

Technical Data Sheet

Aerospace Sealants



PR-2001 Class B rapid curing fuel tank sealant

Description

PR-2001 Class B is a rapid cure, low odor, aircraft integral fuel tank, fuselage and aerodynamic smoothing sealant. It has a service temperature range from -80°F (-62°C) to 320°F (160°C), with intermittent excursions up to 420°F (216°C). This material is designed for fillet sealing of fuel tanks and other aircraft fuselage sealing applications. The cured sealant maintains excellent elastomeric properties after prolonged exposure to both jet fuel and aviation gas.

PR-2001 Class B is a two-part, epoxy cured PERMAPOL® P-3.1 polythioether compound. The uncured material is a low sag, thixotropic paste, suitable for application by extrusion gun or spatula. Unlike standard polysulfide fuel tank sealants, it can cure at low temperatures and is unaffected by changes in relative humidity. This sealant has excellent adhesion to properly prepared common aircraft substrates.

The following tests are in accordance with AMS 3277 Type II, Class B specification test methods.

Application properties (typical)

Color			
Part A		Black	
Part B		White	
Mixed		Lt Gray	
Mixing ratio		Part A:Part B	
By weight		18.5:100	
Base viscosity			
(Brookfield #7 @ 2 rpm), Poise (Pa-s)		13,700 (1370)	
Slump, inches (mm)			
Initial		50 Minutes	90 Minutes
B-1/20.10 (2.54)		---	---
B-2 0.10 (2.54)		0.10 (2.54)	0.10 (2.54)
Initial		120 Minutes	210 Minutes
B-4 0.10 (2.54)		0.10 (2.54)	0.10 (2.54)

Application life and cure time @ 77°F (25°C), 50% RH

	Application life (hours)	Tack free time (hours)	Cure time to 30 A Durometer (hours)
B-1/2	1/2	<2	3
B-2	2	<8	9
B-4	4	<24	24
@ 50°F (10°C), 50% RH			
B-1/2	1/2	4	4

Performance properties (typical)

Cured 7 days @ 77°F (25°C), 50% RH	
Cured specific gravity	1.45
Nonvolatile content, %	98
Ultimate cure hardness, Durometer A	48
Peel strength, pli (N/25 mm), 100% cohesion	
AMS 2629 Type I Fuel immersion, 7 days @ 140°F (60°C)	
AMS 2471 (Anodized aluminum)	39 (173)
AMS 4901 (Titanium*)	40 (177)
AMS 5516 (Stainless steel*)	41 (182)
AMS 4901 (Titanium)	32 (142)
AMS 5516 (Stainless steel)	38 (169)
MIL-C-5541 (Alodine aluminum)	40 (177)
MIL-C-27725 (IFT coating)	41 (182)
AMS 2629 Type I Fuel immersion with 3%NaCl-H ₂ O, 7 days @ 140°F (60°C)	
AMS 2471 (Anodized aluminum)	44 (196)
AMS 4901 (Titanium*)	45 (200)
AMS 5516 (Stainless steel*)	45 (200)
AMS 4901 (Titanium)	39 (173)
AMS 5516 (Stainless steel)	44 (196)
MIL-C-5541 (Alodine aluminum)	40 (177)
MIL-C-27725 (IFT coating)	42 (187)
3% NaCl-H ₂ O immersion, 7 days @ 140°F (60°C)	
MIL-PRF-85582 (Epoxy coating)	45 (200)
MIL-PRF-85285 (Urethane coating*)	44 (196)
MIL-PRF-85285 (Urethane coating)	53 (236)
MIL-PRF-23377	44 (196)
*Primed with AMS 3100 Adhesion Promoter	
Tensile strength, psi (KPa)	
Standard cure, 7 days @ 77°F (25°C), 50% RH	407 (2804)
Standard heat cycle	434 (2990)
Elongation, %	
Standard cure, 7 days @ 77°F (25°C), 50% RH	268
Standard heat cycle	262
Volume shrinkage, %	
Standard cure + 48 hours at 185°F (85°C)	<0.7
Thermal rupture resistance - Retains pressure of 10 psi with only negligible deformation, both before and after immersion in AMS 2629 Type I Fuel.	
Low temperature flexibility @ -65°F (-54°C) - No cracking, checking or loss of adhesion.	
Corrosion resistance - No corrosion, adhesion loss, softening, or blistering after immersion in 2-layer 3% NaCl-H ₂ O/AMS 2629 Type I Fuel/vapor after 12 days @	

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140°F (60°C) + 60 hours @ 160°F (71°C) + 6 hours @ 180°F (82°C).

