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400 Commonwealth Dr., Warrendale, PA 15096

AEROSPACE MATERIAL SPECIFICATION

Submitted for recognition as an American National Standard

SAE AMS 3347A

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Superseding AMS 3347

SILICONE RUBBER
1200 psi (8.25 MPa), High Modulus
45 - 55

1. SCOPE:

1.1 Form: This specification covers a silicone rubber in the form of sheet, strip, tubing, extrusions, and molded shapes.

1.2 Application: Primarily for rubber-like parts required to operate or seal from -75° to +205°C (-100° to +400°F), compounded especially for high strength. Silicone elastomer is resistant to deterioration by weathering and by high-aniline-point petroleum-base oils and remains flexible over the temperature range noted. These products are not normally suitable for use in contact with gasoline or aromatic fuels and low-aniline-point petroleum-base fluids due to excessive swelling.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

2.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2279 - Tolerances, Rubber Products
MAM 2279 - Tolerances, Metric, Rubber Products
AMS 2350 - Standards and Test Methods
AMS 2810 - Identification and Packaging, Elastomeric Products

2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM D297 - Rubber Products - Chemical Analysis
ASTM D395 - Rubber Property - Compression Set
ASTM D412 - Rubber Properties in Tension
ASTM D471 - Rubber Property - Effect of Liquids
ASTM D573 - Rubber - Deterioration in an Air Oven
ASTM D624 - Rubber Property - Tear Resistance
ASTM D2137 - Rubber Property - Brittleness Point of Flexible Polymers and Coated Fabrics
ASTM D2240 - Rubber Property - Durometer Hardness

3. TECHNICAL REQUIREMENTS:

3.1 Material: Shall be a compound based on a silicone rubber, suitably cured to produce a product meeting the requirements of 3.2. Ø

3.2 Properties: The product shall conform to the following requirements; tests shall be performed on the product supplied and in accordance with specified ASTM methods, insofar as practicable:

3.2.1 As Received:

3.2.1.1	Hardness, Durometer "A" or equiv.	50 ± 5	ASTM D2240
3.2.1.2	Tensile Strength, min	1200 psi (8.25 MPa)	ASTM D412, Die B or C
3.2.1.3	Elongation, min	500%	ASTM D412, Die B or C
3.2.1.4	Tear Resistance, min	150 lb per in. (26.5 kN/m)	ASTM D624, Die B
3.2.1.5 Ø	Specific Gravity	Preproduction Value ± 0.03	ASTM D297

3.2.2	Petroleum Lubricating Oil Resistance: (Immediate Deteriorated Properties)		ASTM D471 Medium: ASTM Oil No. 1 Temperature: 175°C ± 3 (347°F ± 5) Time: 70 hr ± 0.5
3.2.2.1	Hardness Change, Durometer "A" or equiv.	-15 to +5	
3.2.2.2	Tensile Strength Change, max	-35%	
3.2.2.3	Elongation Change, max	-30%	
3.2.2.4	Volume Change	0 to +10%	
3.2.2.5	Decomposition	None	

3.2.2.6	Surface Tackiness	None	
3.2.3 Ø	Dry Heat Resistance:		ASTM D573 Temperature: 225°C ± 3 (437°F ± 5) Time: 22 hr ± 0.5
3.2.3.1	Hardness Change, Durometer "A" or equiv.	0 to +10	
3.2.3.2	Tensile Strength Change, max	-25%	
3.2.3.3	Elongation Change, max	-25%	
3.2.3.4	Bend (flat)	No cracking or checking	
3.2.4	Compression Set:		ASTM D395, Method B Temperature: 175°C ± 3 (347°F ± 5) Time: 22 hr ± 0.5
3.2.4.1	Percent of Original Deflection, max	50	
3.2.5	Low-Temperature Resistance:		
3.2.5.1	Brittleness	Pass	ASTM D2137, Method A Temperature: -75°C ± 3 (-103°F ± 5) Time: 3 min. ± 0.3

3.2.6 Weathering: The product shall have weather resistance acceptable to purchaser, determined by a procedure agreed upon by purchaser and vendor.

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

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

3.4 Ø Tolerances: Shall conform to AMS 2279 or MAM 2279.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Ø Responsibility for Inspection: The vendor of the product shall supply all samples for vendor's tests and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.5. 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: Tests to determine conformance to the following Ø requirements are classified as acceptance tests and shall be performed on each lot:

Requirement	Paragraph Reference
Hardness, as received	3.2.1.1
Tensile Strength, as received	3.2.1.2
Elongation, as received	3.2.1.3
Specific Gravity	3.2.1.5

4.2.2 Preproduction Tests: Tests to determine conformance to all technical Ø requirements of this specification are classified as preproduction tests and shall be performed prior to or on the initial shipment of a product to a purchaser, when a change in material, processing, or both, 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, the contracting officer, or the request for procurement.

4.3 Sampling: Shall be as follows:

4.3.1 For Acceptance Tests: Sufficient product shall be taken at random from each Ø 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. 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 specimens cannot be cut from the product, a separate flat strip test sample shall be supplied upon request. This strip shall be prepared from tubing 1 in. ± 0.063 (25 mm ± 1.60) in OD by 0.075 in. ± 0.008 (1.90 mm ± 0.20) in wall thickness, mechanically split and flattened into a strip while being extruded, and cured in the same manner as production material. When the product is a molded shape from which specimens cannot be cut, a slab 6 x 6 in. (150 x 150 mm) by 0.080 in. ± 0.008 (2.00 mm ± 0.020) molded from the same batch of compound shall be supplied upon request.

4.3.1.1 A lot shall be all product from the same batch of compound processed in a Ø continuous run and presented for vendor's inspection at one time. An inspection lot shall not exceed 500 lb (225 kg). A lot may be packaged in small quantities under the basic lot approval provided lot identification is maintained.

4.3.1.2 A batch shall be the quantity of compound run through a mill or mixer at Ø one time.