

PRC Rapid Seal[®] 725

Description

PRC RAPID SEAL[®] 725 is a fast-curing, chrome-free sealant designed for application on transparencies and windshields of transportation vehicles. It has a service temperature range from -65°F (-54°C) to 250°F (121°C), with intermittent excursions up to 275°F (135°C). This material has excellent adhesion to properly prepared glass, polycarbonate, and acrylic substrates. This product is specifically formulated to so that it does not cause crazing on these substrates. The cured sealant exhibits excellent resistance to UV and weather exposure.

PRC Rapid Seal 725 is a two-part manganese dioxide-cured polysulfide compound. The uncured material is a low-sag, thixotropic paste, suitable for application by extrusion gun or spatula. This sealant has excellent adhesion to common windshield substrates when correctly primed with PR-1861 adhesion promoter.

The following tests are in accordance with PRC DeSoto International specification test methods.

Application properties (typical)

Tested at 77°F (25°C), 50% RH

Color			
Part A			Black
Part B			Black
Mixed			Black
Mixing ratio			
By weight			Part A:Part B 15:100
Base viscosity			
(Brookfield #7 @ 2 rpm),			
Poise (Pa-s)			15,300 (1,530)
Slump, inches (mm)			
Initial	50 minutes	90 minutes	
0.22 (5.59)	0.26 (6.60)	0.26 (6.60)	
Application life, minimum			
			2 hours
Tack-free time, maximum			
			8 hours
Cure time to 35 durometer A			
			12 hours
Non-volatile content			
			98%

Performance properties (typical)

Cured 7 days at 77°F (25°C), 50% RH

Specific gravity	1.45
Final cure hardness	49 durometer A

Peel strength, pli (N/25 mm), 100% cohesion*
Dry, 14-days at 77°F (25°C), 50% RH

Glass	50 (219)
Acrylic	63 (276)
Polycarbonate	61 (267)
Aluminum	58 (254)
Polyurethane topcoat	53 (232)

*primed with PR-1861 adhesion promoter

Low-temperature flexibility @ -65°F (-54°C)
No cracking, checking or loss of adhesion

Flexibility
No cracks after being bent 180° over a 0.125 inch.
(3.18 mm) diameter mandrel.

Repairability to itself
Excellent to both freshly cured as well as fuel-aged
and abraded fillets

Rain erosion resistance
Excellent rain erosion resistance and buffing ability

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 or to prime substrates, the surfaces should be cleaned well with solvents to remove dirt and grime. 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. (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.

After the surface has been cleaned, apply PR-1861 Adhesion Promoter with a clean brush or a lint-free gauze pad. Care

PRC Rapid Seal® 725

must be taken to obtain a uniform thin coat. At standard temperature, allow the adhesion promoter to dry for 30 minutes. It is not recommended to apply adhesion promoter below 45°F (7°C). The sealant must be applied within 8 hours of the application of the adhesion promoter. If this time is exceeded, the surface should be recleaned and the adhesion promoter reapplied. Do not use adhesion promoter if it contains particles or precipitate.

Packaging options

PRC Rapid Seal 725 is supplied in two-part 1-gallon can kits and in SEMKIT® packages.

Mixing instructions

Mix according to the ratios indicated in the application properties section. When mixing can kits, stir Part A and Part B separately prior to combination to ensure uniformity. Then, thoroughly mix the entire contents of both parts of the kit together while taking care to avoid leaving unmixed material around the sides or bottom of the mixing containers. Material in *Semkit* packages should be mixed according to the packaging directions.

Storage life

The storage life of *Rapid Seal 725* in two-part kits is at least 9 months when stored at temperatures between 40°F (4°C) and 80°F (27°C) in original, unopened containers.

Health precautions

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

For industrial use only. Keep away from children.

For emergency medical information call 1-800-228-5635.

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

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

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PRC-DeSoto International, Inc.
12780 San Fernando Road
Sylmar, CA 91342
Telephone (818) 362-6711
Toll Free (800) AEROMIX
www.ppgaerospace.com

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