

## TECHNICAL INFORMATION

### WS-8010 Class B Access Door Sealant

#### PRODUCT DESCRIPTION

WS-8010 Class B is an Access door sealant designed to have very low adhesion characteristics and an excellent cure profile. The product can be exposed to a temperature range of -65°F (-54°C) to 250°F (121°C) without adverse effect. WS-8010 Class B uses manganese dioxide as a curing agent formulated to have an outstanding cure profile. The uncured material is a thixotropic low sag paste designed to be applied by extrusion gun or spatula. The product cures at room temperature to form a gasket with very low adhesion characteristics.

#### SPECIFICATIONS:

- ◆ AMS-3284 Type I Qualified
- ◆ MIL-S-8784 Meets Requirements

#### APPLICATION PROPERTIES

Typical @77°F (25°C) 50% RH  
 Slump, inches (mm) <0.2 (5.08) B-1/2, B-2  
 Base Viscosity Poise (pa-s), 8,000-10,000 (800-1,000)  
 Brookfield #7 spindle @ 2 rpm

#### Color

Part A Black  
 Part B Red  
 Mixed Red

#### Mix Ratio

by weight 100 parts base (Part B) to 10 parts  
 accelerator (Part A)  
 by volume 100 parts base (Part B) to 8.3 parts  
 accelerator (Part A)

#### Cure Profile:

	B-1/2	B-2
Application Life (hrs)	½	2
Tack free time (hrs)	<3	<6
Cure time to 35 A Durometer (hrs)	<4	<12

#### PERFORMANCE PROPERTIES

Typical 14 days @ 77°F (25°C), 50% RH  
 (tested per AMS-3284)

Color Red  
 Specific Gravity 1.45  
 Final hardness 55 Shore A

Nonvolatile content 98%  
 Low temperature flexibility @ -65°F (-54°C) No cracking or adhesion loss

Resistance to AMS2629 JRF hydrocarbons @ 7days 140°F (60°C) exposure:

Weight loss <6%  
 Swell 6.5%

Excellent resistance to other fluids such as: water, alcohols, synthetic oils and petroleum based hydraulic fluids.  
 Fungus resistance Non-nutrient

#### Peel Strength

Pli, 100% adhesion failure  
 AMS2629 JRF 7 day immersion @ 140°F (60°C)/ AMS2629  
 JRF/3% saltwater @ 140°F (60°C):

Substrate	Conditioning	Adhesion
QQ-A-250/12(Aluminum)	JRF	<1
QQ-A-250/13 (Alclad)	JRF	<1
Mil-C-27725 ( Fuel Tank Ctg)	JRF	<1
BMS 10-20 (Epoxy Primer)	JRF	<1
BMS 10-11 (Epoxy Primer)	JRF	<1
AMS 5516 (Stainless Steel)	JRF	<1
AMS4901 (Titanium)	JRF	<1
AMS 2471 (Anodized Alum)	JRF	<1
Substrate	Conditioning	Adhesion
QQ-A-250/12(Aluminum)	JRF/SW	<1
QQ-A-250/13 (Alclad)	JRF/SW	<1
Mil-C-27725 ( Fuel Tank Ctg)	JRF/SW	<1
BMS 10-20 (Epoxy Primer)	JRF/SW	<1
BMS 10-11 (Epoxy Primer)	JRF/SW	<1
AMS 5516 (Stainless Steel)	JRF/SW	<1
AMS4901 (Titanium)	JRF/SW	<1
AMS 2471 (Anodized Alum)	JRF/SW	<1
Substrate	Conditioning	Adhesion
QQ-A-250/12(Aluminum)	DRY	<1
QQ-A-250/13 (Alclad)	DRY	<1
Mil-C-27725 ( Fuel Tank Ctg)	DRY	<1
BMS 10-20 (Epoxy Primer)	DRY	<1
BMS 10-11 (Epoxy Primer)	DRY	<1
AMS 5516 (Stainless Steel)	DRY	<1
AMS4901 (Titanium)	DRY	<1
AMS 2471 (Anodized Alum)	DRY	<1

Note: All values are typical and are not intended for specification use or for acceptance inspection criteria.

## **SURFACE PREPARATION**

Surfaces must be cleaned with solvent. Contaminants must be removed prior to sealant application.

## **PACKAGING**

WS-8010 Class B is supplied in two part kit containers and cartridges for the purpose of facilitating mixing and application.

## **MIXING INSTRUCTIONS**

Mix the two part kits and two part sealant cartridges as indicated on the container label. Do not forget to mix Part A and Part B of the two part kits to uniformity before blending them. Avoid leaving unmixed material around the side and bottom of the mixing container.

## **STORAGE LIFE**

The shelf life of WS-8010 Class B is 9 months from the date of shipment when stored below 80°F (27°C) in the original unopened container

## **HEALTH PRECAUTIONS**

This product is considered to be safe when handled with proper care. Read the MSDS (Material Safety Data Sheet) for information on handling precautions, hazardous ingredients and first aid procedures. After use of his product, always wash your hands before eating or smoking. If you need an MSDS, this is always available on request. In case of overexposure, be sure to obtain medical care.

Keep away from children. This product is intended for industrial use only.

## **ADDITIONAL INFORMATION**

Visit our web site at:

[www.royaladhesives.com](http://www.royaladhesives.com)

Contact us at:

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## **NOTE**

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