

TECHNICAL DATA

CA 1010 Mastinox Chromate Free Jointing Compound

Description

CA 1010 is a non-curing, non-chromate corrosion inhibitive compound. It has a service temperature range from -65°F (-54°C) to 320°F (160°C). This material acts as an effective barrier against the common causes of corrosion on aluminum alloys or between dissimilar metals. The compound remains permanently mastic after prolonged exposure to aircraft fuels, both jet fuel and aviation gas.

CA 1010 is a one-part, polyester compound. The material is a thixotropic paste suitable for application by brush or spatula.

The following tests are in accordance with ECS 7009

Application Properties (Typical)

Color Off white

Appearance

Uniform composition, no lumps or separated material

Viscosity

(Brookfield #7 @ 50 rpm),

Poise (Pa-s) 660 (66)

Performance Properties (Typical)

Specific gravity 1.37

Nonvolatile content, % 92

Pigment contents, % 43

Fineness of grind, Hegman >5

Flash point °F (°C),
[Closed cup(SETA)] 75°F (24°C)

Solubility in water @ 73°F (23°C) 2%

Exposure to heat @ 104°F (40°C),
95% R.H. for 1000 hours
Aluminum/Stainless steel - Easy removal,
no corrosion
Graphite/Aluminum - Easy removal, no corrosion

Exposure to dry heat @ 250°F (120°C) for 1000 hours
Easy removal, compound still tacky

Chemical resistance

No swelling, loss of adhesion or film failure after 7 days at 140°F (60°C) in:

AMS2629 TY I

AMS3020MIL-

PRF-83282

Corrosion test by galvanic cell method

Aluminum/Titanium couple, 2 weeks - No signs of corrosion or sealant deterioration.

Aluminum/Stainless steel couple, 2 weeks - No signs of corrosion or sealant deterioration.

Note: The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.

Surface Preparation

Immediately before applying sealant to primed substrates, the surfaces should be cleaned with solvents. Contaminants such as dirt, grease, and/or processing lubricants must be removed prior to sealant application.

A progressive cleaning procedure should be employed using appropriate solvents and a new lint-free cloth conforming to AMS 3819. (Reclaimed solvents or tissue paper should not be used.) Always pour solvent on the cloth to avoid contaminating the solvent supply. Wash one small area at a time.

It is important that the surface is dried with a second clean cloth prior to the solvent evaporating to prevent the redeposition of contaminants on the substrate.

Substrate composition can vary greatly. This can affect sealant adhesion. It is recommended that adhesion characteristics to a specific substrate be determined prior to application on production parts or assemblies.

For a more thorough discussion of proper surface preparation, please consult the SAE Aerospace Information Report AIR 4069. This document is available through SAE, 400 Commonwealth Avenue, Warrendale, PA 15096-0001.

Packing Options

CA 1010 is supplied in 1 part 6 oz. Semco® cartridges.

Mixing Instructions

CA 1010 is supplied in a 1 part 6 oz. Semco® cartridge. Mixing is not required.

Storage Life

The storage life of CA 1010 is at least 12 months when stored at temperatures below 80°F (27°C) in original, unopened containers.

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Health Precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Material Safety Data Sheet (MSDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An MSDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

For industrial use only. Keep away from children.

Additional information can be found at: www.ppgaerospace.com

For sales and ordering information call 1-800-AEROMIX (237-6649).

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