

CS 3600 Top Coat and High Bond Strength Adhesive

Chem Seal

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PRODUCT DESCRIPTION meets MIL-S-4383C

CS 3600 is a one-part high bond strength adhesive, which finds application in a wide variety of purposes, especially where resistance to oils, gasoline, aromatic fuels and corrosion is desired.

Most materials such as synthetic rubber, metals, glass and plastics can be bonded very effectively using this adhesive.

CS3600 is also used as a topcoat for polysulfide sealants in aircraft integral fuel tanks.

APPLICATION

The surfaces to be bonded or coated should be clean, dry and free from oil, dirt, grease and fuel residue.

When using CS 3600 as a tank coating the material may be brushed over the areas scheduled to receive the top coating. For smaller tanks a fill and drain procedure may be used. After cleaning the tank is filled with a quantity of CS 3600 and the tank rotated until all surfaces to receive the coating are covered, the excess is then drained back into the container. Allow four days for room temperature cure.

For bonding applications a thin even coat of CS 3600 is brushed onto each surface of the material to be bonded. If the surface is very porous more than one coat may be necessary in which case a drying time of 10 minutes is allowed between coats.

Bonding is accomplished by allowing the adhesive to dry to a tacky condition and then joining the surfaces and pressing or rolling firmly together to insure intimate contact. Bonding can also be accomplished by solvent reactivation or heat reactivation. (Tack is the condition when the adhesive adheres to the finger but is not transferred to the finger when touched.)

SOLVENT REACTIVATION

CS 3600 is allowed to dry until completely tack free. Wiping with a rag dampened in a low boiling point ketone solvent then moistens the surfaces, and the surfaces are bonded together as described above.

HEAT REACTIVATION

CS 3600 is allowed to dry until completely tack free. The surfaces to be bonded are then joined together applying sufficient pressure to maintain good contact, followed by heating in an oven at 250° F to 300° F. The assembly to remain clamped until cooling to room temperature.

Color	Red or Amber
Base	Oil resistant synthetic rubber
Consistency	Thin syrup
Solids	20%
Specific gravity	0.88
Temperature resistance	-100° F +250° F
Shear strength	150 psi
Peel strength	10 lbs./ inch

CS 3600 Top Coat and High Bond Strength Adhesive

STORAGE LIFE

The storage life of CS 3600 is one-year minimum when stored at temperatures below 80°F in the original unopened containers. Some change in viscosity may occur during this period; however, such changes are slight and in no way affect the end performance of the product.

SAFETY

Flamemaster supplied aviation and fuel tank sealants and coating materials are tested for compatibility with reference fluids and fuels as specified by the applicable specification. Flamemaster does not warrant the performance of fuel tank sealants or coatings when subjected to fuels or fluids other than those specified by the applicable specification.

WARNING

CS 3600 contains a volatile flammable solvent. Containers should be kept away from heat and open flame and should be kept closed when not in use. Refer to the applicable Material Safety Data Sheet prior to use

PACKAGING

CS 3600 is packaged in Pint, Quart, Gallon, 5 Gallon, and 50 Gallon containers

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 risk and liability resulting from his use of the 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 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