



APPLICATION BULLETIN

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Typical viscosity ranges of fuel tank sealants

Class/ Grade	Viscosity	Use
Class A (Brush)	100 - 400 Poise i.e. Chocolate syrup	Brush apply to fastener heads Use as prime coat for fillet seal
Class B (Fillet)	6,000 - 16,000 Poise i.e. Peanut butter	Low sag required Fillet, vertical seals, etc.
Class C (Rollable)	1,000 - Poise i.e. Mayonnaise	Faying surface sealing

Application of sealant

Brushable Sealant Application:

Class A brushable sealants are applied as brushcoat seals on fasteners, and in locations where a flowable material is needed. The first coat is worked in and around all leak sources areas with a short and stiff brush. The second brush coat is applied after the first coat is tack-free.

Brushable sealant is used around crevices, holes, seams, fasteners, and in some cases as a precoat on seams and surfaces to be covered later with the thicker Class B extruded fillet of Sealant.

Extrudable Sealant Application:

Class B fuel tank sealants are known for their low slump (thixotropic) characteristics. The Class B material, which typically contains fewer volatile solvents, is used in providing the required sealant dimensions (or thickness) without entrapment of air or solvents.

Dispensing the sealant from the nozzle in aerospace work is done in a different manner than caulking in the architectural industry. When the architect's method is used -- air can be trapped under the sealant bead as it is applied to the structure.

The preferred technique is to hold the gun approximately 30° off-perpendicular, and point the nozzle in the direction of travel which will push the extruded sealant into the joint or seam. This forces sealant into the crevice and minimizes the possibility air entrapment. Do not apply sealant with the tip pointing opposite to the direction of travel.

This information is provided as a guide, not as a recommendation. Follow aircraft manufacturer's recommendations.

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