



# AC-<sup>®</sup>615 Class A Low Adhesion Access Door Sealant, Chromated

SIN #834-100

## Description

AC-615 Class A is a two-part, low adhesion, chromate containing, corrosion inhibiting Polysulfide access door sealant for faying surfaces where easy separation of joined surfaces is required. The mixed compound is flowable, reddish liquid, thixotropic, which can easily be applied with a spatula, brush, roller or extrusion gun. The cured AC-615 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

## Specifications

AMS 3267 - GSA Approved

## Typical Physical and Application Properties

|   |  |
|---|--|
| Color   |  |
| Base:   | Red/Pink                                 |
| Accelerator:  | Black                                    |
| Mixing Ratio  | 100 base / 10 accelerator<br>(by weight) |
| Non-Volatile Content                                  | 88%                                      |
| Base Viscosity<br>(Brookfield #6 spindle<br>@ 10 rpm) | 300 poise                                |

## Application Life and Cure Time

(@ 75°F, 50% Relative Humidity)

|       | Minimum<br>Application<br>Life <sup>1</sup> | Typical<br>Tack-Free<br>Time <sup>2</sup> | Typical<br>Cure<br>Time <sup>3</sup> |
|-------|---|---|--------------------------------------|
| A-1/2 | ½ hour                                      | 8 hours                                   | 18 hours                             |
| A-2   | 2 hours                                     | 24 hours                                  | 48 hours                             |

## Typical Physical and Performance Properties of Cured Compound when tested per AMS 3267

|   |  |
|---|--|
| Color   | Red/Purple   |
| Specific Gravity  | 1.53   |
| Hardness  | 45 Shore "A"   |
| Adhesion to Aluminum steel,<br>stainless steel, titanium, zinc,<br>cadmium, chromium,<br>magnesium, glass, enamel,<br>Epoxy MIL-P-23377 and<br>Urethane MIL-C-27725 | ≤ 3 lb./in of width<br>positive adhesion   |
| Elongation  | 200%   |
| Temperature Range   | -65° to +200°F   |
| Low Temperature Flexibility   | -65°F (-54°C)  |
| Fuel Resistance   | 4.5% weight loss after 7 days at<br>140°F in TT-S-735, Type III<br>fuel.<br>5.5% weight loss after 9 days at<br>140°F in TT-S-735, Type VII<br>fuel containing up to 0.015% by<br>weight of n-butyl mercaptan. |
| Resistance to other fluids  | Excellent resistance to water,<br>alcohols, petroleum and synthetic<br>lubricating oils and petroleum-<br>base hydraulic fluids  |
| Fungus Resistance   | Non-nutrient   |

<sup>1</sup> Application life refers to the length of time that mixed compound remains at a consistency suitable for application with brush or roller. 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-615 Class A 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.



## Mixing Instructions

### 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. *Note: Do not inject all of catalyst in one location. Distribute evenly throughout base material.*
4. Repeat steps 2 and 3 until all the contents of the rod are emptied into the cartridge. Remove the ramrod.
5. Mix for the required number of strokes (hand mixing) or for the required amount of time (machine mixing) indicated in the kit instructions.
6. When mixing is complete, remove bottom cap.
7. Pull the dasher rod back to the neck of the cartridge, grasp the cartridge firmly at the neck, unscrew the dasher rod and remove.
8. 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-®615 Class A sealant is 12 months from date of manufacture, when stored at temperatures below 80°F in its original container.

Mixed AC-®615 Class A 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 of available application time.

## Health and Safety Precautions

AC-®615 Class A 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-615A-09/09

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Page 2 of 2