

CS 3600 Top Coat

Chem Seal

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TOP COAT AND HIGH BOND STRENGTH ADHESIVE

PRODUCT DESCRIPTION qualified to AMS-S-4383 formerly MIL-S-4383C

CS 3600 is a one-part high bond strength adhesive which finds application in a wide variety of purposes, especially where resistance to oils, gasoline, aromatic fuels and corrosion is desired. Most materials such as synthetic rubber, metals, glass and plastics can be bonded very effectively with this adhesive. CS 3600 is also used as a top coat for polysulfide sealants in integral fuel tanks for aircraft.

APPLICATION

The surfaces to be bonded should be clean, dry and free from oil, dirt and grease. A thin even coat of CS 3600 is brushed onto each surface to be bonded. If the surface is very porous more than one coat may be necessary in which case a drying time of 10 minutes is allowed between coats. Allow 4 days air dry for cure.

Bonding is accomplished by allowing the adhesive to dry to a tacky condition and then joining the surfaces, and pressing or rolling firmly together to insure intimate contact (The tacky condition is reached when the adhesive adheres but is not transferred to the finger when touched). Bonding can also be accomplished by solvent reactivation or heat reactivation.

SOLVENT REACTIVATION: CS 3600 is allowed to dry until completely tack free. The surfaces are then moistened by wiping with a rag dampened in a low boiling ketone solvent, and the surfaces are bonded together as described above.

HEAT REACTIVATION: CS 3600 is allowed to dry completely tack free. The surfaces to be bonded are then joined together applying sufficient pressure to maintain good contact, followed by heating in an oven at 250°F - 300°F.

STORAGE LIFE

CS 3600 may be stored for approximately 6 months below 80°F, in the original unopened containers without deterioration of the usefulness or performance properties of the cured material.

COVERAGE

One Gallon of CS 3600 covers an area of approximately 200 square feet with a normal brush coat. Approximately one mil dry film thickness.

Color	Red or Amber
Base	Oil Resistant Synthetic Rubber
Consistency	Thin Syrup
Solids Content	20%
Specific Gravity	0.88
Temperature Resistance	Does not appreciably soften at temperature up to 250°F.
Low Temperature Flexibility	Flexible at -100°F
Shear Strength	150 PSI
Strip Adhesive (Peel)	10 lbs/inch

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SAFETY

" Flamemaster supplied aviation fuel tank sealants and coating materials are tested for compatibility with reference fluids and fuels as specified by the applicable specification. Flamemaster does not warranty the performance of fuel tank sealants or coatings subjected to fluids or fuels other than those specified by the applicable specification."

It is the responsibility of the user to determine the suitability for use utilizing the information contained in the applicable specification."

WARNING: CS 3600 contains a volatile flammable solvent. Containers should be kept away from heat and open flame and should be kept closed when not in use. Refer to the applicable Material Safety Data Sheet prior to using this product.

PACKAGING

CS 3600 is packaged in Quarts, Gallons, 5-Gallons, and 50 Gallon Drums.

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 user assumes all risk and liability resulting from the use of this 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 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.