



# AC-<sup>®</sup>215 Class B Low Adhesion Access Door Sealant

SIN #834-100

## Description

AC-<sup>®</sup>215 Class B is a two-part, polysulfide access door sealant for faying surfaces where easy separation of joined surfaces is required. It is a highly thixotropic reddish paste which can easily be applied with a spatula, putty knife or caulking gun. The cured AC-215 sealant has low adhesion and forms a tough, "rubbery" gasket that molds well to surface irregularities.

## Applications

- Access door sealant for aerospace metallic structure and pressurized vehicles
- Gaskets for removable parts
- Strippable fillets

## Specifications

MIL-S-8784 - GSA Approved  
TAPS 1163 Ty IV- Qualified  
299-947-074 - Qualified (Pre-mixed & Frozen)

## Typical Physical and Application Properties

Color	
Base:	Red/Pink
Accelerator:	Black
Mix Ratio	100 base / 10 accelerator (by weight)
Non-Volatile Content	98%
Viscosity (Brookfield #7 spindle @ 2rpm)	7,000 - 9,000 poise
Vertical Flow	0.25"-1.25"

## Application Life and Cure Time

(@ 75°F, 50% Relative Humidity)

	Minimum Application Life <sup>1</sup>	Typical Tack Free Time <sup>2</sup>	Typical Cure Time <sup>3</sup>
B-½	½ hour	10 hours	24
B-2	2 hours	24 hours	48

## Typical Physical and Performance Properties of Cured Compound when tested per MIL-S-8784

Color	Red/Purple
Specific Gravity	1.52
Hardness	45 Shore "A"
Adhesion to Aluminum, steel, stainless steel, titanium, zinc, cadmium, chromium, magnesium, glass, enamel, Epoxy MIL-P- 23377 and Urethane MIL-C- 27725	2lb./in of width 100% adhesive failure
Temperature Range	-65°F to +250°F
Low Temperature Flexibility	-65°F, conforms
Fuel Resistance	6% weight loss after 7 days at 130°F in TT-S-735, Type III fluid.
Resistance to Other Fluids	Excellent resistance to water, alcohol, petroleum and synthetic lubricating oils and petroleum- base hydraulic fluids.
Effect on Acrylic Plastics*	Will not cause crazing.
Fungus Resistance	Non-nutrient.

\*Not a specification requirement.

<sup>1</sup> Application life refers to the length of time that mixed compound remains at a consistency suitable for application with spatula or caulking gun. Application life is always measured at a standard temperature of 77°F with a relative humidity level of 50%. In general, for every 20°F rise in temperature, the application life is halved; and for every 20°F drop, it is doubled. High humidity levels during the mixing process will shorten application life.

<sup>2</sup> Tack-free time is the length of time after which a mixed sealant will no longer tightly adhere to L-LP-690 standard low density polyethylene film.

<sup>3</sup> Cure time is defined as the length of time it takes AC-215 Class B sealant to reach 30A 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 process, apply heat up to (but not more than) 120°F.



### Two-Part Sealant Cartridges:

1. Holding the cartridge, grasp the dasher rod and pull back approximately one inch.
2. Insert the ramrod into the hollow of the dasher rod, break the piston loose, and inject about 1/3 of the contents into the cartridge.
3. Repeat steps 2 and 3 until all the contents of the rod are emptied into the cartridge. Remove the ramrod.

*Note: Do not inject all of catalyst in one location. Distribute evenly throughout base material.*

4. Mix for the required number of strokes (hand mixing) or for the required amount of time (machine mixing) indicated in the kit instructions.
5. When mixing is complete, remove bottom cap.
6. Pull the dasher rod back to the neck of the cartridge, grasp the cartridge firmly at the neck, unscrew the dasher rod and remove.
7. Screw the nozzle into the cartridge, insert into the extrusion gun and use as required. For hand extrusion, press the used dasher rod against the plunger to force the material from the cartridge.

### Storage

The shelf life of AC-215 Class B is 12 months from date of packaging, when stored at temperatures below 80°F in its original container.

Mixed AC-215 Class B may be stored under refrigeration as follows:

15 days at -10°F  
30 days at -40°F

It is important to remember that freezing, storing and thawing procedures reduce application life. Also, frozen storage will reduce application life by varying amounts depending on the storage temperature and length of storage time. All aspects of storage, freezing and thawing should be planned carefully and it is not recommended to mix and freeze with less than ½ hour application time.

### Health and Safety Precautions

AC-<sup>®</sup>215 Class B sealant is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Material Safety Data Sheet (MSDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An MSDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure

All values are typical and are not intended for specification use.

**AC-215B-01/09**

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