Resistance to hydrocarbons - 7 days @ 140°F (60°C) immersed in AMS 2629 Type I Fuel+ 24 hrs @ 120°F (49°C) in air.

Weight loss, % 3.4

Flexibility - 7 days @ 140°F (60°C) immersed in AMS 2629 Type I Fuel+ 24 hrs @ 120°F (49°C) in air. No cracks after bending 180 degrees over 0.125 (3.18 mm) mandrel.

Repairability to itself - Excellent to both freshly cured as well as fuel aged and abraded fillets.

Repairability to polysulfide (AMS-S-8802) - Excellent to both freshly cured as well as fuel aged and abraded fillets when primed with PR-187 adhesion promoter.

Resistance to other fluids - Excellent resistance to water, alcohols, petroleum-base and synthetic lubricating oils, and petroleum-base hydraulic fluids.

Shaving and sanding - No rolling or tearing.

Note: The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.

Surface preparation

Immediately before applying sealant to primed substrates, the surfaces should be cleaned with solvents. Contaminants such as dirt, grease, and/or processing lubricants must be removed prior to sealant application. A progressive cleaning procedure should be employed using appropriate solvents and a new lint-free cloth conforming to AMS 3819. (Reclaimed solvents or tissue paper should not be used.) Always pour solvent on the cloth to avoid contaminating the solvent supply. Wash one small area at a time.

It is important that the surface is dried with a second clean cloth prior to the solvent evaporating to prevent the redeposition of contaminants on the substrate.

For repair applications over polysulfide sealants the use of PR-187 adhesion promoter is highly recommended.

Substrate composition can vary greatly. This can affect sealant adhesion. It is recommended that adhesion characteristics to a specific substrate be determined prior to application on production parts or assemblies.

For a more thorough discussion of proper surface preparation, please consult the SAE Aerospace Information Report AIR 4069. This document is available through SAE, 400 Commonwealth Avenue, Warrendale, PA 15096-0001.

Packing options

PR-2001 Class B is supplied in a two-part SEMKIT® package or pre-mixed and frozen cartridge. PR-187 adhesion promoter is included in the kit. See container for sealant mixing instructions.

Storage life

The storage life of PR-2001 Class B in a *Semkit* package is at least 9 months when stored at temperatures between 60°F (15°C) and 80°F (27°C) in original, unopened containers.

The storage life of PR-2001 Class B pre-mixed and frozen cartridges is a maximum of 30 days when stored at temperatures of -80°F (-62°C) or below.

Recommended thawing procedure

To thaw pre-mixed and frozen PR-2001 stored at -80°F (-62°C), place the frozen cartridges in a 120°F (49°C) water bath for 5-7 minutes. The application life for the sealant starts when the thawed cartridges are removed.

Health precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Safety Data Sheet (SDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An SDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

For industrial use only. Keep away from children.

For emergency medical information call 1-800-228-5635.

Additional information can be found at:
www.ppgaerospace.com

For sales and ordering information call 1-800-AEROMIX (237-6649).

Supplied by:
Sil-Mid Limited
Roman Park, Roman Way
Coleshill, West Midlands
B46 1HG, UK
T: 01675 432850
E: info@silmid.com

Emergency Telephone No. +44 (0)1675 432850
(Monday to Friday, 08:00 – 17:30 – GMT)

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PRC-DeSoto International, Inc.
12780 San Fernando Road
Sylmar, CA 91342
Telephone (818) 362-6711
Toll Free (800) AEROMIX
www.ppgaerospace.com

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