

CS 3330 CI Low Adhesion Sealant non-chromate Corrosion Inhibiting

Chem Seal

Technical Bulletin
December, 2012

ACCESS DOOR SEALANT Class B

PRODUCT DESCRIPTION

AMS-3284 Class B2 Type-2 qualified (Formerly AMS-3267)

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

CS 3330 CI is a two-part, polysulfide compound designed to seal access areas where easy separation of joint surfaces is required. CS 3330 CI cures by a chemical reaction at room temperature to a firm, flexible rubber. Cured CS 3330 CI has low adhesion and forms a fuel resistant gasket that molds itself to fill all irregularities between two surfaces. Mixed CS 3330 CI is a red thixotropic paste which is easily applied with an extrusion gun or spatula, but will not flow from vertical or overhead surfaces.

The cured sealant is resistant to aircraft fuels, lubricants, oils, water, and weather and remains flexible at low temperatures.

SURFACE PREPARATION

To obtain uniform adhesion, remove all traces of oil, wax, grease, dirt, and other contamination. This is done by wiping with a 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

		<u>Typical Properties</u>	
Color Mixed		Purple	
Specific Gravity		1.50	
Hardness, Shore A		35	
Tensile Strength		200 psi	
Elongation		400%	
Weight loss		< 3%	
Temperature Range		-65 deg. F to 250 deg. F	
		<u>Typical Application Properties</u>	
	application	tack free	Shore A 30
B 1/2**	1/2 hour	8 hour	16 hour
B 2	2 hour	18 hour	30 hour
		<u>Cured Material</u>	
Fungus Resistance		Non-nutrient	
Adhesion to Aluminum		1 lb/in. of width	
Adhesion to other materials		Very Low adhesion to metals, coatings, porcelain and 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	
Corrosion mixed metal assembly		Pass	
Application and performance properties are typical all tests conducted under controlled conditions. Reference AMS3284 and AS5127 – AS5127/1 for requirements and procedures. **CS3330CI B1/2 meets the requirement of AMS3284 type-2			

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1 of 2

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bottom of the container to assure a complete mix. CS 3330 CI 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

CS 3330 CI may be applied with pressure gun or a spatula within the specified application life. Specified applications lives are based on the standard condition of 77°F and 50% relative humidity. Higher temperatures will reduce the application life. Lower temperatures will extend application life.

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. Accelerate cure by heating up to 120 deg. F.

STORAGE LIFE

The storage life of CS 3330 CI is nine months when stored at temperatures below 80 deg. 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

Clean tools and equipment prior to cure by using Methylene Chloride based strippers. Cured CS 3330 CI may be by soaking in a Methylene Chloride Base Stripper.

SAFETY

CS 3204R sealant is a safe material to use when following recommended precautions. Refer to the applicable Material Safety Data Sheet prior to using this product. CS 3330 CI is lead free.

AVAILABILITY

CS-3330CI Class B is available as two-part Injection cartridges, metal cans and Pre-mixed and frozen cartridges. For availability of other packaging contact Flamemaster.

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 test 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 liability resulting from his use of the product. Sellers and manufacturers sole responsibility shall be to replace that portion of the product of this manufacturer which proves to be defective. Warranty returns accepted only in their original unopened containers no warranty claims accepted for goods repackaged or altered. Neither seller nor manufacturer shall be liable to the 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. Flamemaster does not warranty the performance of fuel tank sealants and coatings subjected to fluids or fuel 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 specification.