SEALPAK Company, Inc.
2301 N. HOOVER (316) 942-6211
WICHITA, KANSAS 67205

FLAMEMASTER CORP./CHEM SEAL DIV.

TECHNICAL BULLETIN

CS3204 CLASS A AND CLASS B AIRCRAFT FUEL TANK SEALANT

PRODUCT DESCRIPTION – meets AMS-S-8802, Type II

CS3204 is a fuel resistant sealant for use on integral fuel tanks and pressurized cabins as well as other areas subject to contact with aircraft fuels, lubricants, oils, water and/or weathering.

CS3204 is a two-part polysulfide base compound which cures at room temperature to a flexible, resilient rubber with excellent adhesion to aluminum, magnesium, titanium, steel, and numerous other materials. CS3204 is designed to withstand the attack of sulphur compounds that are present in jet fuels. When mixed, CS3204 Class A is a self-leveling liquid. CS3204 Class B is a thixotropic paste that will not flow or sag on vertical or overhead surfaces.

	Class A	Class B
COLOR		
PART A:	**Off-White**	**Off-White**
PART B:	**Black**	**Black**
MIXED:	**Gray**	**Gray**
MIXING RATIO		
BY WEIGHT:	**100:10**	**100:10**
BY VOLUME:	**100:8.3**	**100:8.3**
NON VOLATILE CONTENT:	**86%**	**96%**
VISCOSITY – PART A		
(Brookfield RVF – Spindle # 6 @ 10 RPM):	**250 Poises**	**11,000 Poises**
(Brookfield RVF – Spindle #7 @ 2 RPM):		
VISCOSITY – PART B		
(Brookfield RVF – Spindle #7 @ 10 RPM):	**1,000 Poises**	**1,000 Poises**
VERTICAL FLOW:	**N/A**	**0.30**
ULTIMATE HARDNESS, SHORE A:	**50**	**50**

(FOR COMPLETE DESCRIPTION OF PROPERTIES REFER TO MIL-S-8802 SPECIFICATION)

Application And Performance Properties – Typical

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SURFACE PREPARATION

To obtain good adhesion, the surfaces must be free of all traces of oil, wax, grease, dirt or other contamination. Working in small area segments, wipe the surface using a clean rag doused in an oil free solvent. Before the solvent evaporates, wipe the surface dry with a second clean rag. Maintain a clean solvent supply by pouring the solvent on the washing cloth. CS3204 will adhere tenaciously to most substrates providing the surface to be sealed is clean and sound.

MIXING INSTRUCTIONS

CS3204 Parts A and B are carefully matched at the time of manufacture to provide optimum performance when cured. Care should be taken to assure that Parts A and B are combined as recommended on the container label. When mixing pre-measured kits do not thin CS3204 with solvents. Prior to combining with Part A, stir Part B until the contents of the container are uniform. Place all of Part B into Part A container and continue stirring until a uniform gray color is achieved. There should be no white or black streaks in the properly blended material. Periodically scrape the sides and bottom of the container as well as the mixing tool to assure proper mixing. When using a mechanical mixer, avoid high speeds since the heat generated will reduce the application life of the mixed CS3204. Violent stirring will also entrap air in the cured sealant.

When mixing materials packaged in bulk or when only a small quantity is required, stir 10 parts by weight of Part B into 100 parts by weight of Part A. Be sure to stir Part B prior to weighing out the required amount.

APPLICATION

The work life of CS3204 is indicated by the number following the class designation and varies from ½ hour to four hours. Work life is the minimum amount of time the material will maintain its application properties.

Work Life	Application Life	Tack Free Time	Curing Rate To 35 Shore A
½	½ Hour	8 Hours	30 Hours
2	2 Hours	24 Hours	72 Hours
4	4 Hours	36 Hours	90 Hours

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CURE

Specified application and cure schedules are based on the standard conditions of 77F and 50% relative humidity. Increased temperature and relative humidity will reduce the work life and speed up the cure while reduced temperatures and relative humidity will extend the work life and slow the cure. Cure may be accelerated by heating up to 100F. However, care must be exercised to avoid the entrapment of solvent when heat is applied.

STORAGE LIFE

The storage life of CS3204 is nine months when stored in the original unopened containers at temperatures below 80F. Some changes in work life, viscosity and curing time may occur during this period. However, such changes are slight and in no way affect the end performance of the product.

CLEAN UP

For surface preparation as well as removing fresh or cured CS3204, Methylene Chloride can be used. Cured CS3204 will require a soaking period in Methylene Chloride base stripper for satisfactory removal.

SAFETY

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

"It is the responsibility of the user to determine the suitability for use utilizing the information contained in the applicable specification."

PACKAGING – CS3204 is packaged in the following Kit sizes:

2 ½ oz. and 6 oz. Cartridges	**50 Ea. Per Case**
Half Pints or Half Pint Kits	**25 Ea. Per Case**
Pints or Pint Kits	**12 Ea. Per Case**
Quarts or Quart Kits	**6 Ea. Per Case**
Gallons or Gallon Kits	**4 Ea. Per Case**

Also available in 5-Gallon Pails and 50-Gallon Drums

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Refer to the applicable Material Safety Data Sheet prior to using this product.

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 tests 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 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.

PRICE LIST – QUOTE

CS3204 B1/2, B2, B4 FUEL TANK SEALANT – AMS-S-8802

½ Pint Kit – (6 oz.)	1 to 24	=	$14.00/Ea.	1 Oz. Jar Kit @ $5.00/Ea.
	25 to 49	=	13.00/Ea.	(35 Gr. Base Net)
	50+	=	12.00/Ea.	(3.5 Gr. Accel. Net)
½ Pint – (8 oz.)	1 to 24	=	18.00/Ea.	2 Oz. Jar Kit @ $6.00/Ea.
	25 to 49	=	17.00/Ea.	(70 Gr. Base Net)
	50+	=	16.00/Ea.	(7.0 Gr. Accel. Net)
Pint Kit – (12 oz.)	1 to 11	=	24.00/Ea.	4 Oz. Jar Kit @ $8.00/Ea.
	12 to 132	=	23.00/Ea.	(85 Gr. Base Net)
	133+	=	22.00/Ea.	(8.5 Gr. Accel. Net)
Pint – (16 oz.)	1 to 11	=	32.00/Ea.	
	12 to 132	=	31.00/Ea.	
	133+	=	29.00/Ea.	
Quart Kit – (24 oz.)	1 to 5	=	43.00/Ea.	
	6 to 66	=	41.00/Ea.	
	67 to 234	=	38.00/Ea.	
Quart – (32 oz.)	1 to 5	=	57.00/Ea.	
	6 to 66	=	54.00/Ea.	
	67 to 234	=	51.00/Ea.	
Gallon Kit – (96 oz.)	1 to 3	=	145.00/Ea.	
	4 to 44	=	139.00/Ea.	
	45 to 156	=	132.00/Ea.	
Gallon – (128 oz.)	1 to 3	=	194.00/Ea.	
	4 to 44	=	184.00/Ea.	
	45 to 156	=	175.00/Ea.	
2 1/2 Oz. Sealkit – (2 oz.)	1 to 24	=	17.00/Ea.	
	25 to 99	=	15.00/Ea.	
	100+	=	12.00/Ea.	
6 Oz. Sealkit – (5 oz.)	1 to 24	=	20.00/Ea.	
	25 to 99	=	19.00/Ea.	
	100+	=	16.00/Ea.	

TERMS: CREDIT CARD, COD OR NET 30 W.A.C.
F.O.B.: WICHITA, KANSAS
DELIVERY: STOCK ITEMS

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