

CS 3213 Class A

CORROSION INHIBITIVE SEALANT

Technical Data Sheet

Description

CS 3213 Class A aerospace sealant was designed for sealing metal components on aircraft systems for protection against corrosion. It acts as a barrier between dissimilar metals as well as protecting aluminum alloys against corrosion and is typically used for sealing faying surfaces and sealing joints.

- Two-part, manganese dioxide cured polysulfide
- Room temperature cure
- Contains chromate as a corrosion inhibitor
- Excellent adhesion to a wide variety of coated and bare aircraft substrates
- Excellent flexibility and resistance to fuel, water, and other aerospace fluids
- Cured material has a service temperature range of -65°F to 250°F (-54°C to 121°C)
- Uncured CS 3213 Class A is a lower viscosity, self-leveling material due to its higher solvent content and is easily applied with a brush
- CS 3213 A-1/2 and A-2 are qualified to STM40-111.

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 STM40-111 or A5127/1.

Typical Performance Properties

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

Specific gravity	1.55, maximum
Ultimate hardness	35 - 45A
% Nonvolatile material	84% minimum
Thermal stability - After 48 hours at 320°F (160°C), compare original and final hardness	Pass - hardness difference 5A - 15A
Low temperature flexibility at -65°F (-54°C)	No cracking, or loss of adhesion
Peel strength, Alodine, dry CS 3213 C-12	15 - 25 pli 65 - 110 N/25 mm 100% CF
Peel strength, AMS-C-27725, dry CS 3213 C-12, C-48	15 - 20 pli 65 - 90 N/25 mm 100% CF
Corrosion resistance per STM40-111	Pass

Typical Application Properties

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

Color	
Base	Off-white
Curing agent	Black
Mixed	Dark gray
Mix ratio	
By weight	100:17 (base/curing agent)
Base viscosity (Brookfield #6@ 2 rpm)	400 - 500 Poise (40 - 50 Pa·s)

	Minimum application time (hours)	Tack-free time (hours)	Cure time to 35A (hours)
A-1/2	30 minutes	8 - 10	< 48
A-2	2 hours	20 - 40	< 72

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 3213 Class A 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 3213 Class A 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 3213 Class A 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

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This technical data sheet replaces and cancels the previous one.

The above details have been compiled to the best of our knowledge. They have, however, an indicative value only and we therefore make no warranties and assume no liability in connection with any use of this information, particularly if a third party's rights are affected by the use of our products. The above information has been compiled based upon tests carried out by SOCOMORE. All data is subject to change as SOCOMORE deems appropriate. The data given is not intended to substitute for any testing you must conduct in order to determine the suitability of the product for your particular purposes. Pictures are not contractual. Please check your local legislation applicable to the use of this product. Should you need any further information please contact us.