PR 1771 Class B
CORROSION INHIBITIVE SEALANT
NON-CHROMATE
LOW GRAVITY

USE
PR 1771 Class B is a two-part, non-chromate, low gravity, corrosion inhibitive sealant designed for filling and smoothing gaps, slots and depressions on exterior aircraft surfaces. It also provides an effective barrier against the common causes of corrosion in aircraft today.
PR 1771 Class B will resist aircraft fuels (aviation gasoline or jet fuel), oils and hydraulic fluids.

DESCRIPTION
PR 1771 Class B is a two-part manganese cured, based on Permapol P-5 liquid polymers, a chemically modified improved class of polysulfide polymers. The mixed compound is a thixotropic paste which can be readily applied by spatula or extrusion gun. It does not flow from vertical or overhead surfaces.

SPECIFICATION
HMRC6002A
AIMS 04-05-001
APPLICATION PROPERTIES
(23°C / 50 %HR)

Couleur
Base Beige
Accelerator Black
Mixing ratio Part A / Part B 10:1 by weight

Nonvolatile content (mixed compound) 92.5 %

Viscosity (Brookfield # 6 @ 2 rpm) 1100 Pa.s

Vertical Flow:
Initial 2 mm

Application Life and Cure Time

<table>
<thead>
<tr>
<th>Application Life</th>
<th>Tack Free Time</th>
<th>To 30 Shore A</th>
</tr>
</thead>
<tbody>
<tr>
<td>(hours)</td>
<td>(hours)</td>
<td>(hours)</td>
</tr>
<tr>
<td>B 2</td>
<td>16</td>
<td>24</td>
</tr>
</tbody>
</table>

PERFORMANCE PROPERTIES (typical)

Color Black
Specific Gravity 1.15
Hardness, Shore A 45
Low temperature flexibility Passes

Adhesion - Peel strength (N/mm)
14 days 23°C / 100 % Cohesive

<table>
<thead>
<tr>
<th></th>
<th>with PR 148 AF</th>
<th>with PR 184</th>
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<tbody>
<tr>
<td>Alclad 2024</td>
<td>5.8</td>
<td>5.9</td>
</tr>
<tr>
<td>Stainless steel</td>
<td>5.6</td>
<td>5.2</td>
</tr>
<tr>
<td>Titanium</td>
<td>5.0</td>
<td>5.0</td>
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<tr>
<td>Pac 33 NV</td>
<td>4.4</td>
<td>5.8</td>
</tr>
<tr>
<td>PU 66 abraded</td>
<td>4.9</td>
<td>5.0</td>
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14 days 23°C + 7 days JP1 60°C

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<td>4.2</td>
<td>5.7</td>
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Tensile Strength and Elongation:
Initial

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<tr>
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<th>Tensile Strength</th>
<th>Ultimate Elongation</th>
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<tr>
<td></td>
<td>1.28 MPa</td>
<td>395 %</td>
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Corrosion resistance

No sign of corrosion and sealant deterioration after:
Salt spray method 2000 hrs
Galvanic cell method 1 week
Al / Titanium couple
Al / Cadmium plated steel couple

Weight Loss 3.3 %
Flexibility Flexible

NOTE: The above application and performance property values are typical for the material, but are not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.

SURFACE PREPARATION

Part shall be cleaned with solvents to remove dirt, grease, and processing lubricants used in manufacturing. Wash one small area at a time, then dry with a clean cloth before solvent evaporates to prevent redeposition of oil, wax or other surface contaminants. To maintain a clean solvent supply, always pour the solvent on the washing cloth.

MIXING INSTRUCTIONS

Proper mixing and correct proportions are extremely important if optimum results are to be obtained. Mixing by experienced personnel at a central location is recommended.

CAUTION: Do not mix accelerator with compound until ready to use.
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1° Thoroughly stir accelerator in its container until an even consistancy is obtained.
2° Thoroughly stir base compound in its container until an even consistancy is obtained.
3° Slowly stir the accelerator into the base compound and thoroughly mix approximately 7 to 10 minutes. Be sure to scrape the sides and bottom of the container in order to include all the compound in the mixture and to assure uniform blending. Scrape mixing paddle periodically to remove unmixed compound. Slow mixing by hand is recommended.

FRACTIONAL USE OF UNIT:

When it is desired to use only part of the kit, after homogenization, remove the required quantity. (§ APPLICATION PROPERTIES).

For all informations, consult the Engineering Services of LE JOINT FRANCAIS.

SEMKIT TWO-PART SEALANT CARTRIDGE

1° Wear safety glasses.
2° Hold cartridge and pull back dasher rod one fourth.
3° Pull back the dasher rod as injecting as proportionnaly as possible the contents accelerator into the base.
4° Mix material, rotate dasher rod 90° in aspiral clockwise motion; with each stroke turn the dasher rod 90°.
5° When two-parts are mixed thoroughly, pull dasher rod back to the neck of cartridge, grasp cartridge firmly at neck, unscrew dasher rod counterclockwise and remove.
6° Screw nozzle into cartridge, material is ready for extrusion.

For all informations, consult the Technical Services of LE JOINT FRANCAIS.

APPLICATION INSTRUCTIONS

Application life is the period of time that the mixed compound remains at a consistency suitable for application with injection or extrusion guns. Application life is always based on standard conditions at 23°C and 50% relative humidity.

Apply the sealant with an extrusion gun equipped with 3 to 6 mm tip. Hold gun nearly perpendicular so that extruded sealant will be forced into the lip of seam. On most application, the fillet should be 3 to 5 mm thick, but heavier fillets can be applied in a single operation, if necessary.

CURING

The length of the cure depends on the ambient temperature and relative humidity. The temperature/time relationship is approximately the same for curing as it is for application life. Low humidities may extend the cure several times. Cure may hastened by applying heat up to 55°C.

CLEANING EQUIPMENT

Equipment should be cleaned immediately after use with methylethylketone. Cured material may be removed with commercial product.

STORAGE LIFE

The storage life of PR 1771 B is 6 months when stored in the original, unopened containers at temperature below 25°C.

HEALTH PRECAUTIONS

PR 1771 B is a safe material to handle when reasonable care is observed. Ordinary hygienic principles, such as washing the compound from hands before eating or smoking, should be observed.

For additional health and safety information consult a Material Safety Data Sheet which is available upon request on www.ljfm.com.

GUARANTEED

We guarantee all our products against faulty materials or preparation. Our sole responsibility shall be to replace, free of charge, those products which prove to be defective, the user being entitled to no indemnity for any reason whatsoever. All recommendations contained herein as to the choice of materials or of certain methods of operation are of an informative character and are based on tests and experiments we believe to be reliable and correct, but accuracy and completeness of such tests are not guaranteed and are not to be construed as a warranty, either express, or implied.

Neither our company, nor any of its collaborators shall be liable to the user for any injury, loss or damage directly or indirectly resulting from the use of, or inability to use, the products, which does not comply with the application instructions as specified in our information manual. Recommendations or statements other than those contained in a written document signed by an officer of our company shall not be binding upon the company.