

CS 3330 Access Door Sealant

Chem Seal

Technical Bulletin
May, 2008

PRODUCT DESCRIPTION Class-B AMS-3284 Type-I (formerly Mil-S-8784B)

CS 3330 is 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 is a two-part, polysulfide compound designed to seal access areas where easy separation of joint surfaces is required. CS 3330 cures by a chemical reaction at room temperature to a firm, flexible rubber. Cured CS 3330 has low adhesion and forms a fuel resistant gasket that molds itself to fill all irregularities between two surfaces. Mixed, CS 3330 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 10 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 3330 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 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

Color Mixed	Red
Specific Gravity	1.33
Hardness, Shore A	50
Weight Loss	< 5%
Tensile Strength	200 psi
Elongation	400%
	Cure to Shore A 20
B 1/2	10 hour
B 2	24 hour
Temperature Range	-65 F to 225 F
Fungus Resistance	Non-nutrient
Adhesion to Aluminum	1 lb/in. of width
Adhesion to other materials	Very Low adhesion to steel, stainless steel, chromium, zinc, copper, Titanium, magnesium, tin, lead, enamel, porcelain and glass.
Resistance to Salt Water and Hydrocarbons	No evidence of softening, blistering or corrosion of metal under the sealant.
Low Temp Flexibility	-65 deg. F Pass

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Manufactured By The Flamemaster Corporation 1 of 2
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supercedes January, 2006

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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. Cure may be accelerated by heating up to 120 °F.

STORAGE LIFE

The storage life of CS 3330 is twelve 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 Methylene Chloride. Cured CS 3330 may be removed by soaking in a Methylene Chloride Base Stripper.

SAFETY

CS 3330, Class B has not been found to have any toxic effect in normal usage. However, because some individuals may be sensitive to chemicals used in the manufacturing of the curing agent, excessive contact should be avoided. CS 3330 contains manganese in the curing agent. CS 3330 is lead free.

"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".

PACKAGING

CS 3330 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 3330 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 the use of this product. Seller's and manufacturer's sole responsibility shall be to replace that portion of the product of this manufacturer which 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.