protective coatings

caulking compounds

sealants • adhesives

TECHNICAL DATA SHEET

PR-1422 CLASS B

435
15

USE

A filleting compound for sealing integral fuel tanks and pressurized cabins, PR-1422 Class B was especially developed for use over a temperature range of —65°F to +275°F and with outstanding resistance to aircraft fuels (aviation gasoline or jet fuel), petroleum base oils, and resistance to deterioration by the saturation of diphosphate ester type hydraulic fluids.

DESCRIPTION

PR-1422 Class B is a two-part, polysulfide, liquid polymer compound that utilizes an advanced chemical curing system. Each lot is manufactured from carefully selected raw materials under the strictest control and thoroughly evaluated to assure conformance to rigorous specifications. The mixed compound is a highly thixotropic paste that is readily applied with an extrusion or injection gun and does not flow from vertical or overhead surfaces after application. Cure takes place at room temperature and without shrinkage to form a resilient sealant possessing excellent adhesion to aluminum, magnesium, titanium, steel, and numerous other materials. Field service tests and production applications under extremely adverse fuel and temperature environments have proven the success of PR-1422 Class B under conditions previously considered far too rigorous for polysulfide liquid polymer sealants.

SPECIFICATIONS

PR-1422 Class B meets the requirements of the latest revision of MIL-S-8802, Class B.

APPLICATION PROPERTIES (Typical)

(Test methods according to MIL-S-8802D(1), Class B where applicable)

COLOR: Base Compound, Light Brown; Accelerator, Black.

MIXING RATIO: 7.5:1 by weight (base compound:accelerator)

NONVOLATILE CONTENT: 92.5% (mixed compound).

VISCOSITY: Brookfield Spindle #7 @ 2 rpm, 12,000 poises.

VERTICAL FLOW: Initial, 0.3"; 50 minutes after mixing, 0.5"; 90 minutes after mixing, 0.4".

APPLICATION LIFE AND CURE TIME:
(At 75°F, 50% RH)

	MINIMUM APPLICATION LIFE (in hours)	TACK FREE TIME (in hours)	CURE TIME to 35 REX (in hours)
B-½	½	8	24
B-2	2	30	48

PURCHASING DATA

PRODUCT DESIGNATION

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

PR-1422 B-1/2	Minimum Application Life	½ hour
PR-1422 B-1	Minimum Application Life	1 hour
PR-1422 B-2	Minimum Application Life	2 hours
PR-1422 B-4	Minimum Application Life	4 hours

PACKAGING

PR-1422 Class B may be purchased in the following types of packages:

Standard Containers

Designation	Base Compounds Container	No. Per Case
½ pt. kit — 3½ fl. oz.	½-pt. can	16
½ pt. kit — 6 fl. oz.	½-pt. can	16
Pint kit — 12 fl. oz.	1-pt. can	16
Quart kit — 24 fl. oz.	1-qt. can	9
Gallon kit — 96 fl. oz.	1-gal. can	4
5 gallons	5-gal. pail	—
50 gallons	55-gal. open-top drum	—

NOTE: The fluid ounce content is the amount of base compound (128 fluid ounces per gallon). Kits are furnished with a premeasured quantity of base compound and accelerator individually packaged and assembled as a single unit. Bulk quantities of 50 gallons are accompanied by sufficient accelerator individually packaged. Kits are designed so that adequate space is available in the base compound containers for addition of accelerator and mixing.

PREMIXED FROZEN
(Only available in certain application lives)

Designation	Approximate Contents	No. Cartridges per Case
2½ oz. cartridge	2¼ fl. oz.	72
6 oz. cartridge	5¾ fl. oz.	36

Semkit® Two-Part Sealant Cartridges

Designation	Approximate Total Contents	Container	Kits per Case
Model 655	2 fl. oz.	2½ oz. cartridge	24
Model 654	3½ fl. oz.	6 oz. cartridge	24

NOTE: Semkit Two-Part Sealant Cartridges are furnished with a premeasured quantity of base compound and accelerator packaged in a plastic cartridge equipped for mixing the compound in the cartridge.

ACCELERATED STORAGE STABILITY: Aged material continues to meet the viscosity, application life, and tack free time of the specification.

GC-407 SEALANT COMPOUND

SPEC. MIL-S-88[illegible] TYPE I CLASS A-2

[illegible] 1[illegible] GRAMS

[illegible]POUND BATCH # EC72

[illegible]

[illegible]TOR BATCH # EC73

MI[illegible]S: MIX 100 parts by weight of GC-4[illegible]d with 10 parts by weight of GC-4[illegible] until completely uniform.

STORAGE TEMPERATURE [illegible]80°F. or below.

SHELF LI[illegible] months from date of packaging

P.O. # 31[illegible]

GOAL CHEMICAL SEALANTS CORP.

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