LJFM
Aerospace

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PR 1773 Class A

CORROSION INHIBITIVE SEALANT
NON-CHROMATE
LOW ADHESION

USE

PR 1773 Class **A2** is a non-chromate corrosion inhibitive sealant designed for use as access door sealant.
It can also be used to protect electrical wires, terminal and equipment against fuel, moisture, dirt and short circuits.

DESCRIPTION

PR 1773 Class **A2** is a two-part manganese cured, polysulfide-based sealant characterized by low adhesion properties.
The mixed compound is of fluid concistancy wich can be readily applied by brush,once applied around fasteners will not drip or flow from vertical or overhead surfaces.

SPECIFICATION

AIMS 04-05-006
ASNA4168/A - A2

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PRODUCT DESIGNATION

PR 1773 A-2

PACKAGING

KITS :

	Base Volume	Container	Number of Kits per case
KIT n° 10	0,10 liter	1/4 l. Can	12
KIT n° 25	0,25 liter	1/2 l. Can	12
KIT n° 50	0,50 liter	1 liter Can	12

SEMKITS :

	Total Content	Number per Case
655	55 cc	24
654	100 cc	24

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HUTCHINSON® aerospace

APPLICATION PROPERTIES (typical)

(23°C / 50 %HR)

Couleur	
Base	Red
Accelerator	Black
Mixing ratio (by weight)	
Base / Accelerator	10:1
Nonvolatile content (mixed compound)	84 % mini
Viscosity (Brookfield # 7 @ 2 rpm)	20-65 Pa.s

Application Life and Cure Time

	Application Life (hours)	Tack Free Time (hours)	To 30 Shore A (hours)
A 2	2	12	48

PERFORMANCE PROPRERTIES (typical)

Thermal rupture resistance

Color	Dark red
Specific Gravity	1,55
Hardness, Shore A	50
Low temperature flexibility	- 55° C

Adhesion - Peel strength (N/mm)

	Standard	7days in B Fluids at 60°C
Alclad 2024	0,2	0,1
Stainless Steel	0,1	0,1
Titanium	0,1	0,1
PU 66 abraded	0,3	0,3

Tensile Strength and Elongation :

	Tensile Strength (MPa)	Elongation (%)
- Initial	1,5	240

Corosion résistance

No sign of corrosion and sealant deterioration after :

Salt spay methode	5000 hrs
Galvanic cell method	2 weeks

Al/Stainless steel couple
Al/Titanium couple
Al/Cadmium plated steel couple

Resistance to Salt and Hydrocarbon

No sign of blistering and softening.
No evidence of corrosion

Resistance to other Fluids :

Excellent resistance to water, alcohols, petroleum-base and synthetic lubrificating oils, and petroleum-base hydraulique fluids.

SURFACE PREPARATION

Part shall be cleaned with solvents to remove dirt, grease, and processing lubricants used in manufacturing.
Wash one small aera at a time, then dry with a clean cloth before solvent evaporates to prevent redeposition of oil, wax or other surface contaminents. To maintain a clean solvant supply, always pour the solvent on the washing cloth.

MIXING INSTRUCTIONS

Proper mixing and correct proportions are extremely important if optimum results are to be obtained. Mixing by experienced personnel at a central location is recommended.

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

1° Thoroughly stir accelerator in its container until an even consistancy is obtained.
2° Thoroughly stir base compound in its container until an even consistancy is obtained.
3° Slowly stir the accelerator into the base compound and thoroughly mix approximately 7 to 10 minutes. Be sure to scrape the sides and bottom of the container in order to include all the compound in the mixture and to assure uniform blending. Scrape mixing paddle periodically to remove unmixed compound. Slow mixing by hand is recommanded.
FRACTIONAL USE OF UNIT :

When it is desired to use only part of the kit, after homogenization, remove the required quantity.
(§ APPLICATION PROPERTIES).

For all informations, consult the Engineering Services of LE JOINT FRANCAIS.

SEMKIT TWO-PART SEALANT CARTRIDGES

1° Wear safety glasses.
2° Hold cartridge and pull back dasher rod one fourth.
3° Pull back the dasher rod as injecting as proportionnaly as possible the contents accelerator into the base.
4° Mix material, rotate dasher rod 90° in aspiral clockwise motion; with each stroke turn the dasher rod 90°.
5° When two-parts are mixed thoroughly, pull dasher rod back to the neck of cartridge, grasp cartridge firmly at neck, unscrew dasher rod counterclockwise and remove.
6° Screw nozzle into cartridge, material is ready for extrusion.

For all informations, consult the Technical Services of LE JOINT FRANCAIS.

APPLICATION INSTRUCTIONS

Application life is the period of time that the mixed compound remains at a consistency suitable for application with injection or extrusion guns. Application life is always based on standard conditions at 23° C and 50 % relative humidity.

Apply the sealant with an extrusion gun equipped with 3 to 6 mm tip. Hold gun nearly perpendicular so that extruded sealant will be forced into the lip of seam.
On most application, the fillet should be 3 to 5 mm thick, but heavier fillets can be applied in a single operation, if necessary.

CURING

The lenght of the cure depends on the ambient temperatureand relative humidity. The temperature/time relation ship is approximately the same for curing as it is for application life . Low humidities may extend the cure several times. Cure may hastened by applying heat up to 55° C.

CLEANING EQUIPEMENT

Equipment should be cleaned immediately after use with methylethylketone. Cured sealant on accessible portions of equipement will peeled off by hand.

STORAGE LIFE

The storage life of **PR 1773 A** is 6 months when stored in the original, unopened containers at temperature below 25°C.

HEALTH PRECAUTIONS

PR 1773 A is a safe material to handle when reasonable care is observed. Ordinary hygienic principles, such as washing the compound from hands before eating or smoking, should be observed.

For additional health and safety information consult a **Material Safety Data Sheet** which is available upon request on **www.ljfm.com**

GUARANTEED

We guarantee all our products against faulty materials or preparation. Our sole responsability shall be to replace, free of charge, those products which prove to be defective, the user being entitled to no indemnity for any reason whatsoever. All recommendations contained herein as to the choise of materials or of certain methods of operation are of an informative character and are based on tests and experiments we belive to be reliable and correct, but accuracy and completeness of such tests are not guaranteed and are not to be construed as a warranty, either express, or implied.
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Recommendations or statements other than those contained in a written document signed by an officer of our company shall not be binding upon the company.

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