CS 3330 Access Door Sealant

Chem Seal

Technical Bulletin
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PRODUCT DESCRIPTION AMS-3284 Class-A 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 faying surfaces 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 paste of brushable consistency. The cured sealant is resistant to aircraft fuels, lubricants, oils, water, and weather and remains flexible at low temperatures.

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	
A 1/2	10 hour
A 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

SURFACE PREPARATION
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 INSTRUCTIONS
CS 3330 Class A may be applied with a brush or roller 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.

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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 3330 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 not way effect the end performance of the product.

CLEANING OF EQUIPMENT

Tools and equipment may be cleaned prior to cure by use of Methylene Chloride. Cured CS 3330 may be removed 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.

Health Precautions

CS 3330 Class A is a safe material to handle when reasonable care is observed. Always wash hands before eating or smoking. Use adequate ventilation. Obtain medical attention in cases of extreme exposure or ingestion. CS 3330 contains Manganese in the curing agent. CS 3330 is lead free. CS 3300 Class A contains methyl ethyl ketone. The threshold limit value in air is 200 parts per million for safe working conditions. Use adequate ventilation or air-supplied respirators during application. Avoid repeated or prolonged breathing of vapors. In cases of extreme vapor exposure, remove affected personnel to fresh air immediately and obtain medical attention. For additional health and safety information consults a Material Safety Data Sheet which is available upon request.

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.

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