

AEROSPACE MATERIAL SPECIFICATION

Submitted for recognition as an American National Standard

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Superseding AMS 3374

(R) SEALING COMPOUND Aircraft Firewall

1. SCOPE:

1.1 Form:

This specification and its supplementary detail specifications cover sealing compounds which cure to elastomeric materials.

1.2 Application:

These products are used primarily for sealing aircraft firewall structures against passage of air and vapors but usage is not limited to such applications. The sealing compounds are effective at all temperatures from -65 to +400 °F (-54 to +204 °C) and are able to withstand flash temperatures of up to 2000 °F (1093 °C).

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 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.

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1.4 Classification:

The requirements specified herein and in the applicable detail specifications define each sealing compound on the basis of physical properties as shown in the title of each detail specification.

Compounds covered by this specification are classified as follows:

- Type 1 - One-part high temperature silicone, cures on exposure to air
- Type 2 - Two-part high temperature silicone, addition cured
- Type 3 - Two-part high temperature silicone, condensation cured
- Type 4 - Two-part high temperature polysulfide

Unless a specific type is ordered, Type 1 shall be supplied.

2. APPLICABLE DOCUMENTS:

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

2.1 SAE Publications:

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

- AMS 2825 Material Safety Data Sheets
- AMS 3021 Fluid, Reference for Testing Di-Ester (Polyol) Resistant Materials.
- AMS 3819 Cloths, Cleaning, For Aircraft Primary and Secondary Structural Surfaces
- AMS 4045 Aluminum Alloy Sheet and Plate, 5.6Zn 2.5Mg 1.6Cu 0.23Cr Solution and Precipitation Heat Treated
- AMS 4919 Titanium Alloy Sheet, Strip and Plate, 6Al - 2Sn - 4Zr - 2Mo, annealed
- AMS 5511 Steel Sheet, Strip, and Plate, Corrosion Resistant, 19Cr - 9.5Ni (SAE 30403)

2.2 ASTM Publications:

Available from the ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

- ASTM D 792 Density and Specific Gravity (Relative Density) of Plastics by Displacement
- ASTM D 1002 Strength Properties of Adhesives in Shear by Tension Loading(Metal to Metal)
- ASTM D 2240 Rubber Property - Durometer Hardness

2.3 U.S. Government Publications:

Available from DODSSP, Subscription Services Desk, Building 4D, 700 Robbins Avenue, Philadelphia, PA 19111-5094.

MIL-A-9962	Abrasive Mats, Non-Woven, Non-Metallic
MIL-C-5541	Chemical Conversion Coating for Aluminum Alloy
MIL-C-38736	Compound, Solvent, For Use in Fuel Tanks
MIL-P-38714	Packaging and Packing of Two Component Materials in sectional containers.
MIL-S-4383	Sealing Compound, Top Coat, Fuel Tank, Buna N type
PPP-B-636	Boxes, Shipping, Fiberboard
PPP-C-96	Cans, Metal, 28 Gage and Lighter

3. TECHNICAL REQUIREMENTS:

3.1 Detail Specifications:

The requirements for a specific material shall consist of all the requirements specified herein in addition to requirements specified in the applicable detail specification. In case of conflict between requirements of this basic specification and an applicable detail specification, requirements of the detail specification shall govern.

3.2 Materials:

See applicable detail specification.

3.3 Properties:

The sealing compound shall conform to requirements specified in the applicable detail specification, determined in accordance with test methods specified in 4.5.

3.4 Quality:

Compound, as received by purchaser, shall be uniform in quality and condition, free from foreign materials and free from imperfections as commercially practicable.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The manufacturer of the sealing compound shall supply all samples and shall be responsible for all required tests. Purchaser reserves the right to sample and perform any confirmatory testing deemed necessary to ensure the sealing compound conforms to the requirements of this specification.

4.2 Classification of Test:

- 4.2.1 Acceptance Tests: Requirements specified in Table 1 are acceptance tests and shall be performed on each lot.

