



D Aircraft Products, Inc. 1191 Hawk Circle, Anaheim, CA 92807

## DAPCO™ 72 RAPID CURE WINDSHIELD SEALANT

### GENERAL DESCRIPTION

DAPCO™ 72 is a general purpose sealant which cures rapidly in ambient conditions. Best results are obtained when the product is exposed to moderate humidity. In addition to good abrasion and weather resistance, DAPCO™ 72 is less sensitive to cure inhibition than most silicone RTV compounds. The product is available as two-component kits and in pre-packaged cartridges.

### APPLICATIONS

DAPCO™ 72 has been demonstrated to be a useful sealant in a variety of applications where quick setting is desired - e.g. windshield sealants, repair caulks, adhesives, etc.

### TYPICAL PROPERTIES

	PART A	PART B
Color	Grey	Tan
Appearance	Thixotropic Paste	Viscous Liquid
Density lbm/gal	10	11
Viscosity (cps @72°F)	Heavy Paste	50,000

### PROCESSING

**Mix Ratio:** The recommended mix ratio for DAPCO™ 72 is:

	Weight	Volume
Part A	100	100
Part B	15	13.5

The product is a heavy paste and must be mixed thoroughly prior to use. When using a mechanical mixer, care must be taken to avoid high shear equipment that may destroy thixotropy.

**Working Life:** The working life of the mixture is 10 to 15 minutes at 72°F (22°C) after mixing. In the presence of humidity in excess of 60%, the working life will be shortened.

**Curing:** DAPCO™ 72 is generally cured at moderate temperatures, e.g. 72°F (22°C) and requires the presence of minimal humidity. Cure can be accelerated by warming to 150°F (65°C). Optimum physical

properties are developed when the product is cured for three days at 72°F (22°C).

### SURFACE PREPARATION

The substrate must be free from contaminants, i.e., dirt, oil, grease, etc. Clean the surface by wiping with a suitable solvent/cleaning agent and dry thoroughly. Apply DAPCO™ 1-200 Primer and then the DAPCO™ 72. (Note: The sealant must be applied within 90 minutes after the primer has dried.) When circumstances prevent immediate application of DAPCO™ 72, the surface must be cleaned thoroughly to remove the primer before repeating the entire process.

### TYPICAL CURED PROPERTIES

When cured in accordance with the recommended schedule, the following properties are developed:

Hardness (Shore A) ASTM D224	40
Tensile Strength (psi) ASTM D412	325
Elongation (%) ASTM D412	175
Tear Strength (pli) ASTM D624	20
Specific Gravity	1.30

### STORAGE AND HANDLING

Store in a cool, dry place. Keep containers tightly sealed. Shelf life: 6 months from date of shipment

### SAFETY

Although DAPCO™ 72 is considered safe to handle, good housekeeping practices should be followed. Avoid ingestion. DAPCO™ 72 curing agent contains metal soap. Avoid contact with skin to prevent irritation. Material Safety Data Sheets are available upon request.