flamemaster
SOCOMORE Aerospace Sealants

SHIMS & SEALANTS

CS 3206 Class B

Technical Data Sheet

QUICK REPAIR FUEL RESISTANT SEALANT

Description

CS 3206 was originally designed for quick repair of fuel tanks and cabin pressure fuselage sealing. Due to its ability to cure at temperatures as low as 20°F (-13°C), it is suitable for multiple other commercial applications. Available in both Class B and Class A

- Two-part, manganese dioxide cured polysulfide
- Cures down to -20°F (-13°C).
- Excellent adhesion to aluminum, steel, and a variety of other aircraft substrates
- Cured material has a service temperature range of -65°F to 250°F (-54°C to 121°C).
- Uncured CS 3206 Class B is a thixotropic (low sag) material easily applied with an extrusion gun or spatula.
- Uncured CS 3206 Class A is a lower viscosity, self-leveling material due to its higher solvent content and is easily applied with a brush.
- CS 3206 Class A and B are tested to the acceptance requirements of AMS-S-83318 but are not on the QPL.

The following technical information and data are typical for the material but should not be used for specification or acceptance purposes. Testing was performed in accordance with AS5127/1.

Typical Performance Properties

Cured 14 days at 77°F (25°C) and 50% relative humidity

Specific gravity	1.6
Ultimate hardness	45A
% Nonvolatile material	89%, Class A 95%, Class B
Low temperature flexibility at -65°F (-54°C)	No defects, cracking or checking
Fluid immersed cure	34A at 6 hours 40A at 24 hours
Peel strength on AMS-C-27725 panels after 7 days in 50:50 AMS2629 Type 1:3% salt water at 140°F (60°C)	Fuel: 37 pli (162 N/25 mm) Salt water: 37 pli (162 N/25 mm) All 100% cohesive failure

Typical Application Properties

At 77°F (25°C) and 50% relative humidity

Color	
Base	Off-white
Curing agent	Black
Mixed	Gray
Mix ratio	
By weight	100:17 (base/curing agent)
Base viscosity (Class A) (Brookfield #7@ 10 rpm)	1,000 – 4,000 Poise (100 – 400 Pa·s)
Base viscosity (Class B) (Brookfield #7@ 2 rpm)	9,000 – 14,000 Poise (900- 1400 Pa·s)
Slump (Class B)	< 0.2" (5 mm)

	Minimum application time	Extrusion rate at application time (g/min)	Tack-free time (hours)	Cure time to 30A (hours)
A-1/6	10 minutes	100, minimum	< 3	< 8
B-1/6	10 minutes	50 – 100	< 3	< 8

Surface Preparation

To obtain good adhesion, surfaces must be free of all traces of oil, wax, grease, dirt or other contaminants. A progressive cleaning process is recommended. Use an appropriate solvent and lint-free clothes. Pour solvent on the cloth to keep the solvent supply clean. Clean a small area at a time and wipe the surface dry with a second clean cloth. See SAE AIR 4069 for additional information on surface preparation. For Socomore's full line of solvents and wipes used for aerospace sealant preparation, and their customer approvals, visit www.Socomore.com.

Storage

Unmixed CS 3206 has a shelf life of at least 9 months from date of packaging when stored below 80°F or below in the original, unopened package. Refrigerated shipping is not required, but storage above this temperature typically affects application properties before performance properties.

Mixing Instructions

CS 3206 base and curing agents are matched and tested together; do not mix lots. Mix according to the indicated mix ratios; using the incorrect ratio can affect the sealant properties and voids the warranty. Do not thin the material with solvents. For additional information, see the FAQ on the Flamemaster website (www.flamemaster.com).

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Curing

The application, tack-free, and cure times are based on the standard conditions of 77°F (25°C) and 50% relative humidity. For information on the effects of temperature and humidity, as well as information on accelerated curing, see the FAQ on the Flamemaster website (www.flamemaster.com).

Clean up

Cured aerospace sealants are difficult to remove. Cleaning tools and other surfaces is best done when the material has not yet cured. For fresh material and tool cleaning use an appropriate solvent and lint-free cloth. Once the material has cured, use an approved chemical and/or plastic scraper to remove the sealant. For Socomore's full line of solvents, wipes, chemical sealant removers (SkyRestore), plastic scrapers (SkyScraper), and their customer approvals, visit www.Socomore.com.

Packaging

CS 3206 B is available in injection kits and can kits. Bulk packaging may be available; contact Sales.

Health and Safety

CS 3206 is safe to use and apply when the recommended precautions are followed. Before using this material, read and understand the Safety Data Sheet (SDS) as it includes information on health, physical, and environmental hazards, as well as handling precautions and first aid recommendations. SDSs are available upon request.

Emergency Contact Chemtrec 800-424-9300
Outside North America 703-527-3887
Keep out of the reach of children
For industrial use only

Warranty, Limited Remedy, and Disclaimer

All recommendations, statements, and technical data contained herein are based on tests or experience that we believe to be reliable and correct, but accuracy and completeness of such information are not guaranteed and are not to be construed as a warranty, either expressed or implied. Flamemaster does not warranty the performance of fuel tank sealants or coatings when subjected to fluids or fuels other than those specified by the applicable specification.

Users shall rely on their own information and tests to determine suitability of the product for the intended use and users assume all risk and liability resulting from their 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 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.

Rev. June 28, 2024

This technical data sheet replaces and cancels the previous one.