TABLE 1 - Acceptance Tests

Property	Requirement
Specific gravity	See detail specification
Nonvolatile content	See detail specification
Flow	See detail specification
Tack-Free time	See detail specification
Hardness	See detail specification
Peel strength	See detail specification
Shear strength	See detail specification
Application time	See detail specification
Flame resistance	See detail specification
Repairability	See detail specification

- 4.2.2 Preproduction Tests: All technical requirements are preproduction tests and shall be performed prior to or on the initial shipment of sealing compound to a purchaser. 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:

Shall be as follows:

- 4.3.1 For Acceptance Test: Sufficient compound 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 or if not specified therein, not less than three.
- 4.3.1.1 A lot shall be all sealing compound of the same class and composition manufactured as one batch and presented for manufacturers inspection at one time.
- 4.3.1.2 Materials for testing shall, be mixed in the same containers in which the products were procured, as much as is practical.
- 4.3.1.3 A statistical sampling plan acceptable to purchaser, may be used in lieu of sampling as in 4.3.1.
- 4.3.2 For Preproduction Tests: Shall be as agreed upon by purchaser and manufacturer.

4.4 Approval:

- 4.4.1 Sample compound shall be approved by purchaser before compound for production use is supplied, unless approval is waived by purchaser. Results of tests on production compound shall be essentially equivalent to those on the approved sample compound.
- 4.4.2 Manufacturer shall use ingredients, manufacturing procedures, processes, and methods of inspection on production compound essentially the same as those used on the approved sample compound. If necessary to make any change in ingredients, in type of equipment for processing, or in manufacturing procedures, manufacturer shall submit for reapproval a statement of the proposed changes in ingredients and/or processing and, when requested, sample compound. Production compound made by the revised procedure shall not be shipped prior to receipt of reapproval.

4.5 Test Methods:

Shall be in accordance with test methods shown in Table 2.

TABLE 2 - Test Methods

Property	Test Procedure
Specific Gravity	4.5.3
Nonvolatile Content	4.5.4
Flow	4.5.5
Tack-Free Time	4.5.6
Hardness, Durometer A	4.5.7
Thermal-Rupture Resistance	4.5.8
Low Temperature Flexibility	4.5.9
Peel Strength	4.5.10
Corrosion Resistance	4.5.11
Flame Resistance	4.5.12
Oil Resistance	4.5.13
Storage Stability	4.5.14
Shear Strength	4.5.15
Application Time	4.5.16
Repairability	4.5.17

- 4.5.1 Test Conditions: Standard laboratory testing conditions shall be 77 °F ± 5 (25 °C ± 2) and 50% ± 5 relative humidity. Except as otherwise specified herein, all test specimens shall be prepared, cured, and tested under these conditions.
- 4.5.2 Preparation of Test Specimens:
- 4.5.2.1 Cleaning of Test Panels:

- 4.5.2.1.1 Preparation of Aluminum Panel Test Surfaces: AMS 4045 aluminum alloy test surfaces shall be cleaned by flooding the surface with MIL-C-38736 solvent followed by scrubbing with clean AMS 3819 Grade A cloth. After scrubbing, the panel surface shall be again flooded with solvent, then immediately wiped dry using a clean, dry AMS 3819 Grade A cloth. DO NOT allow solvent to evaporate from surface.

NOTE: Panel cleaning shall be accomplished just prior to application of sealing compound.

- 4.5.2.1.2 Preparation of Corrosion Resistant Steel Panel Test Surfaces: AMS 5511 corrosion resistant steel surfaces shall be cleaned by flooding the surface with MIL-C-38736 solvent followed by scrubbing with clean MIL-A-9962, Type I, Class 1 nylon aluminum oxide abrasive mats. After scrubbing, the panel surface shall be again flooded with solvent, then immediately wiped dry using clean, dry AMS 3819 cloth. DO NOT allow solvent to evaporate from surface.

NOTE: Panel cleaning shall be accomplished just prior to application of sealing compound.

- 4.5.2.1.3 Preparation of Titanium Panel Test Surfaces: AMS 4919 titanium test surfaces shall be cleaned by flooding the surface with MIL-C-38736 solvent followed by scrubbing with clean MIL-A-9962, Type III, Class 1, Grade A nylon, silicon carbide abrasive mats. After scrubbing, the panel surface shall be again flooded with solvent, then immediately wiped dry using a clean, dry AMS 3819 cloth. DO NOT allow solvent to evaporate from surface.

