

AEROSPACE MATERIAL SPECIFICATIONS

AMS 3367

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Revised

SILICONE RUBBER COMPOUND

Room Temperature Vulcanizing, 1,200,000 Centipoises Viscosity
(Durometer 55 - 70)

1. ACKNOWLEDGMENT: A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.
2. FORM: Paste compound, to which a separate catalyst is added for curing.
3. APPLICATION: Primarily for sealing and caulking applications. Elastomeric properties are retained in operation at temperatures from -65 to +450 F (-55 to + 230 C). 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 low aniline point petroleum base fluids, including fuels, due to excessive swelling. For mechanical applications where compression set resistance is important, elevated temperature post-curing of parts may be required.
4. TECHNICAL REQUIREMENTS:
 - 4.1 General:
 - 4.1.1 Curing: When mixed with catalyst in accordance with manufacturer's recommendations and cured at room temperature, the compound shall polymerize to a uniform elastomeric material. A number of different catalysts may be found applicable by the user in order to vary pot life and cure time to meet specific production conditions. However, for purposes of qualification to this specification and for inspection control, a standard catalyst type and quantity, as supplied or recommended by the manufacturer of the base compound, shall be used.
 - 4.1.2 Viscosity: Viscosity of compound as received shall be 900,000 - 1,500,000 centipoises when measured on a Brookfield Viscometer at 75 F $\pm$ 5 (23.9 C $\pm$ 2.8). In measuring viscosity, the viscometer spindle and speed used shall be consistent with the viscosity of the material being tested, in accordance with directions supplied by the manufacturer of the instrument.
 - 4.1.3 Pot Life: Compound mixed with the recommended catalyst addition (See 4.1.1) and maintained at a temperature not higher than 85 F (30 C) shall have a pot life of not less than 30 min. nor more than 4 hours. Pot life shall be determined as follows: Weigh a 10 g $\pm$ 0.10 sample of the compound into a dish or cup 2- 2.5 in. in diameter. Add the recommended type and amount of catalyst (See 4.1.1) and mix thoroughly with a small spatula for 60 sec $\pm$ 10. Dip the spatula into the catalyzed compound and pull out strings of material. Repeat the pulling-out procedure at intervals until the strings break or pull back before stretching more than 1/8 inch. Pot life shall be recorded as the time interval between completion of the mixing cycle and first breaking of strings pulled 1/8 inch.

4.1.4 Shrinkage: Compound mixed with the recommended catalyst addition (See 4.1.1) and free of air shall be capable of not shrinking more than 1% in any direction when cured for 24 hr in a mold followed by 48 hr in open air. Test specimen shall be a standard slab approximately 6 in. x 6 in. and 0.075 in. $\pm$ 0.005 thick. Curing temperature shall be 75 F $\pm$ 5 (23.9 C $\pm$ 2.8).

4.1.5 Corrosion: The product shall not have a corrosive effect on other material when exposed to conditions normally encountered in service. Discoloration of metal shall not be considered objectionable.

4.2 Properties: The compound, when mixed with the recommended catalyst addition (See 4.1.1) and cured, shall conform to the requirements of 4.2.1, and shall be capable of meeting the requirements of 4.2.2, 4.2.3, and 4.2.4. Tests shall be performed in accordance with the issue of the listed ASTM methods specified in the latest issue of AMS 2350 insofar as practicable, on standard test slabs prepared in accordance with 4.1.4. Test results from specimens found to contain air bubbles at the point of break shall be discarded and new specimens selected for test. Air bubbles may be minimized by subjecting the catalyzed compound to low pressures or centrifuging before curing.

4.2.1 As Cured:

4.2.1.1	Hardness, Durometer "A" or equiv.	55 - 70	
4.2.1.2	Tensile Strength, psi, min	500	ASTM D412, Die B or C
4.2.1.3	Elongation, %, min	100	ASTM D412, Die B or C
4.2.1.4	Dielectric Strength, v per mil, min	300	ASTM D149
			Electrode Dia: 2 in.
			Rate of Rise: 500 v per sec

4.2.2 Dry Heat Resistance:

4.2.2.1	Hardness Change, Durometer "A" or equiv.	-10 to +10	ASTM D573
			Temperature: 450 F $\pm$ 5
			(232.2 C $\pm$ 2.8)
			Time: 24 hr
4.2.2.1.1	Hardness, Absolute, Durometer "A" or equiv., min	50	
4.2.2.2	Tensile Strength Change, %, max	-25	
4.2.2.3	Elongation Change, %, max	-25	

4.2.3 Compression Set:

			ASTM D395, Method B
4.2.3.1	Per cent of original deflection, max	70	Temperature: 212 F $\pm$ 5
			(100 C $\pm$ 2.8)
4.2.3.2	Per cent of original thickness, max	21	Time: 22 hr

4.2.4 Low Temperature Resistance:

4.2.4.1	Brittleness	Pass	ASTM D746, Procedure B
			Temperature: -67 F $\pm$ 2
			(-55 C $\pm$ 1.1)
			Time: 10 min.