

3M™ Aerospace Sealants - Industry Specification Reference Chart



Industry Specification	3M Aerospace Sealant		Class	Application Time	Tack Free Time* (Hours)	Cure Time* (Hours)	Specific Gravity	Suggested Adhesion Promoter	Technical Data Sheets	Other Industry Sealants for Reference
Fuel Tank Sealants										
AMS-S-8802 (Type 2) AMS 3276	AC-350	Fast-curing polysulfide sealant designed primarily for fuel tank sealing and fuselage applications.	A-1	1 hour	5	8	1.4	AC-137 Red AC-160	TDS	PR-1422® PR-1440® P/S 890® PR-1750® CS 3204 CS 5500 WS-8020 RC MC-780
			A-2	2 hours	8	12	1.4		TDS	
			B-1/4	15 minutes	2-3	<3	1.4		TDS	
			B-1/2	30 minutes	3-4	<4	1.4		TDS	
			B-2	2 hours	7-8	<8	1.4		TDS	
			B-4	4 hours	28-32	<32	1.4		TDS	
AMS 3281 (Type 2)	AC-380	Fast-curing polysulfide sealant used mainly for fuel tank sealing and fuselage sealing with excellent tooling properties.	B-1/2	30 minutes	5	5	1.1	AC-137 Red AC-160	TDS	PR-2007® PR-1776® CS-5530 WS-8030 WS-8032 MC-780
			B-2	2 hours	8-10	8-10	1.1		TDS	
Fuselage Sealants										
AMS 3265	AC-730	Fast-curing, non-chromate corrosion-inhibiting polysulfide sealant; used for fuselage structural and faying surface sealing.	B-1/2	30 minutes	4	<6	1.5	AC-137 Red AC-160	TDS	PR-1775® CS-143 WS-8072
			B-2	2 hours	16	<24	1.5		TDS	
			C-8	8 hours	<72	120	1.5		TDS	
MIL-PRF-81733 (Type 1, Class 1, Grade B)	AC-735	Low-density, fast-curing, non-chromate corrosion-inhibiting polysulfide sealant; used for fuselage structural and fillet sealing.	B-1/2	30 minutes	5	7	1.1	AC-137 Red AC-160	TDS	P/S 870® PR-1775® CS-3213 WS-8070 WS-8072
			B-2	2 hours	10	12	1.1		TDS	
3M Finished Product Standard (FPS)	AC-770	Low-density, fast-curing polysulfide sealant for general fuselage and cabin sealing; great tooling properties and reduced shrinkage.	B-2	2 hours	7-8	9-11	1.1	AC-137 Red AC-160	TDS	PR-1772®
Canopy & Windshield Sealant										
3M Finished Product Standard (FPS)	AC-251	Fast-curing polysulfide sealant used for canopy and windshield sealing, offering excellent UV and weather resistance.	B-1/2	30 minutes	4	4	1.6	AC-137 Clear AC-137 Red	TDS	PR-1425® PR-1425 CF PR-1829®
			B-1	1 hour	6	7	1.6		TDS	
			B-2	2 hours	8	8	1.6		TDS	

*Cured at standard conditions (77°F / 25°C and 50% relative humidity). These products were manufactured under a 3M Quality Management System registered to the AS9100 standard.

Wondering which 3M aerospace sealant is qualified to an OEM Specification? Visit our [3M Specification Portal](#) to learn more.



IMPORTANT: This overview is summary in nature. Always refer to the 3M technical data sheets for detailed product information.

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