NOTE: Panel cleaning shall be accomplished just prior to application of sealing compound.

- 4.5.2.2 Preparation of Sealing Compound: The quantity of sealing compound required for the test shall be hand mixed, either from a can or in a MIL-P-38714 package, as thoroughly as possible according to manufacturer's instructions.

- 4.5.2.3 Application of Sealing Compound: See applicable detail specification.

- 4.5.2.4 Cure of Sealant Compound: For preproduction testing, the sealing compound shall be cured for 14 days at standard conditions. For acceptance testing, the sealing compound shall be given an accelerated cure of 48 hours at 77 °F ± 2 (25 °C ± 1) and 50% ± 5 relative humidity plus 24 hours at 140 °F ± 2 (60 °C ± 1).

- 4.5.2.5 Primer: See applicable detail specification.

- 4.5.3 Specific Gravity: The specific gravity shall be determined in accordance with ASTM D 792. Specimens approximately 1/8 x 1 x 1 inch (3.7 x 25 x 25 mm) shall be cut with a sharp blade from a sheet of cured sealing compound. The specimen shall be weighed to the nearest milligram, dipped in methyl alcohol and, while still wet, immediately suspended in distilled water and reweighed. Specific gravity shall be calculated as shown in Equation 1:

$$\text{Specific Gravity} = \frac{\text{Weight in air}}{\text{Weight in air} - \text{Weight in water}} \quad (\text{Eq.1})$$

- 4.5.4 Nonvolatile Content: A 3 to 5 gram sample of compound shall be transferred as rapidly as possible to a cup approximately 3 inches (76 mm) in diameter and 1/8 inch (3.2 mm) deep. A fitted cover shall immediately be placed over the cup and the weight determined to the nearest milligram. The weight of the cup and cover shall be determined prior to use; this weight shall be subtracted from the initial and final weights to calculate the sample weights. The cover shall be removed and the compound allowed to cure for 48 hours. The cured sample shall be heated in an oven at $158^{\circ}\text{F} \pm 2$ ($70^{\circ}\text{C} \pm 1$) for seven days, cooled to room temperature in a desiccator, the cover replaced, and the weight determined. Total nonvolatile content shall be calculated using Equation 2:

$$\text{Nonvolatile Content, \%} = \frac{\text{Final weight}}{\text{Initial weight}} \times 100 \quad (\text{Eq.2})$$

- 4.5.5 Flow: Flow shall be determined using a flow-test jig as shown in Figure 1. Depth of plunger is critical and shall be controlled within the tolerance during the test. The flow-test jig shall be placed on a table with the front face upward and plunger depressed to the limit of its travel. Compound shall be extruded into the recess cavity of the jig and leveled off even with the block. Within 10 seconds after the leveling operation, the jig shall be placed on its end and the plunger immediately advanced to the limit of its forward travel. The flow measurement shall be taken exactly 30 minutes after the compound was applied to the jig. Flow shall be measured from the lower edge of the plunger to the farthest point the flow has advanced.
- 4.5.6 Tack-Free Time: An AMS 4045 aluminum alloy panel, 0.040 x 2-3/4 x 6 inches (1 x 69.8 x 152 mm) shall be cleaned in accordance with 4.5.2.1 and covered with sealing compound to a depth of 1/8 inch $\pm$ 1/16 (3.2 mm $\pm$ 1.6). The compound shall be allowed to cure at standard conditions (4.5.1) for 24 hours. After curing, two 1 -inch (25 mm) pieces of polyethylene film, 0.004 inch $\pm$ 0.002 (0.1 mm $\pm$ 0.5) thick, shall be applied to the compound and held in place under a pressure of 1/2 ounce per square inch. (0.2 N/mm²) for 2 minutes. The strips shall be withdrawn slowly and evenly at right angles to the compound surface. The film shall come away clean and free of compound.
- 4.5.7 Hardness: Hardness shall be determined in accordance with ASTM D 2240. Specimens shall be prepared by applying a 0.25 $\pm$ 0.03 inch (6.35 $\pm$ 0.76 mm) layer of sealant to a 2.75 x 6 x 0.40 inch (70 X 152 X 1 mm) aluminum panel. After the sealant has cured at standard conditions (4.5.1) for the time specified in the detail specification, durometer hardness shall be determined.
- 4.5.8 Thermal-Rupture Resistance: All test panels shall be cleaned in accordance with 4.5.2.1. Panels of AMS 4045 aluminum alloy panels 0.040 inch (1 mm) thick x 3-1/2 inches (89 mm) square with a 1/4 inch (6.35 mm) diameter hole in the center shall have a layer of compound 0.125 inch (3 mm) thick x 2 inches (51 mm) in diameter applied and the compound cured as in 4.5.1. After curing each panel in turn shall be placed in the test fixture, Figure 2, with the compound on the interior (pressure) side of the fixture chamber. The fixtures, with the panels, shall be heated to 401 $^{\circ}\text{F} \pm 2$ (205 $^{\circ}\text{C} \pm 5$) in an air oven and pressure of 5 psi $\pm$ 0.5 (35 kPa $\pm$ 4) applied for 15 minutes $\pm$ 1. Fixtures shall be removed from the oven, cooled to room temperature, and the deformation measured.

