

AEROSPACE

MATERIAL SPECIFICATIONS

AMS 3304D

SOCIETY OF AUTOMOTIVE ENGINEERS, Inc.

485 Lexington Ave., New York, N. Y. 10017

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SILICONE RUBBER

General Purpose

65 - 75

1. **ACKNOWLEDGMENT:** A vendor shall mention this specification number and its revision letter 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 -55 to +205 C (-67 to +401 F). Silicone elastomer is resistant to deterioration by weathering and 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.
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 an extrusion of such shape that suitable test specimens cannot be cut from the product, a separate flat strip 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 then cured in the same manner as production material.
 - 4.2.1 **As Received:**

4.2.1.1 Hardness, Durometer "A" or equiv.	70 $\pm$ 5	ASTM D676
4.2.1.2 Tensile Strength, psi, min	500	ASTM D412, Die B or C
4.2.1.3 Elongation, %, min	60	ASTM D412, Die B or C
4.2.1.4 Tear Resistance, lb per in., min	25	ASTM D624, Die B
4.2.1.5 Specific Gravity	To be reported	ASTM D297
 - 4.2.2 **Lubricating Oil Resistance:**

(Immediate Deteriorated Properties)	ASTM D471
	Medium: ASTM Oil No. 1
	Temperature: 175 C $\pm$ 3
	(347 F $\pm$ 5.4)
4.2.2.1 Hardness Change, Durometer "A" or equiv.	-15 to +5
	Time: 70 hr

4.2.2.2	Tensile Strength Change, %, max (based on area before immersion)	-30	
4.2.2.3	Elongation Change, %, max	-25	
4.2.2.4	Volume Change, %	0 to +10	
4.2.2.5	Decomposition	None	
4.2.2.6	Surface Tackiness	None	
Ø 4.2.3	<u>Dry Heat Resistance:</u>		ASTM D573
4.2.3.1	Hardness Change, Durometer "A" or equiv.	-5 to +10	Temperature: 225 C ± 3 (437 F ± 5.4)
4.2.3.2	Tensile Strength Change, %, max	-10	Time: 24 hr
Ø 4.2.3.3	Elongation Change, %, max	-20	
4.2.3.4	Bend (flat)	No cracking or checking	
Ø 4.2.4	<u>Compression Set:</u>		ASTM D395, Method B
4.2.4.1	Per cent of original deflection, max	30	Temperature: 175 C ± 3 (347 F ± 5.4)
4.2.4.2	Per cent of original thickness, max	8	Time: 22 hr
4.2.5	<u>Low Temperature Resistance:</u>		
4.2.5.1	Brittleness	Pass	ASTM D746, Procedure B
Ø			Temperature: -65 C ± 3 (-85 F ± 5.4)
			Time: 10 min.
4.2.5.2	Young's Modulus, psi, max	10,000	ASTM D797
Ø	(See Note 1)		Temperature: -50 C ± 1 (-58 F ± 1.8)
			Time: 5 hr

Note 1. This test is not normally required but is intended to be used as a referee test in case of disagreement on the results of the brittleness test.

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	<u>Sheet:</u>	Nominal Thickness Inches	Tolerance, Inch 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 (not both), Inches	Tolerance Plus and Minus	Ovality, % (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 of the minor and major axis diameter measurements, taken at the same transverse plane on the tube, expressed as a percentage of the nominal diameter.

6.2.2	Nominal Wall Thickness Inches	Tolerance 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 stating that the product conforms to the requirements of this specification. This report shall include the purchase order number, material specification number, vendor's compound number, value to be reported, 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.
- Ø 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 To assure adequate performance characteristics, compounds 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.
- 10.2 Vendor shall use the same compound and manufacturing processes for production material as for approved sample material. If necessary to make any change in mold, compound, or processing which could unfavorably affect any characteristics of the material, vendor shall obtain written permission from purchaser prior to incorporating such change.
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