

3M™ Aerospace Sealants Product Comparison

Class B Polysulfide Sealant Tack Free and Cure Times*

Specification	3M Product	Specific Gravity	Tack Free	Cure	Tack Free	Cure	Tack Free	Cure	Tack Free	Cure	Tack Free	Cure	Tack Free	Cure
			Class B-1/4		Class B-1/2		Class B-1		Class B-2		Class B-4		Class B-6	
AMS-S-8802 Fuel Tank and Fuselage	AC-350	1.4			2 - 3 hours	2 - 3 hours			7 - 8 hours	7 - 8 hours	32 - 36 hours	32 - 36 hours		
AMS3276 High Temp Fuel Tank and Fuselage	AC-350	1.4	1 - 2 hours	1 - 2 hours	2 - 3 hours	2 - 3 hours			7 - 8 hours	7 - 8 hours	32 - 36 hours	32 - 36 hours	48 hours	48 hours
AMS3281 Light Weight Fuel Tank and Fuselage	AC-370 (Type 1)	1.3			6 - 7 hours	6 - 7 hours			7 - 8 hours	8 - 10 hours				
	AC-380 (Type 2)	1.1			5 hours	5 hours			8 - 10 hours	8 - 10 hours				
AMS3265 Non-Chromated Corrosion Inhibitive	AC-730	1.5			4 hours	6 hours			16 hours	24 hours				
MIL-PRF-81733 Non-Chromated Corrosion Inhibitive	AC-735	1.1			5 hours	5 hours			10 - 12 hours	10 - 12 hours				
3M Standard Window & Canopy	AC-251 Black	1.6			4 hours	4 hours	5 hours	7 hours	8 hours	9 hours				

*Measured at Standard Conditions (77°F / 25°C and 50% Relative humidity). These products were manufactured under a 3M Quality Management System registered to the AS9100 standard.

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