- 4.5.9 Low-Temperature Flexibility: All test panels shall be cleaned in accordance with 4.5.2.1. Two AMS 4045 aluminum alloy panels, 0.040 x 2-3/4 x 6 inches (1 x 69.8 x 152 mm) shall have applied to the center of each panel a 0.125 inches $\pm$ 1/64 (3.2 mm $\pm$ 0.4mm) layer of compound 1-1/2 inches (37.5 mm) wide x 4 inches (102 mm) long. Care shall be taken to ensure accuracy of compound thickness. Compound shall be cured as in 4.5.1 and the panels immediately mounted in a low temperature flexibility jig as in Figure 3 and the panels gripped on both sides of both 6 inches (152 mm) edges for a distance of 3 inches (76 mm) from one end. The jig with the mounted panels shall be stabilized at -67 °F $\pm$ 2 (-55 °C $\pm$ 1) for 2 hours $\pm$ 0.1 and the panels flexed through a 30 degree arc (15 degrees either side of the neutral position at a rate of 12 cycles per minute for 130 cycles. Each panel shall be examined for evidence of cracking or loss of adhesion.
- 4.5.10 Peel Strength: All test panels shall be cleaned in accordance with 4.5.2.1. Four Panels each of AMS 4045 aluminum alloy, AMS 4919 titanium alloy, and AMS 5511 corrosion resistant steel, 0.040 x 2-3/4 x 6 inches (1 x 69.8 x 152 mm), primed if required by sealant manufacturer, shall be coated with a layer of sealing compound 1/8 inches $\pm$ 1/64 (3.2 mm $\pm$ 0.4) thick. A 2-3/4 x 12 inches (69.8 x 305 mm) strip of 20 to 40 mesh aluminum, nickel copper alloy or stainless steel wire screen shall be primed and impregnated with a sealing compound so approximately 5 inches (127 mm) at one end is covered on both faces and well worked into the screen. The compound impregnated end of the screen shall be placed on the coated panel and smoothed down on the compound layer, taking care not to trap air beneath the screen. An additional 1/32 inches (0.8 mm) thick coating of compound shall be applied over the screen strips and the assemblies cured as in 4.5.1. Two specimens of each panel material shall be aged at 401 °F $\pm$ 5 (205 °C $\pm$ 3) for 72 hours $\pm$ 1. A 1 inch (25 mm) wide section shall be cut from the center of the width of each assembly. The screen shall be stripped back at an angle of 180 degrees to the panel in a suitable tensile machine having a jaw separation rate of 2 inches (51 mm) per minute. Peel strength shall be the numerical average of the peak loads.
- 4.5.11 Corrosion Resistance: All test panels shall be cleaned in accordance with 4.5.2.1. One panel each of AMS 4045 aluminum alloy and AMS 5511 corrosion resistant steel, 0.040 x 2-3/4 x 6 inches (1 x 69.8 x 152 mm) shall have two strips of sealing compound applied 3/16 inch (4.6 mm) thick x 3/4 inch (19 mm) wide x 5 inches (127 mm) long extending to within 1/2 inch (13 mm) of the edges of the panels and spaced approximately 1 inch (25 mm) apart. The coated panels shall be cured as in 4.5.1 except 48 to 72 hours before the end of the curing period, the panels shall be dipped in MIL-S-4383 sealing compound topcoat and the cure allowed to continue. At the end of the curing period, the compound strips shall be trimmed to 1/16 inch (1.6 mm) thick and the panels immersed vertically in 3% sodium chloride solution in distilled water in a covered glass vessel so that one half the panel length is immersed in liquid and the other half exposed to air/vapor mixture. Panels shall be exposed at 140 °F $\pm$ 2 (60 °C $\pm$ 1) for 20 days. Immediately after removal from the liquid, examine the panels for conformance.

