



# AEROSPACE MATERIAL SPECIFICATION

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## AMS 3348

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Revised

SILICONE RUBBER  
1150 psi Tensile Strength, High Resiliency  
25 - 35

1. ACKNOWLEDGMENT: A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.
2. FORM: Sheet, strip, tubing, molded shapes, extrusions, or as ordered.
3. APPLICATION: Primarily for rubber-like parts required to operate or seal at temperatures from -75 to +205 C (-103 to +401 F), compounded especially for high strength. Silicone rubber is resistant to deterioration by weathering and by high aniline point petroleum base oils and remains flexible over the temperature range noted. This material is not normally suitable for use in contact with gasoline or aromatic fuels and low aniline point petroleum base fluids due to excessive swelling.
4. TECHNICAL REQUIREMENTS:
  - 4.1 General:
    - 4.1.1 Condition: Unless otherwise specified, a suitably cured product shall be furnished.
    - 4.1.2 Weathering: When specified, the product shall have weather resistance acceptable to the purchaser as determined by a procedure agreed upon by purchaser and vendor.
    - 4.1.3 Corrosion: The product shall not have a corrosive effect on other materials when exposed to conditions normally encountered in service. Discoloration of metal shall not be considered objectionable.
  - 4.2 Properties: The product shall conform to the following requirements; tests shall be performed on the product supplied and in accordance with the issue of specified ASTM methods listed in the latest issue of AMS 2350, insofar as practicable. When the product supplied is of such shape that suitable test specimens cannot be cut from the product, a separate flat strip test sample shall be supplied upon request. This strip shall be prepared from 1 in.  $\pm$  1/16 OD by 0.075 in.  $\pm$  0.008 thick wall tubing which shall be mechanically split and flattened into a strip while being extruded and cured in the same manner as production material.
    - 4.2.1 As Received:

|                                           |            |                       |
|-------------------------------------------|------------|-----------------------|
| 4.2.1.1 Hardness, Durometer "A" or equiv. | 30 $\pm$ 5 | ASTM D2240            |
| 4.2.1.2 Tensile Strength, psi, min        | 1150       | ASTM D412, Die B or C |
| 4.2.1.3 Elongation, %, min                | 550        | ASTM D412, Die B or C |
| 4.2.1.4 Impact Resilience, min            | 40         | ASTM D2632            |
| 4.2.1.5 Tear Resistance, lb per in., min  | 140        | ASTM D624, Die B      |
| 4.2.1.6 Specific Gravity                  | See Note 1 | ASTM D297             |

4.2.2 Lubricating Oil Resistance:  
(Immediate Deteriorated Properties)

ASTM D471

Medium: ASTM Oil No. 1

Temperature:  $175\text{ C} \pm 3$   
( $347\text{ F} \pm 5.4$ )

Time: 70 hr

4.2.2.1 Hardness Change, Durometer "A" or equiv. -10 to +5

4.2.2.2 Tensile Strength Change, %, max (based on area before immersion) -60

4.2.2.3 Elongation Change, %, max -45

4.2.2.4 Volume Change, % 0 to +10

4.2.2.5 Decomposition None

4.2.2.6 Surface Tackiness None

4.2.3 Dry Heat Resistance:

ASTM D573

Temperature:  $225\text{ C} \pm 3$   
( $437\text{ F} \pm 5.4$ )

Time: 24 hr

4.2.3.1 Hardness Change, Durometer "A" or equiv. -10 to +5

4.2.3.2 Tensile Strength Change, %, max -30

4.2.3.3 Elongation Change, %, max -35

4.2.3.4 Bend (flat) No cracking or checking

4.2.4 Compression Set:

ASTM D395, Method B

Temperature:  $175\text{ C} \pm 3$   
( $347\text{ F} \pm 5.4$ )

Time: 22 hr

4.2.4.1 Per cent of original deflection, max 40

4.2.4.2 Per cent of original thickness, max 10

4.2.5 Low Temperature Resistance:

4.2.5.1 Brittleness Pass

ASTM D746 Procedure B

Temperature:  $-75\text{ C} \pm 3$   
( $-103\text{ F} \pm 5.4$ )

Time 10 min.

Note 1. Value to be reported. Production material shall be within  $\pm 0.05$  of the value agreed upon by purchaser and vendor.

5. QUALITY: The product shall be uniform in quality and condition, clean, smooth, and free from chalky spots and foreign materials, and from imperfections detrimental to fabrication, appearance, or performance of parts.

6. TOLERANCES: Unless otherwise specified, the following tolerances apply:

6.1 Sheet:

| Nominal Thickness<br>Inches | Tolerance, Inch<br>Plus and Minus |
|-----------------------------|-----------------------------------|
| Up to 1/8, incl             | 1/64                              |
| Over 1/8 to 1/2, incl       | 1/32                              |
| Over 1/2                    | 3/64                              |

6.2 Tubing:

| 6.2.1 | Nominal OD or ID<br>(not both), Inches | Tolerance<br>Plus and Minus | Ovality, %<br>(See Note 2) |
|-------|----------------------------------------|-----------------------------|----------------------------|
|       | Up to 1/2, incl                        | 0.020 in.                   | 10                         |
|       | Over 1/2 to 1, incl                    | 0.030 in.                   | 15                         |
|       | Over 1                                 | 4%                          | 15                         |

Note 2. Ovality applies to tubing ordered in straight lengths with wall thickness of 1/16 in. and over, and shall be computed from the difference between the minor and major axis diameter measurements, as a percentage of the nominal diameter.

| 6.2.2 | Nominal Wall Thickness<br>Inches | Tolerance<br>Plus and Minus |
|-------|----------------------------------|-----------------------------|
|       | Up to 1/16, excl                 | 0.005 in.                   |
|       | 1/16 and over                    | 10%                         |

7. REPORTS:

- 7.1 Unless otherwise specified, the vendor of the product shall furnish with each shipment three copies of a report showing the results of tests to determine conformance to the requirements of this specification. This report shall include the purchase order number, material specification number, vendor's compound number, specific gravity value, form or part number, and quantity.
- 7.2 Unless otherwise specified, the vendor of finished or semi-finished parts shall furnish with each shipment three copies of a report showing the purchase order number, material specification number, contractor or other direct supplier of material, supplier's compound number, part number, and quantity. When material for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of material to determine conformance to the requirements of this specification, and shall include in the report a statement that the material conforms, or shall include copies of laboratory reports showing the results of tests to determine conformance.

8. IDENTIFICATION: Unless otherwise specified, all material shall be identified in accordance with the latest issue of AMS 2810 except cure date is not required.

9. PACKAGING:

- 9.1 Packaging shall be accomplished in such a manner as to ensure that the product, during shipment and storage, will not be permanently distorted and will be protected against damage from exposure to weather or any normal hazard.
- 9.2 Each package shall be permanently and legibly marked in accordance with the latest issue of AMS 2810 except cure date is not required.

10. APPROVAL:

- 10.1 Sample material shall be approved by purchaser before material for production use is supplied, unless such approval be waived. Results of tests on production material shall be essentially equivalent to those on the approved sample.