

# Naftoseal<sup>®</sup> MC-650 Class B

## FUSELAGE SEALANT

### 1 Description

Naftoseal<sup>®</sup> MC-650 Class B is a two-component, manganese-dioxide cured polysulfide polymer system providing excellent fuselage seals. It has outstanding resistance to aviation gasoline and jet fuel, as well as resistance to the chemicals and petroleum products used in the aircraft industry.

Naftoseal<sup>®</sup> MC-650 Class B maintains its flexibility and bond strength on most metal substrates like aluminum, stainless steel, steel, titanium, composite and many coatings under extremes of temperature, weathering and stress.

Naftoseal<sup>®</sup> MC-650 Class B Techkits can be mixed by MCI-Mixer or by appropriate 2-component mixing and dosing systems.

The mixed compound is a thixotropic paste easily applied by extrusion, injection gun or spatula. It has excellent tooling properties. For a good surface finish Naftosmooth can be used after application.

The curing time may be reduced considerably by increasing the temperature (up to 60 °C / 140 °F max).

### 2 Field of application

- Sealing fuselages

### 3 Specifications

Application life and cure time at 23°C (73°F) / 50% r.H.			
Type	Min. Application Time	Tack Free Time	Time to Shore A 35
Naftoseal® MC-650 B-1	1,0 hours	≤ 7 hours	≤ 10 hours
Typical Physical and Application Properties			
	Base	Hardener	
Colour	Cream	Brown	
Viscosity at 23 °C, Brookfield RV, Spindel 7	1.200 ± 300 Pa.s (2 rpm)		
Mixing ratio by weight	100	11	
Mixing ratio by volume	100	10,93	
Non-volatile content	97 ± 2 %		

**Typical Values of MC-650 Class B after 14 days at 23 °C (73 °F) / 50 % r.h.**

Colour	Brown
Specific gravity	1,65 g/ccm max.
Ultimate Shore A Hardness:	60 max.
Service temperature	-55 °C (-67 °F)/ +130 °C (+266 °F)
Tensile Strength	≥ 2,0 N/mm <sup>2</sup>
Elongation	Ca. 270 %
Peel Strength on Aluminum, Epoxy Primer, Top Coat and other Substrates	≥ 150 N/25mm
<b>Mixing Instruction for Techkits</b>	
Naftoseal® MC-650 B	Motor revolution in rpm      Strokes up and down      Mixing Time
	110 ± 10      90      2 Min ± 1 Min

#### 4 Surface preparation

To obtain good adhesion, clean surfaces with appropriate cleaners (e.g. Chemetall's Ardrex® products like Ardrex® 5529 or Ardrex® 5575) to remove dirt, grease and processing oils just prior to sealant application. Use lint-free rags or paper towels that are free of oil. Always pour cleaner on the cloth to avoid contamination of the cleaner supply. Clean one small area at a time, quickly wiping it dry before the cleaner's solvent evaporates to prevent redeposition of oil, wax or other contaminants. Usually, in the case of most epoxy resin primers, surfaces need not be additionally prepared with an adhesion promoter to improve adhesion. PUR and EP topcoats as well as composite components should be pre-treated by the Naftoseal® MC-110 Adhesion Promoter.

#### 5 Packaging

Designation	Base Compound Content/Pierce	No. / Case
Techkit 55	58 ccm	24
Techkit 130	137 ccm	24
Kit 25	263 ccm	12
Kit 100	1050 ccm	4
Pail	162 litre	9 x 18 l Base + 1 x 19 l Hardener
Drum	162 litre	1 x 162 l Base + 1 x 19 l Hardener

#### 6 Storage

The shelf life of Naftoseal® MC-650 Class B is 6 months from date of manufacture, when stored at temperatures below 26 °C in its original unopened container.

#### 7 Health and safety precautions

See Safety Data Sheet.

The above details have been compiled to the best of our knowledge on the basis of tests and research work and with regard to the current state of our practical experience. This technical product information is non-binding. No liabilities or guarantees deriving from or in connection with this leaflet can be imputed to us. Statements relating to possible uses of the product do not constitute a guarantee that such uses are appropriate in a particular user's case or that such uses do not infringe the patents or proprietary rights of any third party. The reproduction of any or all of the information contained in this leaflet is expressly forbidden without Chemetall's prior written consent.

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