

CS 3330 CI Low Adhesion Sealant non-chromate Corrosion Inhibiting

Chem Seal

*Technical Bulletin
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PRODUCT DESCRIPTION **Corrosion Inhibiting (Non Chromate)**

In accordance with AMS-3284 Type-2 Class A (Application times ½ hr or 2 hours) formerly AMS-3267

CS 3330CI is an access door sealant for integral fuel tanks and pressurized cabins, as a strippable fillet, and as a gasket for removable parts.

CS 3330CI is a two-part, polysulfide compound designed to seal faying surfaces where easy separation of joint surfaces is required. CS 3330CI cures by a chemical reaction at room temperature to a firm, flexible rubber. Cured CS 3330CI has low adhesion and forms a fuel resistant gasket that molds itself to fill all irregularities between two surfaces. Mixed material is a purple paste of brushable consistency. The cured sealant is resistant to aircraft fuels, lubricants, oils, water and weathering and remains flexible at low temperatures.

Color Mixed	Purple
Specific Gravity	1.50
Hardness, Shore A	50
Tensile Strength	200 psi
Elongation	400%
Weight loss	< 3%
Temperature Range	-65 deg. F to 250 deg. F
Fungus Resistance	Non-nutrient
Adhesion to Aluminum	1 lb/in. of width
Adhesion to other materials	Very Low adhesion to metals, coatings and porcelain / glass.
Resistance to Salt Water and Hydrocarbons	No evidence of softening, blistering or corrosion of metal under the sealant.
Low Temperature Flexibility	-65 deg. F

SURFACE PREPARATION

Remove all traces of oil, wax, grease, dirt, and other contamination, by wiping with clean oil free solvent. Clean only small areas at one time and wipe dry with a clean cloth before the solvent evaporates. Maintain a clean solvent supply.

MIXING INSTRUCTIONS

When mixing pre-packaged kits, the entire contents of base compound and curing agent should be used. For small quantities, mix 100 parts by weight of base compound to 17 parts by weight of curing agent. Curing agent and base compound are carefully matched in production for optimum performance characteristics. Care should be taken to assure that the curing agent packaged with a given base compound isn't separated and used with a different base compound. The lip of the base compound container should be removed to facilitate mixing. Next, stir the curing agent in its original container until it is homogenous. Add the curing agent to the base compound and mix thoroughly seven to ten minutes or until uniform in color. Scrape sides and bottom of the container to assure a complete mix. CS 3330CI may be mixed by hand or with a mechanical mixer. When using a mechanical mixer, use low speeds since high speeds will generate internal heat and reduce application life.

APPLICATION INSTRUCTIONS

CS 3330CI Class A may be applied with a brush or roller within the specified application life. Specified applications lives are based on the standard conditions of 77°F and 50% relative humidity. Higher temperatures will reduce the application life.

Chem Seal Products December, 15 2012
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CURE

The cure period is dependent on the application life, temperature, and relative humidity. Increased temperature and increased relative humidity will speed cure. Reduced temperature and reduced relative humidity will slow cure. Cure may be accelerated by heating up to 120°F.

STORAGE LIFE

The storage life of CS 3330CI is nine months when stored at temperatures below 80°F in the original 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 MEK/Toluene blend. Remove cured CS 3330CI by soaking in Methylene Chloride base stripper.

SAFETY

WARNING: CONTAINS FLAMMABLE AND VOLATILE SOLVENTS

Keep away from heat, sparks, and flame. Proper safety precautions used with flammable material must be taken when applying this product. Comply with all local safety regulations. "Flamemaster supplied aviation fuel tank sealant and coating materials are tested for compatibility with reference fluids and fuels as specified by the applicable specification. Flamemaster does not warranty the performance of fuel tank sealant or coatings subjected to fluids or fuels other than those specified by the applicable specification". "It is the responsibility of the user to determine the suitability for use utilizing the information contained in the applicable specifications".

Health Precautions

CS 3300CI Class A contains methyl ethyl ketone. The threshold limit value in air is 200 parts per million for safe working conditions. For additional health and safety information consult the Material Safety Data Sheet.

PACKAGING

CS 3330 CI is packaged in the following kit sizes:

24 ea. per case	2 1/2 oz. and 6 oz. cartridges
16 ea. per case	Pint Kits
16 ea. per case	Quart Kits
4 ea. per case	Gallon Kits

CS 3330CI is also available in 5-Gallon and 50 Gallon Drum Kits.

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, or 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.