

AEROSPACE MATERIAL SPECIFICATION

SAE

AMS 3267/1A

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Superseding AMS 3267/1

Submitted for recognition as an American National Standard

SEALING COMPOUND, LOW ADHESION, CORROSION INHIBITING
200 to 600 Poises (20 to 60 Pa·s), 1/2 Hour Application Time (A-1/2)

1. SCOPE:

1.1 Form:

This specification covers accelerated curing synthetic rubber compounds with corrosion inhibitors and low adhesive strength supplied as a two-component system.

1.2 Application:

This product has been used typically for sealing aircraft access doors and accessories where gaskets are required, but usage is not limited to such applications. Compound is classified as an A-1/2 sealing compound; the compound being suitable for brush application with a minimum application time of 1/2 hours after the start of mixing.

2. APPLICABLE DOCUMENTS:

See AMS 3267.

3. TECHNICAL REQUIREMENTS:

3.1 Basic Specification:

The complete requirements for procuring the sealing compound described herein shall consist of this document and the latest issue of the basic specification, AMS 3267.

3.2 Properties:

Compound, mixed in accordance with manufacturer's instructions and cured as specified in the basic specification, shall conform to the following requirements, determined in accordance with test methods listed in AMS 3267 and Table 1.

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TABLE 1 - Properties

Paragraph	Property	Requirement
3.2.1	Color	
3.2.1.1	Base Compound	Reddish
3.2.1.2	After Curing	Reddish
3.2.2	Specific Gravity, maximum	1.65
3.2.3	Nonvolatile Content, minimum	84% by weight
3.2.4	Viscosity of Base Compound (See 4.2)	200 to 600 poises (20 to 60 Pa's)
3.2.5	Flow	No requirement
3.2.6	Application Time (See 4.3)	1/2 hour after the beginning of mixing, the viscosity shall be 2500 poises (250 Pa·s) maximum
3.2.7	Tack-Free Time, maximum	10 hours, measured from the beginning of mixing
3.2.8	Hardness (cure time to attain 30 Durometer "A"), minimum	24 hours
3.2.9	Peel Adhesion	4 pounds force per inch (700 N/m of width, maximum; 98% adhesive failure, minimum)
3.2.10	Resistance to Heat	No visual evidence of softening, sponging, blistering, checking, cracking, shrinkage, or powdering
3.2.11	Resistance to Salt Water and Hydrocarbons	No visual evidence of softening, blistering, or evidence of corrosion
3.2.12	Weight Loss, maximum and Flexibility	8% weight loss No cracking when bent
3.2.13	Low-Temperature Flexibility	No visual evidence of cracking or checking
3.2.14	Accelerated Storage Stability	
3.2.14.1	Application Time, minimum	1/2 hour, measured from the beginning of mixing
3.2.14.2	Tack-Free Time, maximum	10 hours, measured from the beginning of mixing