



PR 1827 GR 1/3

CORROSION INHIBITIVE SEALANT QUICK REPAIR

USE

PR 1827 GR 1/3 is a rapid curing corrosion inhibitive sealant designed for use at temperature between -55°C to $+160^{\circ}\text{C}$, with intermittent use to $+210^{\circ}\text{C}$. **PR 1827 GR 1/3** has excellent low temperature curing characteristics.

DESCRIPTION

PR 1827 GR 1/3 is a two-part, chemically curing **Permapol P-3** polythioether polymer based sealant characterized by a rapid cure at low temperature to a fuel resistance elastomer.

This material has application temperature as low as $+5^{\circ}\text{C}$.

The sealant contains a mix of soluble chromates to inhibit corrosion over an extended period of time.

When used with primer **PR149** Adhesion Promoter, the sealant adheres to alclad, titanium, stainless steel, coated surfaces and sealant.

The mixed compound may be applied by brush or roller.

SPECIFICATION

Meet requirement of DAN 1218-04.

Standard conditions :

$23^{\circ}\pm 1^{\circ}\text{C}$ and $50\pm 5\%$ RH

PURCHASING

PRODUCT DESIGNATION

When ordering this product, designate PR number, class letter, and dash number as follows :

PR 1827 GR 1/3 (application life : 20 mn)

STANDARD PACKAGING

DESIGNATION

SEMKITS :

	<u>Total Content</u>	<u>Number per Case</u>
654 A	110cc	24

LE JOINT FRANCAIS SEALANTS ADHESIVES & COATINGS

84/116 rue Salvador Allende, 95870 Bezons - Tél 01.34.23.34.23 - Télécopie 01.34.23.34.99

[http : \www.ljfm.com](http://www.ljfm.com)



APPLICATION PROPERTIES(typical)

- Color	Base	Yellow
	Accelerator	Black
- Mixing ratio	Base/Accelerator	12,3 : 1 by weight

- Nonvolatile content (mixed compound)	90 %
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- Viscosity	
Base	
(Brookfield # 6 @ 2 rpm)	50-150 Pa.s
Accelerator	
(Brookfield # 7 @ 10 rpm)	150 Pa.s

- Application Life and Cure Time

Application Life (mn)	Tack Free Time (hours)	To 35 Shore A (hours)
20	1h	2 h

PERFORMANCE PROPERTIES(typical)

- Color	Black
- Specific Gravity	1,55
- Hardness, Shore A	55
- Low temperature flexibility	- 55° C

- Shear strenght (MPa)

	alclad	alodine	P.U	epoxy
	coat	primer	coat	primer
- Initial	3,2	3,3	2,5	2,5
- 48 h / 60°C	3,2	3,3	2,5	2,5

in B* Fluide

100% cohesive w ith Primer **PR149**

- Tensile strenght and elongation

	Tensile strenght (MPa)	Ultimate elongation (%)
- Initiale	3	150
- 7d. at 23°C + 4 h at 150°C	3,6	120
- 7d. at 23°C + 24 h at 150°C	2	50
- 7d. at 23°C + 4 h at 180°C	2	50
- 7d. at 23°C + 24 h at 180°C	2	40
- 7d. at 23°C + 2 h at 215°C	1,9	60
- 7d.at 23°C		
+ 14d.at 60°C /B*Fluide	1,8	90
- 7d.at 23°C		
+ 7d.at 60°C / salt water	3,4	118

B*Fluide : Iso octane-toluène mixed (70/30)

NOTE : The 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.

SURFACE PREPARATION

To obtain good adhesion the surface must be cleaned with an oil-free solvents which will dissolve 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.

If necessary apply **PR 149** Adhesion Promoter with a clean brush or by wiping on with a gauze pad. Care must be taken with either a brush or gauze to obtain a uniform thin coat - one that is thin enough to cover, but not heavy enough to run. At standard temperature, allow the adhesion promoter to dry 3 minutes. At lower temperature allow a proportionally longer time to dry.

The sealant may be applied up to 30 minutes after the application of the adhesion promoter. After 30 minutes, the surface should be re-cleaned and adhesion promoter reapplied. (Consult **PR149** Data sheet)

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.

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.

APPLICATION INSTRUCTIONS

Application life is the period of time that the mixed compound remains at a consistency suitable for application by brush or roller.

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

CURING

PR 1827 GR 1/3 cures rapidly at room temperature and at lower temperatures. The sealant will cure at temperatures as low as +5°C.

The cure of **PR 1827 GR 1/3** is solely dependant upon the temperature. Humidity has no effect on the cure sealant. The cure of **PR 1827 GR 1/3** will be halved or doubled for each 5°C, up or down respectively, from the standard 23°C.

CLEANING EQUIPEMENT

Equipment should be cleaned immediately after use with methylethylketone. Use commercial stripping compounds to remove cured sealant.

STORAGE LIFE

The storage life of **PR 1827 GR 1/3** is 4 months when stored in the original, unopened containers at temperature of 20°C or 6 months at temperature of +5°C.

SAFETY PRECAUTIONS

WARNING:

PR1827GR1/3 CONTAINS FLAMMABLE AND VOLATILE SOLVENTS.

Keep away from heat, sparks, and flame. Proper precautions used with flammable materials must be taken when applying this product. Comply with

HEALTH PRECAUTIONS

PR 1827 GR 1/3 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. Avoid prolonged contact with skin, contact with open breaks in the skin, and ingestion. In case of contact with skin, wipe off excess then wash with soap and water. Obtain medical attention in case of extreme exposure or ingestion.

Use adequate ventilation or air-supplied respirators during application. Avoid repeated or prolonged exposure. In case of overexposure, remove affected personnel to fresh air.

For additional health and safety information consult a
Material Safety Data Sheet
which is available upon request

GUARANTEED

We guarantee all our products against faulty materials or preparation. Our sole responsibility 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 choice of materials or of certain methods of operation are of an informative character and are based on tests and experiments we believe 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.

Neither our company, nor any of its collaborators shall be liable to the user for any injury, loss or damage directly or indirectly resulting from the use of, or inability to use, the products, which does not comply with the application instructions as specified in our information manual.

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.

