

## 3M AC-250 A-1/6 Aerospace Sealant

Category : Polymer , Thermoset

### Material Notes:

3M Aerospace Sealant AC-250 A-1/6 is a two-part, low temperature curing polysulfide, quick repair sealant for integral fuel tank and fuselage sealing applications. The mixed compound is a pourable liquid which can be applied with a spatula, extrusion gun, roller, or brush. It will cure to a fuel-resistant rubber at temperatures above -6.7°C. Information provided by 3M

Order this product through the following link:

[http://www.lookpolymers.com/polymer\\_3M-AC-250-A-16-Aerospace-Sealant.php](http://www.lookpolymers.com/polymer_3M-AC-250-A-16-Aerospace-Sealant.php)

Physical Properties	Metric	English	Comments
Density	1.61 g/cc	0.0582 lb/in <sup>3</sup>	AMS-S83318
Volatiles	<= 11 %	<= 11 %	
Brookfield Viscosity	100000 - 400000 cP	100000 - 400000 cP	Base, RVF #6 sp @ 2 rpm

Mechanical Properties	Metric	English	Comments
Hardness, Shore A	40	40	Hydrolytic Stability; AMS-S83318
	55	55	AMS-S83318
Tensile Strength at Break	1.52 MPa	220 psi	JRF; AMS-S83318
	@Temperature 60.0 °C, Time 1.21e+6 sec	@Temperature 140 °F, Time 336 hour	
	2.14 MPa	310 psi	JRF; AMS-S83318
	@Temperature 121 °C, Time 605000 sec	@Temperature 250 °F, Time 168 hour	
	2.07 MPa	300 psi	Standard Cure; AMS-S83318
	@Time 1.21e+6 sec	@Time 336 hour	
Elongation at Break	180 %	180 %	JRF; AMS-S83318
	@Temperature 121 °C, Time 605000 sec	@Temperature 250 °F, Time 168 hour	
	225 %	225 %	JRF; AMS-S83318
	@Temperature 60.0 °C, Time 1.21e+6 sec	@Temperature 140 °F, Time 336 hour	
	220 %	220 %	Standard Cure; AMS-S83318
	@Time 1.21e+6 sec	@Time 336 hour	
Peel Strength	3.68 kN/m	21.0 pli	JRF, Stainless Steel; AMS-S83318
	@Temperature 60.0 °C,	@Temperature 140 °F,	

Mechanical Properties	Time 605000 sec Metric	Time 168 hour English	Comments
	3.68 kN/m	21.0 pli	JRF/SW, Alodine; AMS-S83318
	@Temperature 60.0 °C, Time 605000 sec	@Temperature 140 °F, Time 168 hour	
	4.21 kN/m	24.0 pli	JRF/SW, MIL-C-27725; AMS-S83318
	@Temperature 60.0 °C, Time 605000 sec	@Temperature 140 °F, Time 168 hour	
	4.21 kN/m	24.0 pli	JRF/SW, Alclad; AMS-S83318
	@Temperature 60.0 °C, Time 605000 sec	@Temperature 140 °F, Time 168 hour	
	4.38 kN/m	25.0 pli	JRF, MIL-C-27725; AMS-S83318
	@Temperature 60.0 °C, Time 605000 sec	@Temperature 140 °F, Time 168 hour	
	4.38 kN/m	25.0 pli	JRF, Alclad; AMS-S83318
	@Temperature 60.0 °C, Time 605000 sec	@Temperature 140 °F, Time 168 hour	
	4.38 kN/m	25.0 pli	JRF, Titanium; AMS-S83318
	@Temperature 60.0 °C, Time 605000 sec	@Temperature 140 °F, Time 168 hour	
	4.56 kN/m	26.0 pli	JRF/SW, Stainless Steel; AMS-S83318
	@Temperature 60.0 °C, Time 605000 sec	@Temperature 140 °F, Time 168 hour	
	4.56 kN/m	26.0 pli	JRF, Alodine; AMS-S83318
	@Temperature 60.0 °C, Time 605000 sec	@Temperature 140 °F, Time 168 hour	
	4.73 kN/m	27.0 pli	JRF/SW, Titanium; AMS-S83318
	@Temperature 60.0 °C, Time 605000 sec	@Temperature 140 °F, Time 168 hour	

Thermal Properties	Metric	English	Comments
Maximum Service Temperature, Air	121 °C	250 °F	AMS-S83318
Minimum Service Temperature, Air	-54.0 °C	-65.2 °F	AMS-S83318

Processing Properties	Metric	English	Comments
Cure Time	70.2 min	1.17 hour	Tack-Free Time
	@Temperature 25.0 °C	@Temperature 77.0 °F	
	120 min	2.00 hour	

Processing Properties	Metric	English	Comments
	@ Temperature 25.0 °C	@ Temperature 77.0 °F	
	420 min	7.00 hour	Tack-Free Time
	@Temperature 4.40 °C	@Temperature 39.9 °F	
	480 min	8.00 hour	
	@Temperature 4.40 °C	@Temperature 39.9 °F	
	720 min	12.0 hour	Tack-Free Time
	@Temperature -6.70 °C	@Temperature 19.9 °F	
	840 min	14.0 hour	
	@Temperature -6.70 °C	@Temperature 19.9 °F	
Shelf Life	6.00 Month	6.00 Month	
	@Temperature <=26.7 °C	@Temperature <=80.1 °F	

Descriptive Properties	Value	Comments
Alkalinity	13	
Appearance	Dark Brown	Accelerator
	Gray	
	White	Base

## Contact Songhan Plastic Technology Co.,Ltd.

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