SAE Aerospace
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AMS 3217/7

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AEROSPACE MATERIAL SPECIFICATION

TEST SLABS, HIGH STRENGTH, FLUOROSILICONE (FVMQ) 55 - 65

RATIONALE

This document has been reaffirmed to comply with the SAE 5-year Review policy.

1. SCOPE:

1.1 Form:

This specification covers a high strength fluorosilicone (FVMQ) rubber stock in the form of molded test slabs.

1.2 Application:

See AMS 3217.

2. APPLICABLE DOCUMENTS:

See AMS 3217.

3. TECHNICAL REQUIREMENTS:

3.1 Basic Specifications:

The complete requirements for test slabs described herein and their procurement shall consist of this document and the latest issue of the basic specification AMS 3217.

3.2 Material:

Shall be a fluorosilicone (FVMQ) compounded to the formulation shown in Table 1.

TO PLACE A DOCUMENT ORDER: **Tel: 877-606-7323 (inside USA and Canada)**
Tel: 724-776-4970 (outside USA)
Fax: 724-776-0790
Email: custsvc@sae.org
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TABLE 1 - Formulation

Ingredients	Parts
Silastic® LS 2860 or equivalent[1]	100.0 (See 3.2.1)
Silastic® HT-1 or equivalent[1]	1.0 (See 3.2.2)
Varox® DPH-50 or equivalent[1]	1.0 (See 3.2.2)
Press Cure: 10 minutes ± 0.5 at 171 °C ± 3 (340 °F ± 5)	
Oven Cure: 4 hours ± 0.2 at 200 °C ± 3 (392 °F ± 5)	

[1] Equivalent ingredients must be approved by Wright Laboratory (WL/MLSE), WPAFB, OH 45433-6533.

3.2.1 Weigh parts to the nearest 0.1 gram.

3.2.2 Weigh parts to the nearest 0.02 gram.

3.3 Processing:

After the elastomer has banded on the rubber mill, the other ingredients shall be added in the order listed in 3.2.

3.3.1 The stock shall not be allowed to become hotter than can be handled with the bare hands; it is recommended that the stock be removed from the mill and cooled to room temperature before incorporating the final ingredient.

3.3.2 After all ingredients have been incorporated and the stock has been thoroughly milled, the stock shall be passed through the mill 10 times, crossblending after each pass.

3.3.3 Suitable preforms shall be cut from the freshly milled stock and molded into test slabs as specified in ASTM D 3182, Figure 1.