



D Aircraft Products, Inc. 1191 Hawk Circle, Anaheim, CA 92807

DAPCO™ 72 RAPID CURE WINDSHIELD SEALANT

GENERAL DESCRIPTION

DAPCO™ 72 is a general purpose sealant which cures rapidly in ambient conditions. Best results are obtained when the product is exposed to moderate humidity. In addition to good abrasion and weather resistance, DAPCO™ 72 is less sensitive to cure inhibition than most silicone RTV compounds. The product is available as two-component kits and in pre-packaged cartridges.

APPLICATIONS

DAPCO™ 72 has been demonstrated to be a useful sealant in a variety of applications where quick setting is desired - e.g. windshield sealants, repair caulks, adhesives, etc.

TYPICAL PROPERTIES

	PART A	PART B
Color	Grey	Tan
Appearance	Thixotropic Paste	Viscous Liquid
Density lbm/gal	10	11
Viscosity (cps @72°F)	Heavy Paste	50,000

PROCESSING

Mix Ratio: The recommended mix ratio for DAPCO™ 72 is:

	Weight	Volume
Part A	100	100
Part B	15	13.5

The product is a heavy paste and must be mixed thoroughly prior to use. When using a mechanical mixer, care must be taken to avoid high shear equipment that may destroy thixotropy.

Working Life: The working life of the mixture is 10 to 15 minutes at 72°F (22°C) after mixing. In the presence of humidity in excess of 60%, the working life will be shortened.

Curing: DAPCO™ 72 is generally cured at moderate temperatures, e.g. 72°F (22°C) and requires the presence of minimal humidity. Cure can be accelerated by warming to 150°F (65°C). Optimum physical

Dapco™ 72
Page 1 of 1

properties are developed when the product is cured for three days at 72°F (22°C).

SURFACE PREPARATION

The substrate must be free from contaminants, i.e., dirt, oil, grease, etc. Clean the surface by wiping with a suitable solvent/cleaning agent and dry thoroughly. Apply DAPCO™ 1-200 Primer and then the DAPCO™ 72. (Note: The sealant must be applied within 90 minutes after the primer has dried.) When circumstances prevent immediate application of DAPCO™ 72, the surface must be cleaned thoroughly to remove the primer before repeating the entire process.

TYPICAL CURED PROPERTIES

When cured in accordance with the recommended schedule, the following properties are developed:

Hardness (Shore A) ASTM D224	40
Tensile Strength (psi) ASTM D412	325
Elongation (%) ASTM D412	175
Tear Strength (pli) ASTM D624	20
Specific Gravity	1.30

STORAGE AND HANDLING

Store in a cool, dry place. Keep containers tightly sealed. Shelf life: 6 months from date of shipment

SAFETY

Although DAPCO™ 72 is considered safe to handle, good housekeeping practices should be followed. Avoid ingestion. DAPCO™ 72 curing agent contains metal soap. Avoid contact with skin to prevent irritation. Material Safety Data Sheets are available upon request.

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