- 4.5.12 Flame Resistance: All test panels shall be cleaned in accordance with 4.5.2.1. Four panels of AMS 5511 corrosion resistant steel, 0.040 x 2-7/8 x 6 inches (1 x 73 x 152 mm), having a 1/4 inch (6.25 mm) diameter hole at the center shall be coated with a 1/8 inch (3.2 mm) thick layer of compound and cured as in 4.5.1. Two of the panels shall be immersed vertically in AMS 3021 fluid at 140 °F $\pm$ 2 (60 °C $\pm$ 1) for 72 hours $\pm$ 1. Panels shall be subjected to Bunsen burner flame of 2003 °F $\pm$ 94 (1095 °C $\pm$ 55) for 15 minutes $\pm$ 1. The flame shall be directed at the center of the coated face at a 45 degree angle, see Figure 4.
- 4.5.13 Oil Resistance: All test panels shall be cleaned in accordance with 4.5.2.1. Two AMS 4045 aluminum alloy panels, .040 x 2-3/4 x 6 inches (1 x 69.8 x 152 mm), having two parallel strips of sealing compound applied, each strip being 3/16 inch (4.76 mm) thick x 3/4 inch (19 mm) wide x 5 inches (127 mm) long extending to within 1/2 inch (13 mm) of the edge of the panel. Compound on the panel shall be cured as in 4.5.1 and the panels immersed vertically in AMS 3021 fluid at 140 °F $\pm$ 2 (60 °C $\pm$ 1) for 72 hours $\pm$ 1.
- 4.5.14 Storage Stability: After storage for 6 months at not higher than 40 °F (4 °C), compound shall meet the requirements of flow, tack free time and hardness in accordance with applicable detail specification.
- 4.5.15 Shear Strength: Twenty-four of each of the following panels shall be prepared:
- 0.050 x 1 x 3 inches (1.27 x 25 x 76 mm), corrosion resistant steel alloy conforming to AMS 5511 surface finish 2D
- 0.050 x 1 x 3 inches (1.27 x 25 x 76 mm), titanium alloy conforming to AMS 4919
- 0.050 x 1 x 3 inches (1.27 x 25 x 76 mm), aluminum alloy conforming to AMS 4045 treated in accordance with MIL-C-5541.
- All panels shall be cleaned in accordance with 4.5.2.1, and arranged in pairs to fabricate lap shear specimens. Mixed sealant shall be applied to a one square inch area at one end of each panel. The panels shall then be assembled and contact pressure applied and maintained on the bonded areas. Sufficient sealant shall be applied to produce a continuous bond film thickness of 0.011 $\pm$ 0.004 inch (0.28 $\pm$ 0.1 mm). After the assembled parts have received the standard cure (4.5.2.4), excess sealant shall be trimmed from the panels. Three of each type of specimen shall be exposed to one of the following conditions for seven days:
1. Dry heat 401 °F $\pm$ 5 (205 °C $\pm$ 2)
 2. Condensing humidity at 120 °F $\pm$ 2 (49 °C $\pm$ 2)
 3. Aviation Hydraulic Test Fluid at 75 °F $\pm$ 2 (24 °C $\pm$ 2)
 4. Control (No conditioning) Kept at 75 °F $\pm$ 5 (24 °C $\pm$ 2)

4.5.15 (Continued):

At the completion of the conditioning period, the specimens shall be allowed to cool to room temperature prior to removal from test fluids. The shear test shall be done within 30 minutes after removal from the conditioning fluids. Determine Shear Strength of the sealant by pulling in shear at a speed of 2 inches (51 mm) per minute. Record the maximum pull (load) in pounds required to separate the strips and the percentage of cohesive failure. Calculate the average shear strength for each set of three identical specimens.

