

CS 3330 CI Class B

Technical Data Sheet

LOW ADHESION SEALANT COMPOUND WITH NON-CHROMATE CORROSION INHIBITOR

Description

CS 3330 CI Class B is a low adhesion sealing compound designed for removable panels and fuel tank inspection plates. CS 3330 CI Class B can be used for sealing aircraft access doors and accessories where gaskets are required.

- Two-part, manganese dioxide cured polysulfide
- Contains a corrosion inhibitor
- Room temperature cure
- Low adhesion for removable panels
- Excellent flexibility and resistance to jet fuels
- Cured material has a service temperature range of -65°F to 250°F (-54°C to 121°C).
- Uncured CS 3330 CI Class B is a thixotropic (low sag) material easily applied with an extrusion gun or spatula.
- CS 3330 CI B-1/2 and B-2 are qualified to SAE AMS3284, which superseded MIL-S-8784.

For information on other qualifications or the availability of modified products, contact Sales.

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 SAE AMS3284.

Typical Performance Properties

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

Specific gravity	1.41
Ultimate hardness	46A
% Nonvolatile material	98%
Resistance to heat: 72 hours at 250°F (121°C) after immersion in AMS2629 Type 1	No softening, sponging, checking or cracking
Weight loss after AMS 2629 Type 1; flexibility	2.6 %; no cracking or checking
Low temperature flexibility at -65°F (-54°C)	No defects, cracking or checking
Corrosion with mixed metal assembly after 4 weeks in SO ₂ salt spray	No corrosion with aluminum/titanium couple
	No corrosion with aluminum/magnesium couple

Typical Application Properties

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

Color	
Base	Red
Curing agent	Brown/black
Mixed	Dark red/purple
Mix ratio	
By weight	100:17 (base/curing agent)
Base viscosity (Brookfield #7@ 2 rpm)	12,000 Poise (1200 Pa·s)
Slump	< 0.2" (5 mm)

	Minimum application time	Extrusion rate at application time (g/min)	Tack-free time (hours)	Cure time to 30A (hours)
B-1/2	30 minutes	40 - 100	7 - 8	< 24
B-2	2 hours	40 - 90	20 - 24	< 48

Peel strength

First value is pli; second value is N/25 mm All have 98% minimum adhesive failure Low adhesion products are expected to have a peel strength of less than 4 pli (17.4N/ 25 mm) and 98% minimum adhesive failure After 48 hours in JRF (AMS2926 Type 1) at 77°F (25°C)	
Aluminum (AlClad, AMS4049)	< 2 pli; <9 N/25 mm
Stainless steel (AMS 5516)	< 2 pli; <9 N/25 mm
Titanium (AMS 4911)	< 2 pli; <9 N/25 mm
Sulfuric acid anodized (AMS4045)	< 2 pli; <9 N/25 mm
After 48 hours in distilled water at 77°F (25°C)	
MIL-PRF-23377	< 2 pli; <9 N/25 mm

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 3330 CI Class B 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 3330 CI Class B 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).

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 3330 CI Class B is available in injection kits and can kits. Bulk packaging and premix frozen (PMF) may be available; contact Sales.

Health and Safety

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. December 03, 2024

This technical data sheet replaces and cancels the previous one.

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