

# AEROSPACE MATERIAL SPECIFICATION

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Superseding AMS 3357F

## RUBBER, SILICONE (VMQ) Lubricating Oil and Compression Set Resistant 65 - 75

### 1. SCOPE:

#### 1.1 Form:

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

#### 1.2 Application:

Primarily for parts required to operate or seal from -55° to +230°C (-67° to +446 °F), compounded specially for aircraft piston engine oil resistance and low compression set. Silicone elastomer is resistant to deterioration by weathering and by high-aniline-point petroleum-base oils 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.

### 2. APPLICABLE DOCUMENTS:

The following publications form a part of this specification to the extent 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.

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#### TO PLACE A DOCUMENT ORDER:

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<http://www.sae.org>

#### SAE WEB ADDRESS:

## 2.1 SAE Publications:

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

## 2.1.1 Aerospace Material Specifications:

|          |                                                    |
|----------|----------------------------------------------------|
| AMS 2279 | Tolerance, 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 797  | Rubber Property - Young's Modulus at Normal and Subnormal Temperatures      |
| ASTM D 2137 | Rubber Property - Brittleness Point of Flexible Polymers and Coated Fabrics |
| ASTM D 2240 | Rubber Property - Durometer Hardness                                        |

## 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 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 equivalent | 70 ± 5                | ASTM D 2240            |
| 3.2.1.2 | Tensile Strength, minimum             | 800 psi<br>(5.52 MPa) | ASTM D 412, Die B or C |
| 3.2.1.3 | Elongation, minimum                   | 150%                  | ASTM D 412, Die B or C |

| AMS 3357G |                                                                              | SAE                                        | AMS 3357G                                                                                                                                       |
|-----------|------------------------------------------------------------------------------|--------------------------------------------|-------------------------------------------------------------------------------------------------------------------------------------------------|
| 3.2.1.4   | Tensile Stress at 50% Elongation, minimum                                    | 200 psi<br>(1.39 MPa)                      | ASTM D 412, Die B or C                                                                                                                          |
| 3.2.1.5   | Tear Strength, minimum                                                       | 60 pounds<br>force per<br>inch (10.5 kN/m) | ASTM D 624, Die B                                                                                                                               |
| 3.2.1.6   | Specific Gravity<br>Value $\pm 0.03$                                         | Preproduction                              | ASTM D 297                                                                                                                                      |
| 3.2.2     | Petroleum Lubricating Oil Resistance:<br>(Immediate Deteriorated Properties) |                                            | ASTM D 471<br>Medium: ASTM Oil No. 1<br>Temperature: $175^{\circ}\text{C} \pm 3$<br>( $347^{\circ}\text{F} \pm 5$ )<br>Time: 70 hours $\pm 0.5$ |
| 3.2.2.1   | Hardness Change, Durometer<br>"A" or equivalent                              | -10 to +5                                  |                                                                                                                                                 |
| 3.2.2.2   | Tensile Strength Change,<br>maximum                                          | -20%                                       |                                                                                                                                                 |
| 3.2.2.3   | Elongation Change, maximum                                                   | -15%                                       |                                                                                                                                                 |
| 3.2.2.4   | Volume Change, maximum                                                       | 0 to +15%                                  |                                                                                                                                                 |
| 3.2.2.5   | Decomposition                                                                | None                                       |                                                                                                                                                 |
| 3.2.2.6   | Surface Tackiness                                                            | None                                       |                                                                                                                                                 |
| 3.2.3     | Dry Heat Resistance:                                                         |                                            | ASTM D 573<br>Temperature: $225^{\circ}\text{C} \pm 3$<br>( $437^{\circ}\text{F} \pm 5$ )<br>Time: 22 hours $\pm 0.5$                           |
| 3.2.3.1   | Hardness Change, maximum<br>"A" or equivalent                                | -5 to +10                                  |                                                                                                                                                 |
| 3.2.3.2   | Tensile Strength Change,<br>maximum                                          | -15%                                       |                                                                                                                                                 |
| 3.2.3.3   | Elongation Change, maximum                                                   | -25%                                       |                                                                                                                                                 |
| 3.2.4     | Compression Set:                                                             |                                            | ASTM D 395, Method B<br>Temperature: $175^{\circ}\text{C} \pm 3$<br>( $347^{\circ}\text{F} \pm 5$ )<br>Time: 22 hours $\pm 0.5$                 |
| 3.2.4.1   | Percent of Original<br>Deflection, maximum                                   | 35                                         |                                                                                                                                                 |
| 3.2.5     | Low Temperature Resistance:                                                  |                                            |                                                                                                                                                 |

|         |                                       |                      |                                                                                                                      |
|---------|---------------------------------------|----------------------|----------------------------------------------------------------------------------------------------------------------|
| 3.2.5.1 | Brittleness                           | Pass                 | ASTM D 2137, Method A<br>Temperature: $-65^{\circ}\text{C} \pm 3$<br>( $-85^{\circ}\text{F} \pm 0.5$ )               |
| 3.2.5.2 | Young's Modulus, maximum<br>(See 8.2) | 10,000<br>(68.9 MPa) | ASTM D 797<br>Temperature: $-50^{\circ}\text{C} \pm 3$<br>( $-58^{\circ}\text{F} \pm 5$ )<br>Time: 5 hours $\pm 0.2$ |

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 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 Quality:

The product, as received by purchaser, shall be uniform in quality and condition, smooth, as free from foreign materials as commercially practicable, and free from imperfections detrimental to usage of the product.

### 3.4 Tolerances:

Shall conform to AMS 2279 or MAM 2279.

## 4. QUALITY ASSURANCE PROVISIONS:

### 4.1 Responsibility for Inspection:

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The vendor of the product shall supply all samples for vendor's 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 the following requirements are 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                     | 3.2.1.6             |
| Petroleum Lubricating Oil Resistance | 3.2.2               |
| Compression Set                      | 3.2.4               |

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 the product to a purchaser, 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:

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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 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. 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  $\pm$  0.020) 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 vendor's inspection at one time. An inspection lot shall not exceed 500 pounds (227 kg) and may be packaged in smaller quantities and delivered under the basic lot approval provided lot identification is maintained.