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INTERNATIONAL
400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE MATERIAL SPECIFICATION

SAE AMS 3336D

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Superseding AMS 3336C

Silicone (PVMQ) Rubber
Extreme-Low-Temperature Resistant
55 - 65

1. SCOPE:

1.1 Form:

This specification covers a silicone (PVMQ) rubber in the form of sheet, strip, tubing, extrusions, and molded shapes.

1.2 Application:

These products have been used typically for parts required to operate or seal from -85 to +230 °C (-121 to +446 °F), compounded especially for operation at extreme low temperatures, but usage is not limited to such applications.

1.2.1 Silicone rubber is resistant to deterioration by weathering and by high-aniline-point petroleum-base oils and remains flexible over the temperature range noted.

1.2.2 These products are not normally suitable for use in contact with low-aniline-point petroleum-base fluids, including fuels, due to excessive swelling.

1.3 Safety - Hazardous Materials:

While the materials, methods, applications, and processes described or referenced in this specification may involve the use of hazardous materials, this specification does not address the hazards which may be involved in such use. It is the sole responsibility of the user to ensure familiarity with the safe and proper use of any hazardous materials and to take necessary precautionary measures to ensure the health and safety of all personnel involved.

2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other documents shall be the issue in effect on the date of the purchase order.

QUESTIONS REGARDING THIS DOCUMENT: (724) 772-7161 FAX: (724) 776-0243
TO PLACE A DOCUMENT ORDER: (724) 776-4970 FAX: (724) 776-0790
SAE WEB ADDRESS: http://www.sae.org

2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 2279 Tolerances, Rubber Products
MAM 2279 Tolerances, Metric, Rubber Products
AMS 2810 Identification and Packaging, Elastomeric Products

2.2 ASTM Publications:

Available from ASTM, 1916 Race Street, Philadelphia, PA 19103-1187.

ASTM D 297 Rubber Products - Chemical Analysis
ASTM D 395 Rubber Property - Compression Set
ASTM D 412 Rubber Properties in Tension
ASTM D 471 Rubber Property - Effect of Liquids
ASTM D 518 Rubber Deterioration - Surface Cracking
ASTM D 573 Rubber - Deterioration in an Air Oven
ASTM D 624 Rubber Property - Tear Resistance
ASTM D 797 Rubber Property - Young's Modulus at Normal and Subnormal Temperatures
ASTM D 1149 Rubber Deterioration - Surface Ozone Cracking in a Chamber (Flat Specimens)
ASTM D 2137 Rubber Property - Brittleness Point of Flexible Polymers and Coated Fabrics
ASTM D 2240 Rubber Property - Durometer Hardness

3. TECHNICAL REQUIREMENTS:

3.1 Material:

Shall be a compound, based on a silicone (PVMQ) rubber, suitably cured to produce a product meeting the requirements of 3.2.

3.2 Properties:

The product shall conform to requirements shown in Table 1; tests shall be performed on the product supplied and in accordance with specified ASTM methods, insofar as practicable.

TABLE 1 - Properties

Paragraph	Property	Requirement	Test Method
3.2.1	Hardness, Durometer "A" or equivalent	60 ± 5	ASTM D 2240
3.2.2	Tensile Strength, min	600 psi (4.14 MPa)	ASTM D 412, Die B or C
3.2.3	Elongation, min	150%	ASTM D 412, Die B or C
3.2.4	Tear Resistance, min	40 pounds force per inch (7.0 kN/m)	ASTM D 624, Die B
3.2.5	Specific Gravity	Preproduction Value ± 0.03	ASTM D 297
3.2.6	Petroleum Lubricating Oil Resistance: (Immediate Deteriorated Properties)		ASTM D 471 ASTM Oil No. 1 175°C ± 3
3.2.6.1	Hardness Change, Durometer "A" or equivalent	-15 to +5	(347 °F ± 5) 70 hours ± 0.5
3.2.6.2	Tensile Strength Change, max	-30%	
3.2.6.3	Elongation Change, max	-20%	
3.2.6.4	Volume Change	0 to +25%	
3.2.6.5	Decomposition	None	
3.2.6.6	Surface Tackiness	None	
3.2.7	Dry Heat Resistance:		ASTM D 573 225 °C ± 3
3.2.7.1	Hardness Change, Durometer "A" or equivalent	-5 to +10	(437 °F ± 5) 22 hours ± 0.5
3.2.7.2	Tensile Strength Change, max	-15%	
3.2.7.3	Elongation Change, max	-20%	
3.2.7.4	Bend (flat)	No cracking or checking	

