

# CS 3247 Class B

## AIRCRAFT WINDSHIELD SEALANT

### Technical Data Sheet

#### Description

CS 3247 Class B was designed for use in setting or repairing aircraft windshields and canopies made of glass, acrylic or polycarbonate. An adhesion promoter is recommended for use with acrylics and polycarbonates.

- Two-part, manganese dioxide cured polysulfide
- Room temperature cure
- Excellent adhesion to aluminum, steel, and a variety of other aircraft substrates
- Resistant to crazing on acrylic and polycarbonate, both at room temperature and at 160°F (71°C)
- Excellent UV resistance
- Cured material has a service temperature range of -65°F to 250°F (-54°C to 121°C).
- Uncured CS 3247 Class B is a thixotropic (low sag) material easily applied with an extrusion gun or spatula.
- CS 3247 B-1/2 and B-2 meet the acceptance tests of AMS3333 as a Type II (high peel strength version). This specification does not have an active QPL.

The following technical information and data are typical for the material but should not be used for specification or acceptance purposes. Testing was performed in accordance with AMS3333.

#### Typical Performance Properties

Cured 14 days at 77°F (25°C) and 50% relative humidity

|                                              |                                  |
|----------------------------------------------|----------------------------------|
| Specific gravity                             | 1.6                              |
| Ultimate hardness                            | 45A - 50A                        |
| % Nonvolatile material                       | 96%, min                         |
| Low temperature flexibility at -65°F (-54°C) | No defects, cracking or checking |
| Thermal rupture testing, 10 psi at 250       | Pass                             |
| Stress crazing on polycarbonate              | Pass                             |
| Stress crazing on acrylic                    | Pass                             |

#### Peel strength

|                                                                          |                      |
|--------------------------------------------------------------------------|----------------------|
| First value is pli; second value is N/25 mm<br>All 100% cohesive failure |                      |
| Dry (after 7-day cure at standard conditions)                            |                      |
| Aluminum (AlClad, AMS4049)                                               | 35 pli; 153 N/25 mm) |
| Stainless steel (AMS 5516)                                               | 30 pli; 131 N/25 mm) |
| Titanium (AMS 4911)                                                      | 30 pli; 131 N/25 mm) |
| Polycarbonate                                                            | 37 pli; 162 N/25 mm) |
| Acrylic                                                                  | 35 pli; 153 N/25 mm) |
| Glass                                                                    | 35 pli; 153 N/25 mm) |

#### Typical Application Properties

At 77°F (25°C) and 50% relative humidity

|                                       |                            |
|---------------------------------------|----------------------------|
| Color                                 |                            |
| Base                                  | Black                      |
| Curing agent                          | Black                      |
| Mixed                                 | Black                      |
| Mix ratio                             |                            |
| By weight                             | 100:10 (base/curing agent) |
| Base viscosity (Brookfield #7@ 2 rpm) | 11,000 Poise (1100 Pa·s)   |
| Slump                                 | < 0.2" (5 mm)              |

|       | Minimum application time | Extrusion rate at application time (g/min) | Tack-free time (hours) | Cure time to 30A (hours) |
|-------|--------------------------|--------------------------------------------|------------------------|--------------------------|
| B-1/2 | 30 minutes               | 40 - 80                                    | < 10                   | < 30                     |
| B-2   | 2 hours                  | 20 - 40                                    | < 24                   | < 48                     |

#### Surface Preparation

To obtain good adhesion, surfaces must be free of all traces of oil, wax, grease, dirt or other contaminants. A progressive cleaning process is recommended. Use an appropriate solvent and lint-free clothes. Pour solvent on the cloth to keep the solvent supply clean. Clean a small area at a time and wipe the surface dry with a second clean cloth. See SAE AIR 4069 for additional information on surface preparation. For Socomore's full line of solvents and wipes used for aerospace sealant preparation, and their customer approvals, visit [www.Socomore.com](http://www.Socomore.com).

#### Storage

Unmixed CS 3247 Class B has a shelf life of at least 9 months from date of packaging when stored below 80°F or below in the original, unopened package. Refrigerated shipping is not required, but storage above this temperature typically affects application properties before performance properties.

#### Mixing Instructions

CS 3247 base and curing agents are matched and tested together; do not mix lots. Mix according to the indicated mix ratios; using the incorrect ratio can affect the sealant properties and voids the warranty. Do not thin the material with solvents. For additional information, see the FAQ on the Flamemaster website ([www.flamemaster.com](http://www.flamemaster.com)).

## Curing

The application, tack-free, and cure times are based on the standard conditions of 77°F (25°C) and 50% relative humidity. For information on the effects of temperature and humidity, as well as information on accelerated curing, see the FAQ on the Flamemaster website ([www.flamemaster.com](http://www.flamemaster.com)).

## Clean up

Cured aerospace sealants are difficult to remove. Cleaning tools and other surfaces is best done when the material has not yet cured. For fresh material and tool cleaning use an appropriate solvent and lint-free cloth. Once the material has cured, use an approved chemical and/or plastic scraper to remove the sealant. For Socomore's full line of solvents, wipes, chemical sealant removers (SkyRestore), plastic scrapers (SkyScraper), and their customer approvals, visit [www.Socomore.com](http://www.Socomore.com).

## Packaging

CS 3247 Class B is available in injection kits and can kits. Bulk packaging and premix frozen (PMF) may be available; contact Sales.

## Health and Safety

Before using this material, read and understand the Safety Data Sheet (SDS) as it includes information on health, physical, and environmental hazards, as well as handling precautions and first aid recommendations. SDSs are available upon request.

**Emergency Contact Chemtrec 800-424-9300**  
**Outside North America 703-527-3887**  
**Keep out of the reach of children**  
**For industrial use only**

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**This technical data sheet replaces and cancels the previous one.**

The above details have been compiled to the best of our knowledge. They have, however, an indicative value only and we therefore make no warranties and assume no liability in connection with any use of this information, particularly if a third party's rights are affected by the use of our products. The above information has been compiled based upon tests carried out by SOCOMORE. All data is subject to change as SOCOMORE deems appropriate. The data given is not intended to substitute for any testing you must conduct in order to determine the suitability of the product for your particular purposes. Pictures are not contractual. Please check your local legislation applicable to the use of this product. Should you need any further information please contact us.