NAFTOSEAL MC-780 CLASS B

Fuselage and Fuel Tank Sealant

PRIMARY APPLICATION

NAFTOSEAL MC-780 Class B is a two-component, manganese-dioxide cured, low-density, liquid polysulphide polymer system providing excellent fuel tank and 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 MC-780 Class B maintains its flexibility and bond strength on most metal substrates like aluminum stainless steel, steel, titanium and many coatings under the extremes of temperature, weathering and stress. Mixed compound is a thixotropic paste easily applied by extrusion, an injection gun or a spatula. It has excellent tooling properties.

APPLICATIONS

- Sealing fuselages
- Sealing fuel tanks

APPROVALS

Naftoseal MC-780 Class B is approved by Airbus, Bombardier, Embraer, Eurocopter, and others on request. Speak to your Chemetall representative for complete approvals.

SPECIFICATIONS

Application Life and Cure Time at 73.4°F/50% r.H.			
Type	**Min. Application Time**	**Max. Tack-Free Time**	**Time to Shore A 30**
NAFTOSEAL			
MC-780 B 1/2	0,5 Std./hours	≤ 4 Std./hours	≤ 8 Std./hours
MC-780 B 1	1,0 Std./hours	≤ 7 Std./hours	≤ 10 Std./hours
MC-780 B 2	2,0 Std./hours	≤ 14 Std./hours	≤ 24 Std./hours
MC-780 B 4	4,0 /std,/hours	≤ 20 Std./hours	≤ 48 Std./hours

Typical Physical and Application Properties		
	Base	Hardener
Color	Grey	Brown
Viscosity @ 73.4° F, Brookfield, Spindel7	800 ± 200 Pa.s (B-1) 14,00 ± Pa.s (B-1/2, B-2, B-4) (2 rpm)	max. 200 Pa.s (10 rpm)
Mixing ratio / by weight	100	10
Mixing ratio / by volume	100	6,2
Non-volatie content	≥94% (B-1), ≥97% (B-1/2, B-2)	

Typical Physical & Performance Properties of Cured Compound after 14 days / 23°C	
Color:	Grey
Specific gravity:	1.1 g/ccm
Ultimate Shore A Hardness:	50 max.
Service Temperatures:	-67°F / 266°F

1. Typical Values of MC-780 Class B		
Tensile Stength (N/mm² / Elongation (%)		
Conditioning	Typical Values	
	N/mm²	%
14 days 73.4°F	≥1,5	300
6 months fuel / 73.4°F	≥1,5	300

2. Peel Strength (N/25mm/%Cohesion)		
Adherend	Conditioning	Typical Values
Al + Epoxy Primer	14 days 73.4°F	≥120 N/25mm - 100%
	300 h jet-fuel @ 212°F	≥120 N/25mm - 100%
Al + Epoxy + PU Topcoat	14 days 73.4°F	≥120 N/25mm - 100%

SURFACE PREPARATION

To obtain good adhesion, clean surface with Ardrox 5503 or like product 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 to dry before the cleaner's solvent evaporates to prevent redeposition of the oil, wax or other contaminants. In cases where an adhesion promoter is required, components should be pre-treated by the Naftoseal MC-115 Adhesion Promoter.

EQUIPMENT

Cleaning:

Immediately after use of the sealant, wash equipment and tools with Ardrox 5503 or like product to remove uncured, semi-cured Naftoseal sealants.

NOTES ON USE (See Safety Data Sheet)

SAFETY AND HANDLING

Prior to handling and use of any of the materials referenced in this document, the Safety Data Sheets should be read and understood by all personnel in contact with these materials.

KEEP OUT OF REACH OF CHILDREN

STORAGE

Dry indoor storage at temperatures between 40°F and 100°F (4.4°C and 37.8°C) is recommended, away from any incompatible materials referenced in the Safety Data Sheets. All containers should be tightly closed when not in use.

SHELF LIFE

The shelf life of Naftoseal MC-780 Class B is 6 months from date of manufacture, when stored at the temperatures below 78.8°F in its original unopened container.

DISPOSAL

Any disposal of the materials referenced in this document should be in accordance with all applicable federal, state, providential and local regulations. The process solution can contain components other than those present in the materials as supplied. Analysis of process solutions may be required prior to disposal.

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