

# GENERAL SEALANTS, INC.

## GS# 416ET Sealant

### Technical Data Sheet

#### PRODUCT DESCRIPTION

GS# 416ET Sealant is specially formulated from a blend of advanced synthetic rubbers. This unique formula was specifically designed for the aerospace market to be used for crucial low temperature composite curing. The sealant has a low room temperature surface tack which allows for reposition of the vacuum bag film if needed after film has contacted the sealant tape. The product still provides great adhesion to a variety of films and tooling surfaces, as well as excellent release/clean up from tooling post-cure. For best results, pull sealant from tooling surface at room temperature.

#### PRODUCT ADVANTAGES

- Can be used for multiple debulking cycles
- Lower initial tack enables the user to adjust the film after it has contacted the sealant.
- Strips clean from tooling surface at room temperature
- Non-Hazardous
- Fast and easy to apply by hand
- Room Temperature to 275°F (135°C) cure cycles

#### APPLICATION

Surface should be clean and dry for maximum bond. Apply the sealant by hand to the tooling surface pressing the sealant firmly into place. When ready to apply the film, remove the release liner from the sealant and apply the film to the sealant. It is recommended to use a roller to run the entire area of the sealant applying firm pressure to achieve the best seal.

Product is not considered hazardous to skin however wash hands before eating. DO NOT TAKE INTERNALLY



#### TYPICAL PHYSICAL PROPERTIES

<b>Chemical Base</b>	Synthetic Rubber
<b>Color</b>	Red
<b>Specific Gravity (ASTM D 792)</b>	1.44
<b>Total Solids</b>	100%
<b>Penetration (ASTM D 217) cone at 72°F / 150 grams</b>	45-55 (4.5 to 5.5 mm)
<b>Rolling Ball Tack (ASTM D 3121)</b>	< 5 cm (11/16" Ball)
<b>Elongation (ASTM D 1000)</b>	> 1000%
<b>Weight Loss (ASTM C 771)</b>	< 3.0%
<b>Odor (ASTM D 1833)</b>	None
<b>Adhesion</b>	Good
<b>Water Resistance</b>	Excellent
<b>Corrosion Resistance</b>	Excellent
<b>Service Temperature</b>	Room Temperature to 275°F (135°C)
<b>Shelf Life (Storage At 72°F/22°C)</b>	12 Months from DOM

NOTE: TECHNICAL INFORMATION AND DATA SHOULD BE CONSIDERED REPRESENTATIVE OR TYPICAL ONLY AND SHOULD NOT BE USED FOR SPECIFICATION PURPOSES.

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#### Packaging

GS# 416ET Sealant is available in a wide range of extruded sizes supplied in roll form on a release liner. The standard sizes are 1/8" x 1/2" x 25' (40 Rolls/Case) and 1/8" x 3/4" x 25' (28 Rolls/Case) but other custom sizes are available upon request.

#### Storage and Handling

Material should be stored at 72°F (22°C) in a dry area in its original sealed case and case must remain right side up.

For more information on GS# 416ET Sealant, please email [Sales@GeneralSealants.com](mailto:Sales@GeneralSealants.com) or call (800)-762-1144 to speak with our Sales Department.

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