

# 3M™ AC-350 Class A Aerospace Sealants

## Technical Data Sheet

3M™ AC-350 Class A Aerospace Sealants are designed for aircraft integral fuel tank and fuselage applications. When mixed, these two-part manganese dioxide cured polysulfide sealants form a pourable compound that is easily applied by brush or roller. AC-350 Sealants have a service temperature range of -65 °F to 250 °F (-54 °C to 121 °C), with intermittent excursions (6 hours total) to 360 °F (182 °C).

### Key Features

- Resistant to common commercial and military jet fuels
- Optimized mixing, application and tooling characteristics
- Maintain flexibility and bond strength on a variety of metal, composite, and coated substrates during service

### Application Properties<sup>1</sup>

Class	Application Time <sup>2</sup>	Tack Free Time <sup>3</sup>	Cure Time to ≥ 30A Hardness
A-1	1 hour	5 hours	8 hours
A-2	2 hours	8 hours	12 hours

### Physical and Performance Properties

Color	Base: White Accelerator: Dark Brown Mixed: Gray
Mix Ratio, base to accelerator	10 : 1 by weight 12.7 : 1 by volume
Nonvolatile Content	89%
Base Viscosity, Brookfield #6 10 rpm, 77 °F (25 °C)	200 – 500 poise 20 – 50 Pa·s
Specific Gravity, cured	1.4
Ultimate Hardness, Durometer A	48 – 53
Thermal Rupture Resistance 250 °F (121 °C), 10 psi (69 kPa), 60 minutes	≤ 0.125 inch (3.18 mm) No blistering or sponging

### 180° Peel Strength

**AMS2629 Type 1 Jet Reference Fluid (JRF) Immersion**  
**7 days at 140 °F (60 °C), 100% cohesive failure**

Substrate	Load lbf/inch (N/25 mm)
MIL-DTL-5541 Conversion Coating	48 (210)
AMS2471 Sulfuric Acid Anodize	33 (140)
AMS-C-27725 Ty 2 Fuel Tank Coating	49 (210)
AMS5516 Stainless Steel	46 (200)
AMS4911 Titanium Alloy	50 (220)
AS4/3501-6 Graphite epoxy (ply side)	29 (130)
AS4/3501-6 Graphite epoxy (tool side)	34 (150)
IM7/5250-4 Graphite BMI (ply side)	39 (170)
IM7/5250-4 Graphite BMI (tool side)	28 (120)

**AMS2629 Type 1 JRF/3% Saltwater Bi-layer Immersion**  
**7 days at 140 °F (60 °C), 100% cohesive failure**

Substrate	Load lbf/inch (N/25 mm)
MIL-DTL-5541 Conversion Coating	60 (260)
AMS2471 Sulfuric Acid Anodize	42 (180)
AMS-C-27725 Ty 2 Fuel Tank Coating	56 (250)
AMS5516 Stainless Steel	54 (240)
AMS4911 Titanium Alloy	53 (230)
AS 4/3501-6 Graphite epoxy (ply side)	29 (130)
AS 4/3501-6 Graphite epoxy (tool side)	33 (140)
IM7/5250-4 Graphite BMI (ply side)	38 (170)
IM7/5250-4 Graphite BMI (tool side)	27 (120)

### 3% Saltwater Immersion

**7 days at 140 °F (60 °C), 100% cohesive failure**

Substrate	Load lbf/inch (N/25 mm)
MIL-PRF-85285 Urethane Topcoat	32 (140)
MIL-PRF-85582 Water-based Primer	49 (210)
MIL-PRF-23377, Standard cure	55 (240)
MIL-PRF-23377, 200 °F (93 °C) cure	28 (120)

## Shelf Life and Storage

The shelf life of 3M™ AC-350 Class A Aerospace Sealants in 2-part kits is 9 months from Date of Packaging (DOP), when stored below 80 °F (27 °C) in the original unopened containers. Pre-mixed and frozen (PMF) AC-350 Class A sealants will maintain typical application properties for a minimum of 30 days if stored at or below -40 °F (-40 °C).

**Note:** Industry and/or OEM specifications to which the product is qualified may establish different storage requirements. The information shown on the product label and/or the accompanying Certificate of Analysis (COA) takes precedence over the Technical Data Sheet.

## Mixing and Thawing Instructions

**2-Part Injection Kits:** Hand Mix: 50 - 75 strokes; Machine Mix: 50 strokes (2 minutes at 25 strokes/min).

**2-Part Can Kits (Bulk):** Only base and catalyst compounds with the same lot numbers should be mixed. Stir catalyst before using. Mix entire contents of both containers together or mix in appropriate base to accelerator ratio until sealant is uniform in color with no streaks.

**Pre-Mixed Frozen (PMF):** Thaw at ambient temperature until core reaches 50 °F (10 °C), minimum, and/or until condensation no longer forms after wiping the cartridge exterior. Do not refreeze after thawing.

<sup>1</sup> Testing per AMS-S-8802, AMS3276 and AS5127/1.

Standard Conditions: 77 °F (25 °C) and 50 % Relative Humidity.

Sealant cure for performance properties: 14 Days at Standard Conditions

OR 48 hours at Standard Conditions + 24 hours at 140 °F (60 °C).

<sup>2</sup> Viscosity of ≤ 2500 poise (#6 spindle, 10 rpm), at Application Time.

<sup>3</sup> No sealant transfer to low density polyethylene film.

**Precautionary Information:** Refer to Product Label and Safety Data Sheet for health and safety information before using this product. For additional health and safety information, visit [www.3m.com/3M/en\\_US/company-us/SDS-search/](http://www.3m.com/3M/en_US/company-us/SDS-search/)

### Authorization to Use

Ensure products meet all applicable specifications, standards, and maintenance manual requirements for the platform being worked on and validate all aircraft approvals against current technical documentation.

These products are manufactured under a 3M Quality Management System registered to the AS9100 standard.

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