

## DAPCO™ 2200

Dapco™ 2200 is an adhesive, two-component, solvent-free, thixotropic silicone paste. Dapco™ 2200 is most commonly used as a coating, sealant, or filleting material in the construction, repair and maintenance of all types of aircraft. The product can be applied using a variety of methods and is especially useful where fire resistance, exposure to phosphate ester fluids, and/or exposure to extreme temperatures -65°F (-54°C) to 400°F (204°C) are major considerations. The product can also be used as an insulative and/or ablative heat shield. The product is available in kit sizes of 2.5 oz and 6 oz injection kits.

### Features and Benefits

- Quick Cure
- Excellent fire resistance to 2000°F (1093°C)
- Service temperature of -65°F (-54°C) up to 400°F (204°C)
- Universal primerless adhesion to diverse substrates
- Good resistance to aerospace chemicals
- Offers non-inhibition curing characteristics against other sealants and adhesives
- Non-Volatile Content of >96%
- Qualified to BMS 5-63, BAMS 552-004, and AMS3374

## CHARACTERISTICS

Table 1 | Physical Properties

Property	Part A	Part B	Mixed
Solids, %	100	100	100
Consistency	Paste	Viscous Liquid	Thixotropic Paste
Density, lb/gal (kg/L)	11.6 (1.39)	7.8 (0.94)	11.4 (1.37)
Shore Hardness ASTM D 2240	Shore A: 50		
Shelf Life <sup>1</sup>	6 months stored at or below 75°F (24°C)		

<sup>1</sup> Keep in unopened foil bags.



**Table 2 | Product Availability**

Property		
Color	Part A	Gray
	Part B	White
	Mixed	Gray
Kit Size	2.5 oz	
	6.0 oz	

**Table 3 | Flammability Properties of Dapco™ 2200**

Property	DAPCO 2200	Substrate
Flame Resistance BMS 5-63	Self-extinguishing Time: < 2 sec	0.050 in (1.27 mm)
	Flame Penetration: None	Titanium, TI-6AL-4V

## PROPERTIES

When cured in accordance with the recommended schedule, the following typical properties are developed:

**Table 4 | Mechanical Properties of Dapco™ 2200**

Property	DAPCO 2200	Substrate	
Lap Shear Strength ASTM D 1002	<b>psi (MPa)</b>	0.050 in (1.27 mm) Included: Stainless Steel, Titanium, Aluminum (bare), and Aluminum (bare) primed	
	Control		330 (2.3)
	7 days at 400°F (204°C)		330 (2.3)
	7 days at 120°F (49°C) & 100% RH		330 (2.3)
	7 days in Skydrol® LD4 Hydraulic Fluid		260 (1.8)
Floating Roller Peel ASTM D 3167	<b>lb/in(kN/m)</b>	0.025 in (0.63 mm) and 0.064 in (1.63 mm) Aluminum	
	20 (3.5)		

## PROCESSING

### HANDLING

#### Mixing

Part A and B must be mixed in the correct ratio and mixed thoroughly. Product is supplied in injection kits and comes with mixing instructions. Mechanical mixing is recommended.

Parts	Weight
Part A	100
Part B	4.4

**Tack Free Time** 60 minutes

**Work life** Product will extrude from the tube adequately for 30 minutes after mixing.



## APPLICATION

### Applying

The substrate must be free from contamination, i.e. dirt, oil grease, etc. Clean the surface by wiping with a suitable solvent/cleaning agent and dry thoroughly. Handling strength is achieved in less than 4 hours at 75°F (24°C) (loads on the product should be limited until full cure is achieved).

### Curing

Dapco™ 2200 is generally cured at ambient temperatures above 55°F (13°C). Moisture helps develop final properties (a relative humidity ranging between 30% - 70% is preferred). Product reaches a hardness of 30 shore A in 4 hours at 75°F (24°C) and 50% R.H., allowing for quick repairs and fast "fly away" times. Full cure is achieved in 48 hours, however optimum physical properties are developed when the product is cured for a minimum of seven days for sealing applications and 14 days for faying surface applications at 75°F (24°C) and 50% R.H.

Cure may be inhibited by proximity or contact with a variety of materials including old RTV silicone sealant of the tin-cure variety, polysulfide, sulfur, amine and amide compounds, natural, nitrile or other organic rubbers, paper masking tape, plasticizers, lubricants, release agents or solvents.

### Cleanup

Before the material has cured, the excess may be removed using commercial solvent. For optimum removal of silicone residue prior to paint or coating application, Dapco™ 2000 diluent is recommended.

## HEALTH & SAFETY

Please refer to the product SDS for safe handling, personal protective equipment recommendations and disposal considerations.

