TECHNICAL DATA SHEET

FM30 – FAC240 FUEL MASTER SEALANT

Technical Data:

Base	Polysulfide
Consistency	Thick paste
Colour	Grey : Base (white) Accelerator (black)
Curing System	Chemical cure (2 pack)
Skin Formation	Ca. 30 minutes (23°C & 55% R.H.)
Tack Free Time	5 Hrs (23°C & 55% R.H.)
Curing Rate	6 Hrs to emersion, full strength 7 days @ (23°C/55% R.H.)
Change in Volume	5%
Hardness Shore A	60
Maximum Deformation	No cracking when bent 180° over a 3mm mandrel.
Weight Loss	No more than 6% loss of sealant compound after fluid immersion
Specific Gravity	1.61 gm/L
Temperature Resistance	-54°C until +121°C Intermittent exposure to 182°C
Character	Thixotropic, does not slump
Elongation at Break	+300%
Tensile Strength	>2.0 N/mm^2 (ISO 8839)
Shear Strength	>2.0 N/mm^2 (ASTM D1002)
Thermal Rupture Resistance	Does not blister or sponge
Corrosion	None
Fungus Resistance	Meets MIL-STD
Shelf Life	9 months
Non Volatile Content	98%

(*) Values may vary depending on environmental conditions

Product:
FM30 Fuel Master Sealant is a 2 part, Polysulfide based product for use as a long application life, quick cure sealant for integral fuel tanks and fuselages. The mixed compound has a thixotropic non-sag consistency and can easily be applied by spatula, extrusion gun or piping bag to verticle surfaces. FM30 will cure to a fuel resistant rubber at temperatures above 6.67° C and exhibits excellent tooling capabilities with very low shrinkage.

Characteristics:
- Excellent adhesion on most substrates (except Teflon, PE and PP)
- Good filling capacities

Specification Standard:

STM 40-113	Qualified
AMS-S-8802	Qualified
P.S. 11346	Qualified
TAPS 1163 Type I	Qualified
MEP-09-096	Qualified
RLD.JA.001	Qualified
NA-66-1032	Qualified
BMS 5-26U Type II	Meets Requirements

Applications:
Repair and construction of fuel tanks, fuselages and fuel cell cavities.

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FM30 – FAC240 FUEL MASTER SEALANT

Packaging:
Colour – Grey
Packaging – 500ml Kit 10:1 mix ratio

Shelf life:
9 months; from production date. In unopened packaging in a cool and dry storage place a t temperatures between +5°C and 23°C.

Surfaces:
State of Surface: clean, dry, free of dust and grease
Preparation: For maximum adhesion, clean surfaces with appropriate solvent to remove dirt, grease and oil. Aways use clean cloth and pour the solvent on to the cloth to aoid contaminating the solvent supply.
We recommend a preliminary compatibility test.

Application:
Method: Spatula, Extrusion Gun or Piping Bag
Application temperature: +6.67°C to 30°C
Clean up: Solvent before curing
Repair: FM30 Fuel Master Sealant and other AMS-S-8802 approved sealants

Mixing:
Mix accelerator and base seperately before combining. The accelerator settles to a gel on standing to prevent the heavy manganese from settling. Gentle mixing is required to restore the fluid consistency. Mixing at a ratio of 10:1, accurately weigh both components. Combine components by hand mixing. High speed mixers create heat that shortens application life.
For optimal results it is important to to use the correct proportions and mix properly. Any unmixed base or accelerator remaining on the sides and bottom of the container or mixing paddle must be combined.

Health- and Safety Recommendation:
Apply the usual industrial hygiene. Wear gloves . Safety Glasses. Respirator.

Remarks: Application life refers to the length of time the mixed compound remains at a consistency suitable for application with spatula or caulking gun. Application life is always measured as a standard temperature of 23°C with a relative humidity level of 50%. In general, for every 10°C rise in temperature, the application life is halved; and for every 10°C drop, it is doubled. High humidity levels during the mixing process will shorten application life. Tack free time is the length of time after which a mixed sealant will no longer tightly adhere to MIL-I-631 standard polyethylene film. 'Cure time is defined as the length of time it takes FM30 Class B sealant to reach 35'A" hardness. It depends on three factors: remaining application life, temperature and relative humidity. To a certain extent, the temperature/humidity factors for application life also apply to curing. To accelerate the curing of FM30, apply heat up to (but not more than) 48°C.

For Professional use only. Compatibility tests are recommended.

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