

TECHNICAL DATA

PR-1829 Class B Rapid Curing Windshield and Canopy Sealant

Description

PR-1829 Class B is a rapid curing aircraft windshield and canopy sealant. It has a service temperature range from -80°F (-62°C) to 320°F (160°C), with intermittent excursions up to 420°F (216°C). This material is designed for fillet sealing of glass, polycarbonate, acrylic and other aircraft sealing applications. The product contains no organic solvents and does not craze substrates. The cured sealant exhibits excellent resistance to UV and weather exposure.

PR-1829 Class B is a two-part, epoxy cured Permapol® P-3 polythioether compound. The uncured material is a low sag, thixotropic paste, suitable for application by extrusion gun or spatula. Unlike standard polysulfide windshield sealants, it can cure at low temperatures and is unaffected by changes in relative humidity. This sealant has excellent adhesion to common aircraft substrates.

The following tests are in accordance with PRC-DeSoto International and other OEM specification test methods.

Application Properties (Typical)

Color			
Part A		Black	
Part B		White	
Mixed		Gray	
Mixing ratio		Part A:Part B	
By weight		12.5:100	
Base viscosity			
(Brookfield #7 @ 2 rpm),			
Poise (Pa-s)		16,000 (1600)	
Slump, inches (mm)			
	Initial	50 Minutes	90 Minutes
B-1/4	0.30 (7.62)	_____	_____
B-1/2	0.25 (6.35)	_____	_____
B-2	0.20 (5.08)	0.30 (7.62)	0.30 (7.62)
Application life and cure time @ 77°F (25°C), 50% RH			
	Application life (hours)	Tack free time (hours)	Cure time to 30 A Durometer (hours)
B-1/4	1/4	<2	3
B-1/2	1/2	<3	4
B-2	2	<16	24

Performance Properties (Typical)

Cured 7 days @ 77°F (25°C), 50% RH	
Cured specific gravity	1.47
Nonvolatile content, %	99
Ultimate cure hardness, Durometer A	45
Peel strength, pli (N/25 mm), 100% cohesion	
Dry, 14 days @ 77°F (25°C) + 7 days @ 140°F (60°C)	
MIL-G-25667 (Glass)	50 (222)
MIL-P-8184 (Acrylic)*	50 (222)
MIL-P-83310 (Polycarbonate)*	55 (245)
AMS 2629 JRF immersion, 7 days @ 140°F (60°C)	
AMS 2471 (Anodized aluminum)	38 (169)
AMS 4901 (Titanium)*	40 (178)
AMS 5516 (Stainless steel)*	40 (178)
MIL-C-5541 (Alodine aluminum)	35 (156)
MIL-C-27725 (IFT coating)	42 (187)
AMS 2629 JRF/NaCl-H ₂ O immersion, 7 days @ 140°F (60°C)	
AMS 2471 (Anodized aluminum)	50 (222)
AMS 4901 (Titanium)*	54 (240)
AMS 5516 (Stainless steel)*	53 (236)
MIL-C-5541 (Alodine aluminum)	55 (245)
MIL-C-27725 (IFT coating)	52 (231)
Dry, 14 days @ 77°F (25°C) + 7 days @ 140°F (60°C)	
MIL-G-25667 (Glass)	50 (222)
MIL-P-8184 (Acrylic)*	50 (222)
MIL-P-83310 (Polycarbonate)*	55 (245)
*Primed with PR-1861 Adhesion Promoter	
Tensile strength, psi (KPa), Standard cure, 7 days @ 77°F (25°C), 50% RH	
14 days immersion in JRF @ 140°F (60°C)	411 (2834)
8 hours @ 360°F (182°C)	230 (1586)
	255 (1758)
Elongation, %	
Standard cure, 7 days @ 77°F (25°C), 50% RH	
14 days immersion in JRF @ 140°F (60°C)	283
8 hours @ 360°F (182°C)	262
	150
Thermal rupture resistance - Retains pressure of 10 psi with only negligible deformation, both before and after immersion in AMS 2629 JRF.	
Low temperature flexibility @ -65°F (-54°C) - No cracking, checking or loss of adhesion.	

PR-1829 Class B Rapid Curing Windshield and Canopy Sealant

Resistance to hydrocarbons - 7 days @ 140°F (60°C)
immersed in AMS 2629 JRF.

Weight loss, % 3.2

Flexibility - No cracks after bending 180 degrees over
0.125 inch (3.18 mm) mandrel.

Repairability to itself - Excellent to both freshly cured
as well as fuel aged and abraded fillets.

Fungus resistance Non-nutrient

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.

Surface Preparation

Immediately before applying sealant to primed substrates, the surfaces should be cleaned with solvents. Contaminants such as dirt, grease, and/or processing lubricants must be removed prior to sealant application.

A progressive cleaning procedure should be employed using appropriate solvents and a new lint-free cloth conforming to AMS 3819. (Reclaimed solvents or tissue paper should not be used.) Always pour solvent on the cloth to avoid contaminating the solvent supply. Wash one small area at a time.

It is important that the surface is dried with a second clean cloth prior to the solvent evaporating to prevent the redeposition of contaminants on the substrate.

Substrate composition can vary greatly. This can affect sealant adhesion. It is recommended that adhesion characteristics to a specific substrate be determined prior to application on production parts or assemblies.

For a more thorough discussion of proper surface preparation, please consult the SAE Aerospace Information Report AIR 4069. This document is available through SAE, 400 Commonwealth Avenue, Warrendale, PA 15096-0001.

Packing Options

PR-1829 Class B is supplied in two-part Semco® cartridges.

Mixing Instructions

See the container for specific mixing instructions. The mix ratio is very critical.

Storage Life

The storage life of PR-1829 Class B is at least 9 months when stored at temperatures below 80°F (27°C) in original, unopened containers.

Health Precautions

This product 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.

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).

Permapol and Semco are trademarks of PRC-DeSoto International, Inc., registered with the U.S. Patent Office.

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.

PRC-DeSoto International, Inc.
12780 San Fernando Road
Sylmar, CA 91342
Telephone (818) 362-6711
Toll Free (800) AEROMIX
www.ppgaerospace.com

Issue Date: 07/12
Supersedes: 09/09
Lit: 0315