

CS 2415 Aluminum Exterior Sealant

Chem Seal

Class B

**Technical Bulletin
August, 2009**

meets Mil-S-38228, DMS 1819C, and Lockheed STM 40-006

PRODUCT DESCRIPTION

CS 2415 recommended for sealing external seams, depressions and gaps on aircraft to yield weather tightness and achieve aerodynamic smoothness. CS 2415 is a non-flow material and may be utilized on vertical and overhead, as well as horizontal surfaces. CS 2415 is a Thixotropic, fuel resistant sealant for use on pressurized cabins.

A two component, polysulfide based, aluminum filled, non-flow, filleting material designed for Aircraft sealing. CS 2415 is based on Flamemaster technology, utilizing Permapol P-5 Polymers, an improved chemical modification of Thiokol LP* polymers. Permapol P-5 polymers are covered under U.S. Patent 4,623,711.

CURE

The rate of cure is affected by temperature and humidity. High temperature and high humidity accelerate the cure and low temperature and low humidity retard it. To hasten curing under adverse conditions, it is permissible to heat the applied compound with infrared lamps or by other convenient means. However, temperatures higher than 120 deg. F may cause sponging or bubbling of the uncured compound and should be avoided. Full cure is obtained in seven days at 77 deg. F and 50% R.H. *LP - is a trade name of Morton Thiokol

MIXING INSTRUCTIONS

Production matches accelerator and base compound for optimum performance characteristics. The accelerator package is a separate container, but the label designates by batch number which lot of accelerator is matched to which lot of base compound. Assure that the accelerator and the base compound are a designated "match" before the two components are mixed. Proper mixing of all two-component synthetic rubber compounds requires care to obtain a uniform, air free mix. Mechanical mixing is recommended for best results. However, mixing by hand is entirely satisfactory for small quantities. When material is to be mixed in the gallon or smaller sized unit, it is advisable to remove the container lip using a can opener

The accelerator is first stirred separately to assure even dispersion. Then add the accelerator to the base compound. Mix slowly with a paddle or low speed mixer (70-80 RPM), for approximately seven minutes, until a thorough blend is obtained. In order to insure proper dispersion; scrape paddle, bottom, and sides of container several times during mixing procedure. There is sufficient color contrast between the base and accelerator components; this is to provide a visual safeguard against incomplete mixing.

Color:	
Base Compound	Aluminum
Curing Agent	Black
Viscosity-	
Base Compound (Brookfield RVF Spindle #7, 2 RPM)	12,000 Poises
Curing Agent	Heavy Paste
Mixing Ratio	100:10 by weight
Application Life	2 hours minimum
Tack Free Time	<than 24 hours
Cure Rate	72 hours

APPLICATION

CS 2415 is applied with extrusion gun, putty knife or spatula. Satisfactory performance depends on continuous contact between the compound and the sides of the joint; apply carefully, eliminate gaps, bubbles and voids. Whenever possible, seams and joints should be filled in a continuous operation without layering of the compound. After application, the uncured compound may be smoothed or tooled. Dipping of the brush or tool in water facilitates tooling. Excessive amounts of cured material may be sanded using #400 grit sandpaper. Application life is always measured at temperatures of 75°F and 50% relative humidity.

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STORAGE LIFE

CS 2415 has a storage life of nine months when stored at temperatures below 80°F in the original unopened container. Minor variations may occur to the application properties.

CLEAN UP

Remove uncured CS 2415 from equipment and tools with solvent before the sealant cures. Remove cured material from tools and equipment by soaking and scrubbing with Polysulfide/Epoxy Stripper.

SAFETY

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

PACKAGING

CS 2415 is packaged in the following Kit sizes:

24 ea. per case 2 1/2 oz. and 6 oz.
cartridges

16 ea. per case Pint Kit

16 ea. per case Quart Kit

4 ea. per case Gallon Kits

CS 2415 is also sold in 5-Gallon and 50-Gallon Drum Kits

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Flamemaster does not warranty the performance of fuel tank sealants or coatings when 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." 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 manufacturers 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 the 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. However since much of this information has been received from sources outside of the company, it is provided without any warranty expressed or implied regarding its correctness or suitability for specific situations. The conditions of handling, storage, use and disposal are beyond our control and may be beyond our knowledge.