4.5.16 Application Time: The base compound and accelerator shall be stabilized at standard conditions (4.5.1) for not less than eight hours before a sample of base compound is mixed with the proper amount of accelerator sufficient to fill a standard sealing compound gun cartridge having a 440 nozzle with an orifice of $0.125 \text{ inch} \pm 0.005$ ($3.18 \text{ mm} \pm 0.13$). The gun and sealing compound shall be maintained at standard conditions throughout the test. The gun shall be attached to a constant air supply of $90 \text{ psig} \pm 5$ ($620 \text{ kPa} \pm 34$). From 2 to 3 inches (51 to 76 mm) of sealing compound shall be extruded initially to clear trapped air. At the end of 4 hours, measured from the beginning of the mixing period, the sealing compound shall be extruded onto a suitable receptacle for one minute and the weight of extruded sealing compound determined.

4.5.17 Repairability: Two panels, stainless steel MIL-S-5059, $0.02 \times 3 \times 6$ inches ($0.5 \times 76 \times 152 \text{ mm}$) of shall be prepared for the material to be tested. An additional two panels shall be prepared for each material already qualified to this specification. After the panels are cleaned and primed, if required, a fillet of the test sealant approximately 0.19 inch (4.7 mm) thick, 0.05 inch (1.25 mm) wide and 5.0 inches (127 mm) long shall be applied to the approximate center of one side of each of the two panels. The same size of fillet shall also be applied to two of the test panels for each material already qualified to this specification. After standard cure of specimens, check to be certain the fillet adheres to the primed surface. If adhesion is satisfactory, remove a section approximately 1.5 inches (37 mm) long and 0.1 inch (2.5 mm) thick of the cured sealant from each end of the fillet. See Figure 3. Apply the same fresh sealant to one end of the fillet and on the other end apply sealant to be tested on previously qualified sealant. Subject all specimens to the standard cure and check sealant adhesion to itself and to the other qualified sealants.

4.6 Reports:

The manufacturer of the sealing compound shall furnish with each shipment a report showing the results of test to determine conformance to the acceptance test requirements and stating the product conforms to the other technical requirements. This report shall include the purchase order number, lot number, AMS 3374 and the applicable detail specification number and revision letters if any, manufacturer's identification, date of manufacture, and quantity.

4.6.1 A material safety data sheet conforming to AMS 2825 shall be supplied to each purchaser prior to, or concurrent with, the report of preproduction test results or, if preproduction testing be waived by purchaser, concurrent with the first shipment of sealing compound for production use. Each request for modification of sealing compound formulation shall be accompanied by a revised data sheet for the proposed formulation.

4.7 Resampling and Retesting:

If any specimen used in the above test fails to meet the specified requirements, disposition of the compound may be based on the results of testing three additional specimens for each original nonconforming specimen. Failure of a retest specimen to meet the specified requirements shall be cause for rejection of the compound represented. Results of all tests shall be reported.

5. PREPARATION FOR DELIVERY:

5.1 Packaging:

See applicable detail specification.

5.2 Identification:

See applicable detail specification.

6. ACKNOWLEDGEMENT:

A manufacturer shall mention this specification number and the applicable detail specification number and their revision letters, if any, in all quotations and when acknowledging purchasing orders.

7. REJECTIONS:

Sealing compound not conforming to this specification and the applicable detail specification, or to modifications authorized by purchaser, will be subject to rejection.

8. NOTES:

8.1 The (R) symbol is for the convenience of the user in locating areas where technical revisions, not editorial changes, have been made to the previous issue of this specification. If the symbol is next to a specification title, it indicates a complete revision of the specification.

8.2 Dimensions and properties in inches/pounds units and the Celsius temperatures are primary; dimensions and properties in SI units and the Fahrenheit temperatures are shown as the approximate equivalents of the primary units and are presented only for information.

8.3 Purchase documents should specify not less than the following:

Title, number, and date of applicable detail specification
Type and size of containers (kit) desired
Quantity of containers (kits) desired
Special packaging, if required.

- 8.4 Sealing compounds meeting the requirements of this specification has been classified under Federal Supply Classification (FSC) 8040.

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