



# AEROSPACE MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.  
400 COMMONWEALTH DRIVE, WARRENDALE, PA. 15096

**AMS 3244B**  
Superseding AMS 3244A

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## CHLOROPRENE RUBBER Flame-Resistant 65 - 75

### 1. SCOPE:

- 1.1 Form: This specification covers a chloroprene rubber in the form of sheet, strip, tubing, molded shapes, and extrusions.
- 1.2 Application: Primarily for parts, such as grommets, seals, and line supports, on the firewall of aircraft or wherever flame resistance is of prime importance.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications (AMS) shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

- 2.1 SAE Publications: Available from Society of Automotive Engineers, Inc., 400 Commonwealth Drive, Warrendale, PA 15096.

#### 2.1.1 Aerospace Material Specifications:

AMS 2350 - Standards and Test Methods  
AMS 2810 - Identification and Packaging, Elastomeric Products

- 2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM D297 - Chemical Analysis of Rubber Products  
ASTM D395 - Compression Set of Vulcanized Rubber  
ASTM D412 - Tension Testing of Vulcanized Rubber  
ASTM D471 - Change in Properties of Elastomeric Vulcanizates Resulting from Immersion in Liquids  
ASTM D573 - Accelerated Aging of Vulcanized Rubber by the Oven Method  
ASTM D624 - Tear Resistance of Vulcanized Rubber  
ASTM D635 - Flammability of Self-Supporting Plastics  
ASTM D2137 - Low-Temperature Impact Test for Brittleness  
Determination of Flexible Polymeric Materials or Fabrics Coated Therewith, or Both  
ASTM D2240 - Indentation Hardness of Rubber and Plastics by Means of a Durometer

- 2.3 Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

#### 2.3.1 Military Standards:

MIL-STD-794 - Parts and Equipment, Procedures for Packaging and Packing of

### 3. TECHNICAL REQUIREMENTS:

- 3.1 Material: Shall be a compound based on a chloroprene elastomer, suitably cured to produce a product meeting the requirements of 3.2.

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3.2 Properties: The product shall conform to the following requirements; tests shall be performed on the product supplied and in accordance with specified ASTM methods, insofar as practicable:

3.2.1 As Received:

3.2.1.1 Hardness, Durometer ASTM D2240  
 $\phi$  "A" or equiv.  $70 \pm 5$

3.2.1.2 Tensile Strength, min ASTM D412, Die B or C  
1000 psi  
(6.9 MPa)

3.2.1.3 Elongation, min ASTM D412, Die B or C  
200%

3.2.1.4 Tear Resistance, min ASTM D624, Die B  
70 lb per in.  
(12.3 kN/m)

3.2.1.5 Specific Gravity ASTM D297  
 $\phi$  Qualification  
Value  $\pm 0.02$

3.2.2 Petroleum Hydraulic Oil Resistance:  
 (Immediate Deteriorated Properties)

ASTM D471  
 Medium: ASTM Oil No. 3  
 Temperature:  $100^{\circ}\text{C} \pm 1$   
( $212^{\circ}\text{F} \pm 1.8$ )  
 Time:  $22 \text{ hr} \pm 0.5$

3.2.2.1 Tensile Strength Change, max -60%

3.2.2.2 Elongation Change, max -60%

3.2.2.3 Volume Change +30 to +90%

3.2.2.4 Decomposition None

3.2.2.5 Surface Tackiness None

3.2.3 Aromatic Fuel Resistance:  
 (Immediate Deteriorated Properties)

ASTM D471  
 Medium: ASTM Ref. Fuel B  
 Temperature  $20^{\circ} - 30^{\circ}\text{C}$   
( $68^{\circ} - 86^{\circ}\text{F}$ )  
 Time:  $22 \text{ hr} \pm 0.5$

3.2.3.1 Tensile Strength Change, max -75%

3.2.3.2 Elongation Change, max -50%

3.2.3.3 Volume Change 0 to +80%

3.2.3.4 Decomposition None

3.2.3.5 Surface Tackiness None

3.2.4 Dry Heat Resistance:

ASTM D573  
 Temperature:  $125^{\circ}\text{C} \pm 2$   
( $257^{\circ}\text{F} \pm 3.6$ )  
 Time:  $70 \text{ hr} \pm 0.5$

3.2.4.1 Hardness Change, Durometer ASTM D2240  
 "A" or equiv.  $0 \text{ to } +20$

3.2.4.2 Tensile Strength Change, max -30%

3.2.4.3 Elongation Change, max -50%

3.2.4.4 Bend (flat) No cracking or checking

3.2.5 Compression Set: ASTM D395, Method B  
 Temperature: 100°C ± 1  
 (212°F ± 1.8)  
 3.2.5.1 Percent of Original Deflection, max 50 Time: 70 hr ± 0.5

∅ 3.2.6 Low Temperature Resistance: ASTM D2137, Method A  
 Temperature: -35°C ± 1  
 (-31°F ± 1.8)  
 3.2.6.1 Brittleness Pass

3.2.7 Flame Resistance:  
 Flameout time, max 10 sec 4.5.1

3.2.8 Weathering: When specified, the product shall have weather resistance acceptable to the purchaser, determined by a procedure agreed upon by purchaser and vendor.

3.2.9 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.

3.3 Quality: The product shall be uniform in quality and condition, clean, smooth, as free from foreign material as commercially practicable, and free from imperfections detrimental to fabrication, appearance, or performance of parts.

3.4 Tolerances: Unless otherwise specified, the following tolerances shall apply:

3.4.1 Sheet and Strip:

TABLE I

Nominal Thickness Inches	Tolerance, Inch plus and minus
Up to 0.125, incl	0.016
Over 0.125 to 0.500, incl	0.031
Over 0.500	0.047

TABLE I (SI)

Nominal Thickness Millimetres	Tolerance, Millimetres plus and minus
Up to 3.18, incl	0.41
Over 3.18 to 12.70, incl	0.79
Over 12.70	1.19

3.4.2 Tubing:

3.4.2.1 Diameter:

TABLE II

Nominal OD or ID (Not both), Inches	Tolerance plus and minus	Ovality, % (See 3.4.2.1.1)
Up to 0.500, incl	0.020 in.	10
Over 0.500 to 1.000, incl	0.030 in.	15
Over 1.000	4%	15

TABLE II (SI)

Nominal OD or ID (not both), Millimetres	Tolerance plus and minus	Ovality, % (See 3.4.2.1.1)
Up to 12.70, incl	0.51 mm	10
Over 12.70 to 25.40, incl	0.76 mm	15
Over 25.40	4%	15

3.4.2.1.1 Ovality applies to tubing ordered in straight length with wall thickness of 0.063 in. (1.60 mm) and over, and shall be computed from the difference between the minor and major axis diameter measurements, taken at the same transverse plane on the tube, expressed as a percentage of the nominal diameter.

3.4.2.2 Wall Thickness:

TABLE III

Nominal Wall Thickness Inches	Tolerance plus and minus
Up to 0.063, excl 0.063, and over	0.005 in. 10%

TABLE III (SI)

Nominal Wall Thickness Millimetres	Tolerance plus and minus
Up to 1.60, excl 1.60 and over	0.13 mm 10%

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of the product shall supply all samples and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.6. Purchaser reserves the right to perform such confirmatory testing as he deems necessary to ensure that the product conforms to the requirements of this specification.

∅ 4.2 Classification of Tests: