



# PR 1776 Class A AS

## FUEL TANK SEALANT LOW GRAVITY

### USE

A filleting compound **low gravity** for sealing integral fuel tank and pressurized cabins.

**PR 1776 class A AS** was especially developed for use over a temperature range of -55°C to + 95°C and up to 180°C , with outstanding resistance to aircraft fuels (aviation gasoline or jet fuel) and petroleum base lubricating oils.

### DESCRIPTION

**PR 1776 class A AS** is a two-part, high temperature resistant low gravity, fuel tank and fuselage sealant, based on **Permapol P-5** liquid polymers, a chemically modified improved class of polysulfide polymers. The mixed compound is of fluid consistency which can be applied by brush, once applied around fasteners will not drip or flow from vertical or overhead surfaces. Sealant has excellent adhesion to aluminium, titanium, stainless steel, and other metals.

### SPECIFICATION

AIMS 04-05-001  
AIMS 04-05-002  
ASNA 4157/D-A2

### LE JOINT FRANCAIS

#### Sealants, Adhesives and Coatings

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### PRODUCT DESIGNATION

PR 1776 A2 AS

### 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
KIT n° 100	1,00 liter	2 liters Can	6

#### SEMKITS :

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

**APPLICATION PROPERTIES** (typical)

23+/-1°C and 50+/-5% HR

Couleur			
Base	White		
Accelerator	Black		
Mixing ratio (by weight)			
Base / Accelerator	100:10	A2	version
	100:12	A1/2	version

Nonvolatile content  
(mixed compound) 90 %

Vertical Flow :	
Initial	4 mm
50 mn	2 mm
90 mn	2 mm

**Application Life and Cure Time**

	Application Life (hours)	Tack Free Time (hours)	To 35 Shore A (hours)
A 1/2	1/2	5	12
A 2	2	12	30

**Resistance to other Fluids :**

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

**Réparability :**

Excellent to both fresh sealant and heat/fuel-abraded fillets

For maximum adhesive strength between **PR 1776A AS** and the material to which it is bonded, **PR 148 AF** is recommended.

**SURFACE PREPARATION**

Part shall be cleaned with solvents to remove dirt, grease, and processing lubricants used in manufacturing.

Wash one small area at a time, then dry with a clean cloth before solvent evaporates to prevent redeposition of oil, wax or other surface contaminants. To maintain a clean solvent supply, always pour the solvent on the washing cloth.

**NOTE :** The above application and performance property values are typical for the material, but are not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.

**PERFORMANCE PROPERTIES** (typical)

Color	Grey
Density	1,3
Shore A	50
Low temperature Flexibility	- 55° C

**Adhesion - Peel strength (N/mm)**

	Initiale	+ 7days 60°/B Fluid
Alclad 2024	7,0	---
Stainless steel	6,0	---
Titanium	5,5	---
PAC 33 NV	6,5	4,0
PU 66 Abraded	6,5	5,0

100% cohesive

**Tensile Strength and Elongation :**

	Tensile Strength	Ultimate Elongation
14 days 23°C	2,0 MPa	450 %
4500 h/23°C in JP1	2,4 MPa	250 %

## 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 consistency is obtained.
- 2° Thoroughly stir base compound in its container until an even consistency 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 recommended.

### 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 proportionally 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.

## CURING

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

## CLEANING EQUIPMENT

Equipment should be cleaned immediately after use with methylethylketone. Cured material may be removed with commercial product.

## STORAGE LIFE

The storage life of **PR 1776 A AS** is 6 months when stored in the original, unopened containers at temperature below 25°C.

## HEALTH PRECAUTIONS

**PR 1776 A AS** 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](http://www.ljfm.com)

## GUARANTEED

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