



AEROSPACE MATERIAL

Society of Automotive Engineers, Inc.
400 COMMONWEALTH DRIVE, WARRENDALE, PA. 15096

SPECIFICATION

AMS 3348A

Superseding AMS 3348

Issued 11-1-69

Revised 1-15-77

SILICONE RUBBER

1150 psi (7.93 MPa) Tensile Strength, High Resiliency
25 - 35

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 parts required to operate or seal at temperatures from -75° to +205° C (-105° to +400° F), compounded especially for high strength and resiliency. Silicone rubber is resistant to deterioration by weathering and aircraft piston engine oil 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 of the elastomer.

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

- 2.1 SAE Publications: Available from Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

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 Method
ASTM D624 - Rubber Property - Tear Resistance
ASTM D2137 - Rubber Property - Brittleness Point of Flexible Polymers and Coated Fabrics
ASTM D2240 - Rubber Property - Durometer Hardness
ASTM D2632 - Rubber Property - Resilience (Vertical Rebound)

- 2.3 Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

2.3.1 Military Standards:

MIL-STD-794 - Parts and Equipment, Procedures for Packaging and Packing of

3. TECHNICAL REQUIREMENTS:

SAE Technical Board rules provide that: "All technical reports, including standards approved and practices recommended, are advisory only. Their use by anyone engaged in industry or trade is entirely voluntary. There is no agreement to adhere to any SAE standard or recommended practice, and no commitment to conform to or be guided by any technical report. In formulating and approving technical reports, the Board and its Committees will not investigate or consider patents which may apply to the subject matter. Prospective users of the report are responsible for protecting themselves against liability for infringement of patents."

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

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.	30 ± 5	ASTM D2240
---------	--------------------------------------	------------	------------

3.2.1.2	Tensile Strength, min	1150 psi (7.93 MPa)	ASTM D412, Die B or C
---------	-----------------------	------------------------	--------------------------

3.2.1.3	Elongation, min	550%	ASTM D412, Die B or C
---------	-----------------	------	--------------------------

3.2.1.4	Impact Resilience, min	40	ASTM D2632
---------	------------------------	----	------------

3.2.1.5	Tear Resistance, min	140 lb per in. (24.5 kN/m)	ASTM D624, Die B
---------	----------------------	-------------------------------	---------------------

3.2.1.6	Specific Gravity Ø	Qualification Value ± 0.03	ASTM D297
---------	-----------------------	-----------------------------------	-----------

3.2.2 Petroleum Lubricating Oil Resistance:
(Immediate Deteriorated Properties)

ASTM D471

Medium: ASTM Oil No. 1

Temperature: $175^{\circ} \text{C} \pm 3$
($347^{\circ} \text{F} \pm 5$)

Time: 70 hr ± 0.5

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

3.2.2.2	Tensile Strength Change, max	-60%
---------	------------------------------	------

3.2.2.3	Elongation Change, max	-45%
---------	------------------------	------

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 Dry Heat Resistance:

ASTM D573

Temperature: $225^{\circ} \text{C} \pm 3$
($437^{\circ} \text{F} \pm 5$)

Time: 24 hr ± 0.5

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

3.2.3.2	Tensile Strength Change, max	-30%
---------	------------------------------	------

3.2.3.3	Elongation Change, max	-35%
---------	------------------------	------

3.2.3.4	Bend (flat)	No cracking or checking
---------	-------------	----------------------------

3.2.4 Compression Set:

ASTM D395, Method B

3.2.4.1 Percent of Original
Deflection, max

40

Temperature: $175^{\circ}\text{C} \pm 3$
($347^{\circ}\text{F} \pm 5$)Time: 22 hr ± 0.5 Ø 3.2.5 Low-Temperature Resistance:

ASTM D2137, Method A

3.2.5.1 Brittleness

Pass

Temperature: $-75^{\circ}\text{C} \pm 3$
($-103^{\circ}\text{F} \pm 5$)3.2.6 Weathering: When specified, the product shall have weather resistance acceptable to the purchaser, determined by a procedure agreed upon by purchaser and vendor.3.2.7 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.3.3 Quality: The product shall be uniform in quality and condition, clean, smooth, as free from foreign materials as commercially practicable, and free from internal and external imperfections detrimental to fabrication, appearance, or performance of parts.3.4 Tolerances: Unless otherwise specified, the following tolerances shall apply:3.4.1 Sheet and Strip:

TABLE I

Nominal Thickness Inches	Tolerance, Inch plus and minus
Up to 0.125, incl	0.016
Over 0.125 to 0.500, incl	0.031
Over 0.500	0.047

TABLE I (SI)

Nominal Thickness Millimetres	Tolerance, Millimetres plus and minus
Up to 3.18, incl	0.41
Over 3.18 to 12.70, incl	0.79
Over 12.70	1.19

3.4.2 Tubing:3.4.2.1 Diameter:

TABLE II

Nominal OD or ID (not both), Inches	Tolerance plus and minus	Ovality, % (See 3.4.2.1.1)
Up to 0.500, incl	0.020 in.	10
Over 0.500 to 1.000, incl	0.030 in.	15
Over 1.000	4%	15

TABLE II (SI)

Nominal OD or ID (not both), Millimetres	Tolerance plus and minus	Ovality, % (See 3.4.2.1.1)
Up to 12.70, incl	0.51 mm	10
Over 12.70 to 25.40, incl	0.76 mm	15
Over 25.40	4%	15

3.4.2.1.1 Ovality applies to tubing ordered in straight lengths with wall thickness of 0.063 in. (1.60 mm) and over and shall be computed from the difference between the minor and major axis diameter measurements, taken at the same transverse plane on the tube, expressed as a percentage of the nominal diameter.

3.4.2.2 Wall Thickness:

TABLE III

Nominal Wall Thickness Inches	Tolerance plus and minus
Up to 0.063, excl	0.005 in.
0.063 and over	10%

TABLE III (SI)

Nominal Wall Thickness Millimetres	Tolerance plus and minus
Up to 1.60, excl	0.13 mm
1.60 and over	10%

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of the product shall supply all samples 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 perform such confirmatory testing as he deems 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 requirements are classified as acceptance tests and shall be performed on each lot of product:

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
Impact Resilience	3.2.1.4
Specific Gravity	3.2.1.6