

Technical Data Sheet

Aerospace Sealants



P/S 815M tack free time accelerator

Description

P/S 815M is designed for application over manganese dioxide cure polysulfide sealants to cure the surface to a tack free state in approximately two hours.

This material significantly reduces the risk of foreign objects and debris (FOD) from adhering to the sealant's surface during its cure cycle.

P/S 815M is a one part, ethyl alcohol-based rubber vulcanizing accelerator. The material is a low viscosity liquid suitable for application by spray or brush.

The following tests are in accordance with PPG's aerospace internal test methods.

Application properties (typical)

Color	clear / yellow
Viscosity	
Centipoise (Pa-s), #1@ 20 rpm	50 (0.005)
Dry time, hours	
@77°F (25°C), 50% RH	<2

Performance properties (typical)

Liquid specific gravity	0.81
Nonvolatile content, %	2.1
VOC, g/l	772
Flash point (CC)	65°F (18°C)

Repairability

PR-1776M B-2 over fuel-aged PR-1776M B-2; no conditioning

No adhesion promoter:	43 pli, 100% CF
With adhesion promoter:	44 pli, 100% CF
With abrasion only:	47 pli, 100% CF
With abrasion and adhesion promoter:	44 pli, 100% CF

PR-1776M B-2, over fuel-aged PR-1776M B-2;
7 days in 50/50 salt water/AMS2629 at 140°F

No adhesion promoter:	43 pli, 100% CF
With adhesion promoter:	42 pli, 100% CF
With abrasion only:	44 pli, 100% CF
With abrasion and adhesion promoter:	48 pli, 100% CF

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

Usage instructions

P/S 815M is supplied in a hand-pump spray bottle. Shake the bottle prior to application to ensure uniformity. Apply a light mist to the surface of the uncured sealant. Do not over-apply, as this may cause streaks and running of the P/S 815M.

Surface preparation of uncured sealant

When P/S 815M is applied directly over uncured polysulfide sealants, no special surface preparation is required. The material exhibits excellent activity on manganese dioxide cured polysulfide sealants.

Surface preparation of cured sealant (for repair application)

Sealant that had previously been cured with P/S 815M should be lightly scuffed with an abrasive pad or sandpaper, and thoroughly washed with an approved aerospace cleaning solvent.

Use of an adhesion promoter is highly recommended for repair of sealant that has been fuel-aged.

If an adhesion promoter is used, allow it to dry according to the manufacturer's recommendation.

Fresh sealant may then be applied over the sealant being repaired.

Storage life

This storage life of P/S815M is at least 6 months when stored at temperatures below 80°F (27°C) in original unopened container.

Health precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Safety Data Sheet (SDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An SDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

P/S 815M tack free time accelerator

For industrial use only. Keep away from children.

For emergency medical information call
1-800-228-5635.

Additional information can be found at:
www.ppgaerospace.com

For sales and ordering information call
1-800-AEROMIX (237-6649).

All recommendations, statements, and technical data contained herein are based on tests we believe to be reliable and correct, but accuracy and completeness of said tests are not guaranteed and are not to be construed as a warranty, either expressed or implied. User shall rely on his own information and tests to determine suitability of the product for the intended use and assumes all risks and liability resulting from his use of the product. Seller's and manufacturer's sole responsibility shall be to replace that portion of the product of this manufacturer which proves to be defective. Neither seller nor manufacturer shall be liable to the buyer or any third person for any injury, loss, or damage directly or indirectly resulting from use of, or inability to use, the product. Recommendations or statements other than those contained in a written agreement signed by an officer of the manufacturer shall not be binding upon the manufacturer or seller.

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