SAE Aerospace
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AEROSPACE MATERIAL SPECIFICATION

SAE AMS3374/4 REV. A

Issued 1996-11
Cancelled 2011-02

Superseded by AMS3374

Sealing Compound
Two-Part, Polysulfide (Type 4)
Firewall Sealant

RATIONALE

Specification slash sheet is being cancelled. Technical information was incorporated in Revision C (July 2005) of base specification (AMS3374).

CANCELLATION NOTICE

This document has been declared "CANCELLED" as of February 2011 and has been superseded by AMS3374. By this action, this document will remain listed in the Numerical Section of the Aerospace Standards Index noting that it is superseded by AMS3374.

Cancelled specifications are available from SAE.

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1. SCOPE:

1.1 Form:

This specification covers two-part, high temperature resistant polysulfide compounds.

1.2 Application:

This product is used primarily for sealing aircraft firewall structures against passage of air and vapors. The cured compound shall remain an effective sealant at all temperatures between -65 and +400 °F (-54 to +204 °C) and shall be able to withstand a flash temperature of 2000 °F (1093 °C).

2. APPLICABLE DOCUMENTS:

See AMS 3374.

3. TECHNICAL REQUIREMENTS:

3.1 Basic Specifications:

The complete requirements for procuring the sealing compound described herein shall consist of this document and the latest issue of the basic specification AMS 3374.

3.2 Properties:

Shall conform to the following requirements, determined in accordance with test methods listed in AMS 3374 and Table 1.

3.2.1 Primer: The manufacturer's recommended primer shall be used in preparation of all applicable test specimens.

TABLE 1 - Properties

Test Method Paragraph (Basic Specification)	Property	Requirement
4.5.3	Specific Gravity. max	1.5
4.5.4	Nonvolatile Content, min	98%
4.5.5	Flow	0.2 inch (5 mm)
4.5.6	Tack-Free Time, max	6 hours
4.5.7	Hardness, Durometer A, min	35
4.5.8	Thermal-Rupture Resistance, max	1/8 inch (3.2 mm)
4.5.9	Low Temperature Flexibility	No cracking or loss of adhesion
4.5.10	Peel Strength, min	10 pounds/inch (1750 N/m)
4.5.11	Corrosion Resistance	No loss of adhesion, softening, blistering, or leaching. No corrosion of panels. Discoloration is acceptable.
4.5.12	Flame Resistance	No Flame Penetration
4.5.13	Oil Resistance	No loss of adhesion, softening, or blistering.
4.5.14	Storage Stability	Shall meet requirements for flow, tack-free time and hardness.
4.5.15	Shear Strength, psi, min	150 min (85% Cohesion)
4.5.16	Application Time, min	15 grams
4.5.17	Repairability	Adhere

4. QUALITY ASSURANCE PROVISIONS:

See AMS 3374.

5. PREPARATION FOR DELIVERY:

5.1 Packaging:

Compound shall be furnished in individual containers (for base compound and curing compound) or sectional-type containers. The ratio of the quantity in base container to the quantity contained in the curing agent container shall be the same as the recommended mixing ratio of the base compound and curing agent.

5.1 .1 Individual Containers: The base compound shall be furnished in 1/2 pint (237 mL), 1 pint (473 mL), 1 quart (946 mL), or 1 gallon (3.79 L) metal cans, or as specified in the purchase order. Metal cans shall conform to PPP-C-96, Type V, Class 2. Tin plate cans with paper labels may be used, unless specifically prohibited by purchaser. The base compound contained in each size container shall be as shown in Table 2.

TABLE 2 - Containers

Size of Container	Amount of Base Compound
1/2 pint (237 mL)	6 fluid ounces ± 1/8 (177 mL ± 4)
1 pint (473 ml)	12 fluid ounces ± 1/4 (355 mL ± 7)
1 quart (946 mL)	24 fluid ounces ± 1/2 (710 mL ± 15)
1 gallon (3.79 L)	96 fluid ounces ± 2 (2839 mL ± 60)

5.1.2 The curing agent shall be furnished in glass jars or bottles, cans or in suitable plastic containers approved by purchaser. The jars or plastic containers, as applicable, shall have vertical, smooth inside walls and no internal projections or internal lips exceeding 1/16 inch (1.6 mm). The glass jars and bottles shall be closed with enabled metal or plastic continuous thread screw caps having a nonabsorbent lining material. Caps shall be tightened adequately and further sealed with cellulose bands or equivalent. One container each of the base compound and curing agent, individually packaged in accordance with the forgoing, shall be enclosed in PPP-B-636, Grade W5C, container and shall constitute a complete kit.

5.1.3 Sectional Type Containers: The base compound and curing agent shall be furnished in high density polyethylene sectional type 2-1/2 ounces (74 mL) or 6 ounce (177 mL) cartridges, conforming to MIL-P-38714, as specified in the purchase order. The total content of the base compound and curing agent contained in each sectional type container shall be shown in Table 3.

TABLE 3 - Sectional Type Containers

Size of Container	Total Content (Base Resin and Curing Agent)
2-1/2 ounce (74 mL)	2 fluid ounces ± 1/8 (59 mL ± 4)
6 ounce (177 mL)	3-1/2 fluid ounces ± 1/8 (59 mL ± 4)

5.1.4 Sectional Type Containers: The base compound and curing agent shall be furnished in high density polyethylene sectional type 2-1/2 ounces (74 mL) or 6 ounce (177 mL) cartridges, conforming to MIL-P-38714, as specified in the purchase order. The total content of the base compound and curing agent contained in each sectional type container shall be shown in Table 3.

5.1.5 Containers of compound shall be prepared for shipment in accordance with commercial practice and in compliance with applicable rules and regulations pertaining to the handling, packaging, and transportation of the compound to ensure carrier acceptance and safe delivery.

5.1.6 Primer: Six 4 fluid ounce (120 mL) glass bottles of primer shall be furnished with each 24 cartridge box of sealing compound. The bottles shall be packaged in a suitable sectionalized cardboard box. Instructions for use of the primer shall be included.