

Naftoseal[®] MC-460 Class A and B Floor Panel Sealants

1 General Description

Naftoseal[®] MC-460 Class A / Class B are two-component, fast curing and flame-retardant sealants on base of Polysulfide with low density designed for sealing operations where good adhesion as well as removability of the seal for maintenance purposes is important.

The cured Naftoseal[®] MC-460 sealants are elastic and build up fast a good adhesion to the floor panels. Thus, these sealants are especially appropriate to fill gaps between floor panels with sandwich structure as used for aircraft construction.

At maintenance times the cured Naftoseal[®] MC-460 sealants can be removed easily by means of appropriate tools (like e.g. a plastic spatula) without harming the floor panels or even the supporting structure.

To allow optimum filling of different gap widths, Naftoseal[®] MC-460 sealants are available in two viscosity versions: Naftoseal[®] MC-460 Class A is pourable whereas Class B is paste-like.

2 Applications

- Sealing of floor panels
- Sealing of parts which need to be removable e.g. for the purpose of maintenance

3 Method of use

Naftoseal[®] MC-460 sealants are available in Techkit 130. The mixing in Techkit 130 can be done by MCI mixer. The application of the sealants may be carried out by manual or pressurised applicator gun.

4 Specifications

Naftoseal[®] MC-460 sealants fulfil the requirements of the Airbus Specification AIMS 04-31-002.

Application Life and Cure Time at 23°C (73 °F)/50% r.H.			
Type	Min.Application Time	Tack-free Time	Time to Shore A 20
Naftoseal [®] MC-460 A-1/4	15 minutes	≤ 3 hours	≤ 4 hours
Naftoseal [®] MC-460 B-1/4	15 minutes	≤ 3 hours	≤ 4 hours
Typical Physical and Application Properties			
	Base	Hardener	
Color	Beige	Brown	
Mixing ratio by weight	A 1/4: 100 B 1/4: 100	7,5 +/- 15% 7,5 +/- 15%	
Typical Properties of Cured Compound			
Color:	Brown		
Specific gravity:	≤ 1,15		
Ultimate Shore A hardness:	20 – 40		
Service temperatures:	-55 °C (-67 °F) / +80 °C (+176 °F)		

Mixing Instruction			
Naftoseal [®] MC-460 A-1/4 Naftoseal [®] MC-460 B-1/4	Motor revolution in rpm	Strokes up and down	Mixing time
	110 ± 10	90	2 Min ± 1 Min

5 Surface Preparation

To obtain good adhesion, clean surfaces with appropriate cleaners to remove dirt, grease and processing oils just prior to sealant application. Use lint-free rags or paper towels that are free of oil or soap. Always pour cleaner on the cloth to avoid contamination of the cleaner supply. Clean one small area at a time, quickly wiping it dry before the cleaner's solvent evaporates to prevent redeposition of oil, wax or other contaminants.

6 Packaging

The material is supplied in Techkit 130 (137 ccm), with 24 Techkits per carton.

7 Storage

The shelf life of Naftoseal[®] MC-460 sealants is 4 months from date of manufacture, when stored at temperatures below 26 °C (+79 °F). Store in a dry place.

8 Health and Safety Precautions

See Safety Data Sheet

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