TABLE 1 - Properties (Continued)

Paragraph	Property	Requirement	Test Method
3.2.8	Compression Set:		ASTM D 395, Method B 175 °C ± 3
3.2.8.1	Percent of Original Deflection, max	30	(347 °F ± 5) 22 hours ± 0.5
3.2.9	Low-Temperature Resistance:		
3.2.9.1	Brittleness	Pass	ASTM D 2137, Method A -85 °C ± 3 (-120 °F ± 5)
3.2.9.2	Young's Modulus, max (See 8.2)	10.0 ksi (68.9 MPa)	ASTM D 797 -85 °C ± 3 (-120 °F ± 5) 5 hours ± 0.2

3.2.10 Weather Resistance: The product shall show no evidence of cracking when tested in accordance with ASTM D 1149 for seven days at 40 °C ± 1 (104 °F ± 2). Test specimens shall be prepared and mounted in accordance with ASTM D 518, Method B.

3.2.11 Corrosion: The product shall not have a corrosive effect on other materials when exposed to conditions normally encountered in service, determined by a procedure acceptable to purchaser. Discoloration of metal shall not be considered objectionable.

3.3 Quality:

The product, as received by purchaser, shall be uniform in quality and condition, smooth, as free from foreign material as commercially practicable, and free from imperfections detrimental to usage of the product.

3.4 Tolerances:

Shall conform to all applicable requirements of AMS 2279 or MAM 2279.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The manufacturer of the product shall supply all samples for required tests and shall be responsible for all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the product conforms to the requirements of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Requirements shown in Table 2 are acceptance tests and shall be performed on each lot.

TABLE 2 - Acceptance Tests

Requirement	Paragraph Reference
Hardness	3.2.1
Tensile Strength	3.2.2
Elongation	3.2.3
Specific Gravity	3.2.5
Brittleness	3.2.9.1
Tolerances	3.4

4.2.2 Preproduction Tests: All technical requirements are preproduction tests and shall be performed prior to or on the initial shipment of a product to a purchaser, when a change in ingredients and/or processing requires reapproval as in 4.4.2, and when purchaser deems confirmatory testing to be required.

4.2.2.1 For direct U.S. Military procurement, substantiating test data and, when requested, preproduction test material shall be submitted to the cognizant agency as directed by the procuring activity, contracting officer, or request for procurement.

4.3 Sampling and Testing:

Shall be as follows:

4.3.1 For Acceptance Tests: Sufficient product shall be taken at random from each lot to perform all required tests. The number of determinations for each requirement shall be as specified in the applicable test procedure or, if not specified therein, not less than three.

4.3.1.1 If specimens cannot be prepared from the product, ASTM specimens prepared from the same batch and state of cure shall be used. When the product supplied is an extrusion of such shape that suitable test specimens cannot be cut from the product, a separate flat strip test sample from the same production lot shall be supplied upon request. This strip shall be prepared from tubing 1.000 inch ± 0.063 (25.40 mm ± 1.60) in OD by 0.075 inch ± 0.008 (1.90 mm ± 0.20) in wall thickness, mechanically slit and flattened into a strip while being extruded, and cured in the same manner as production product. When the product is a molded shape from which test specimens cannot be cut, a slab 6 inches (152 mm) square by 0.075 inch ± 0.008 (1.90 mm ± 0.20) thick, molded from the same batch of compound, shall be supplied upon request.

4.3.1.2 A lot shall be all product from the same batch of compound processed in one continuous run and presented for manufacturer's inspection at one time.