduce the work life and accelerate the cure. Conversely lower temperatures and relative humidity will extend the work life and retard the cure. The cure may be accelerated at temperatures not exceeding 120F

## STORAGE LIFE

The storage life of CS 3204 WT20 is nine months when stored at temperatures below 80 deg. F in the original unopened containers. Some change in application life, viscosity, and curing rate may occur during this period. However, such changes are slight and in no way effect the end performance of the product.

## CLEANING OF EQUIPMENT

Tools and equipment may be cleaned prior to cure by use of solvent. Cured sealant may be removed from equipment by soaking and scrubbing with polysulfide/epoxy stripper.

## SAFETY

The Material Safety Data Sheet and product container label provided with CS 3204 WT20 describe the specific hazards if any associated with this product. Volatiles present in the sealant may persist for 20 hours. When required use local or area ventilation to disperse volatiles. It is the responsibility of the user to determine the suitability for use using the information contained in the applicable specification

## PACKAGING

CS 3204 WT20 is packaged in the following kit sizes:

- 4 ea. per case   Gallon Kit
- 1 each 5-gallon pail Kit
- 1 each 50 gallon drum Kit

All recommendations, statements, and technical data contained herein are based on tests we believe to be reliable and correct, but accuracy and completeness of said tests are not guaranteed and are not to be construed as a warranty, either expressed or implied. User shall rely on his own information and tests to determine suitability of the product for the intended use and user assumes all risk and liability resulting from his use of the product. Seller's and manufacturers sole responsibility shall be to replace that portion of the product of this manufacturer that proves to be defective. Neither seller nor manufacturer shall be liable to buyer or any third person for any injury, loss, damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements other than those contained in a written agreement signed by an officer of the manufacturer shall not be binding upon the manufacturer or seller.