

PR-1764 M Class B, electrically conductive sealant

Description

PR-1764 M Class B is an electrically conductive, corrosion inhibitive, chromate and aromatic-free sealant. It has a service temperature range from -42°C (-43.6°F) to 130°C (266°F). The cured sealant maintains electrical continuity in aircraft applications. The product is also corrosion inhibitive and protects against the common causes of corrosion on aluminium alloys or between dissimilar metals. The cured sealant is resistant to prolonged exposure to both jet fuel and aviation gas.

PR-1764 M Class B is a two-part, manganese dioxide cured, liquid polysulfide compound. The mixed compound is a low-sag, thixotropic paste suitable for application by extrusion gun or spatula. It cures at room temperature to form a resilient sealant having excellent adhesion to common aircraft substrates without shrinkage.

Application properties (typical)

Colour	
Part A	Black
Part B	Grey
Mixed	Dark grey/black

Mix Ratio	Part A: Part B
by weight	13:100

Base viscosity, (Brookfield)	
Pa.s, (poise)	Non-measurable

Application life and cure time at 23°C (73°F), 50% RH

	Application life (hours)	Tack free time (hours)	Time to 30 shore A* (hours)
B-2	2	16	48

*Instantaneous hardness measurement

Performance properties (typical)

Standard cure 14 days @ 25°C (77°F), 50% RH

Cured specific gravity	<2.23
Non-volatile content	>90
Ultimate cure hardness, Shore A	>50

Peel Strength, N/mm, 100% cohesive failure*

No exposure	
Aluminium (alclad 2024)	≥1.2
37035A	≥1.2
Composite	≥1.2
PU 66 abraded	≥1.2

*when used with adhesion promoter PR-148 AF.

Tensile Strength, MPa	
Initial 14 days/23°C	1.5

Elongation, %	
Initial 14 days/23°C	60

Electrical contact resistance, ohm.cm	
Initial 14 days/23°C	<12
On composites,	
1000h 35°C water	<12
7days 60°C ISO 1817	<12
2000h 80°C dry air	<12

The product keeps its electrical properties after these exposures.

Corrosion resistance according to DIN 65252- Part 1 method – No adhesion loss or swelling observed – the sealant provides outstanding protection against corrosion following galvanic couples.

Low-temperature flexibility @ -42°C (-43.6°F) – no cracking, checking or loss of adhesion.

Reparability: excellent to both freshly cured sealant when used with the adhesion promoter PR-148 AF.

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. (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

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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.

After the surface has been cleaned, apply PR-148 AF Adhesion Promoter with a clean brush or a gauze pad. Care must be taken to obtain a uniform thin coat. At standard temperature, allow the adhesion promoter to dry for 30 minutes. It is not recommended to apply adhesion promoter below 45°F (7°C). The sealant must be applied within 8 hours of the application of the adhesion promoter. If this time is exceeded, the surface should be re-cleaned and the adhesion promoter re-applied. Do not use the adhesion promoter if it contains particles or precipitate.

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.

Mixing instructions

PR-1764 M Class B is supplied in a two-part kit. Mix according to ratios indicated in the application properties section. Mix part A and part B separately to uniformity, then thoroughly mix entire contents of both parts of the kit together taking care to avoid leaving unmixed areas around the sides or bottom of the mixing container.

SEMKIT[®] two-part sealant cartridges – manual mixing:

1. Hold cartridge and pull back dasher rod
2. Inject 1/3 of the accelerator into the base
3. Push dasher rod half way into the cartridge and inject a second 1/3 of accelerator into base
4. Push dasher rod all the way into the cartridge and inject final 1/3 of accelerator into base
5. Mix material, rotate dasher rod 90° in a spiral clockwise motion; with each stroke turn the dasher rod by 90°

6. When two-parts are mixed thoroughly, pull dasher rod back to the neck of the cartridge, grasp cartridge firmly at neck, unscrew dasher rod counter-clockwise and remove.
7. Screw nozzle into cartridge, material is ready for extrusion.

CAUTION: Do not mix accelerator with the base until ready to use.

Storage life

The storage life of PR-1764 M Class B is 6 months when stored in original, unopened containers at temperatures between 4-27 °C (39-81 °F). During storage, slight variations in the application characteristics may occur. This does not affect either the overall application properties or the final performance properties of the product.

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 (2376649).

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