

SEALING COMPOUND, LOW ADHESION, CORROSION INHIBITING  
200 - 600 Poises (20 - 60 Pa·s), 1/2 Hour Application Time (A-1/2)

1. SCOPE:

- 1.1 Form: This specification covers accelerated curing synthetic rubber compounds with corrosion inhibitors and low adhesive strength supplied as a two-component system.
- 1.2 Application: Primarily for sealing aircraft access doors and accessories where gaskets are required. Material specified herein is classified as an A-1/2 sealing compound; the compound being suitable for brush application with a minimum application time after mixing of 1/2 hour.

2. APPLICABLE DOCUMENTS: See AMS 3267.

3. TECHNICAL REQUIREMENTS:

- 3.1 Basic Specification: The complete requirements for procuring the sealing compound described herein shall consist of this document and the latest issue of the basic specification, AMS 3267.

SAE Technical Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

AMS documents are protected under United States and international copyright laws. Reproduction of these documents by any means is strictly prohibited without the written consent of the publisher.

# AMS 3267/1

3.2 **Properties:** Compound, mixed in accordance with manufacturer's instructions and cured as specified in the basic specification, shall conform to the following requirements, determined in accordance with test methods listed in AMS 3267 and herein:

## 3.2.1 Color

3.2.1.1 Base Compound

Reddish

3.2.1.2 After curing

Reddish

3.2.2 Specific Gravity

1.65 max

3.2.3 Nonvolatile Content

84% by weight, min

3.2.4 Viscosity of Base Compound (See 4.2)

200 - 600 poises (20 - 60 Pa·s)

3.2.5 Flow

No requirement

3.2.6 Application Time (See 4.3)

1/2 hr after the beginning of mixing, the viscosity shall be 2500 poises (250 Pa·s) max

3.2.7 Tack-Free Time

10 hr max, measured from the beginning of mixing

3.2.8 Hardness (cure time to attain 30 Durometer "A" min)

24 hr

3.2.9 Peel Adhesion

4 lb per in. (700 N/m) width, max 98% adhesive failure, min

3.2.10 Resistance to Heat

No visual evidence of softening, sponging, blistering, checking, cracking, shrinkage, or powdering

3.2.11 Resistance to Salt Water and Hydrocarbons

No visual evidence of softening blistering, or evidence of corrosion

3.2.12 Weight Loss and Flexibility

8%, max, weight loss  
No cracking when bent

3.2.13 Low Temperature Flexibility

No visual evidence of cracking or checking

3.2.14 Accelerated Storage Stability

3.2.14.1 Application time

1/2 hr min, measured from the beginning of mixing