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| AEROSPACE MATERIAL SPECIFICATION | AMS3348 | REV. D |
| | Issued 1969-11 Revised 1994-01 Reaffirmed 2007-06 Stabilized 2014-05 Superseding AMS3348C | |
| Silicone (VMQ) Rubber 1150 psi (7.93 MPa) Tensile Strength, High Resiliency 25 - 35 | | |

RATIONALE

This document has been determined to contain basic and stable technology which is not dynamic in nature.

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1. SCOPE:

1.1 Form:

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

1.2 Application:

These products have been used typically for parts required to operate or seal from -75 to +205 °C (-103 to +401 °F), compounded especially for high strength and resiliency, but usage is not limited to such applications.

- 1.2.1 Silicone elastomer is resistant to deterioration by weathering and aircraft piston engine oil and remains flexible over the temperature range noted. The rubber is not normally suitable for use in contact with gasoline or aromatic fuels and low-aniline-point petroleum-base fluids due to excessive swelling of the elastomer.

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.

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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 publications shall be the issue in effect on the date of the purchase order.

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 573 | Rubber - Deterioration in An Air Oven |
| ASTM D 624 | Rubber Property - Tear Resistance |
| ASTM D 1415 | Rubber Property - International Hardness |
| ASTM D 2137 | Rubber Property - Brittleness Point of Flexible Polymers and Coated Fabrics |
| ASTM D 2240 | Rubber Property - Durometer Hardness |
| ASTM D 2632 | Rubber Property - Resilience by Vertical Rebound |

3. TECHNICAL REQUIREMENTS:

3.1 Material:

Shall be a compound based on a silicone (VMQ) 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, 3.2.11, and 3.2.12; 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 | 30 ± 5 | ASTM D 2240 or ASTM D 1415 |
| 3.2.2 | Tensile Strength, minimum | 1150 psi (7.93 MPa) | ASTM D 412, Die B or C |
| 3.2.3 | Elongation, minimum | 550% | ASTM D 412, Die B or C |
| 3.2.4 | Impact Resilience, minimum | 40 | ASTM D 2632 |
| 3.2.5 | Tear Resistance, minimum | 140 pounds force per inch (24.5 kN/m) | ASTM D 624, Die B |
| 3.2.6 | Specific Gravity | Preproduction Value ± 0.03 | ASTM D 297 |
| 3.2.7 | Petroleum Lubricating Oil Resistance: (Immediate Deteriorated Properties) | | ASTM D 471 ASTM Oil No. 1 175 °C ± 3 (347 °F ± 5) 70 hours ± 0.5 |
| 3.2.7.1 | Hardness Change, Durometer "A" or equivalent | -10 to +5 | |
| 3.2.7.2 | Tensile Strength Change, maximum | -60% | |
| 3.2.7.3 | Elongation Change, maximum | -45% | |
| 3.2.7.4 | Volume Change | 0 to +10% | |
| 3.2.8 | Dry Heat Resistance: | | ASTM D 573 225 °C ± 3 |
| 3.2.8.1 | Hardness Change, Durometer "A" or equivalent | -10 to +5 | (437 °F ± 5) 22 hours ± 0.5 |
| 3.2.8.2 | Tensile Strength Change, maximum | -30% | |
| 3.2.8.3 | Elongation Change, maximum | -35% | |
| 3.2.9 | Compression Set: | | ASTM D 395, Method B 175 °C ± 3 |
| 3.2.9.1 | Percent of Original Deflection, maximum | 40 | (347 °F ± 5) 22 hours ± 0.5 |
| 3.2.10 | Low-Temperature Resistance: | | ASTM D 2137, Method A -75 °C ± 3 |
| 3.2.10.1 | Brittleness | Pass | (-103 °F ± 5) |

3.2.11 Weather Resistance: The product shall have weather resistance acceptable to purchaser, determined by a procedure agreed upon by purchaser and supplier.

3.2.12 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 supplier. 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 performing 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: Tests for requirements shown in Table 2 are acceptance tests and shall be performed on each lot.

TABLE 2 - Acceptance Tests

| Requirement | Paragraph |
|-------------------|-----------|
| Hardness | 3.2.1 |
| Tensile Strength | 3.2.2 |
| Elongation | 3.2.3 |
| Impact Resilience | 3.2.4 |
| Specific Gravity | 3.2.6 |
| Tolerances | 3.4 |

- 4.2.2 Preproduction Tests: Tests for all technical requirements are preproduction tests and shall be performed prior to or on the initial shipment of a product by the manufacturer, 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 test specimens prepared from the same batch and state of cure shall be used for required tests. 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 \pm 0.063 (25.40 mm \pm 1.60) in OD by 0.075 inch \pm 0.008 (1.90 mm \pm 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 \pm 0.008 (1.90 mm \pm 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.
- 4.3.1.3 A batch shall be the quantity of compound run through a mill or mixer at one time.
- 4.3.1.4 When a statistical sampling plan has been agreed upon by purchaser and supplier, sampling shall be in accordance with such plan in lieu of sampling as in 4.3.1 and the report of 4.5 shall state that such plan was used.
- 4.3.2 For Preproduction Tests: As agreed upon by purchaser and supplier.
- 4.4 Approval:
- 4.4.1 Sample product shall be approved by purchaser before product for production use is supplied, unless such approval be waived by purchaser. Results of tests on production product shall be essentially equivalent to those on the approved sample.