

Cloth, Glass
Aluminum Face, Silicone Rubber Back

RATIONALE

This document is being revised and updated as a result of the 5 year review.

1. SCOPE

1.1 Form

This specification covers one type of glass cloth coated on one face with aluminum and the other face with silicone rubber.

1.2 Application

Primarily for use as a thermal curtain for protection of personnel and equipment from short-time exposure to high intensity thermal radiation.

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 which may be 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.

2. APPLICABLE DOCUMENTS

The issue of the following documents in effect on the date of the purchase order forms a part of this specification to the extent specified herein. The supplier may work to a subsequent revision of a document unless a specific document issue is specified. When the referenced document has been cancelled and no superseding document has been specified, the last published issue of that document shall apply.

SAE Technical Standards Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be reaffirmed, revised, or cancelled. SAE invites your written comments and suggestions.

Copyright © 2011 SAE International

All rights reserved. No part of this publication may be reproduced, stored in a retrieval system or transmitted, in any form or by any means, electronic, mechanical, photocopying, recording, or otherwise, without the prior written permission of SAE.

TO PLACE A DOCUMENT ORDER: Tel: 877-606-7323 (inside USA and Canada)
Tel: +1 724-776-4970 (outside USA)
Fax: 724-776-0790
Email: CustomerService@sae.org
http://www.sae.org

SAE WEB ADDRESS:

**SAE values your input. To provide feedback
on this Technical Report, please visit
<http://www.sae.org/technical/standards/AMS3673C>**

2.1 U.S. Government Publications

Available from the Document Automation and Production Service (DAPS), Building 4/D, 700 Robbins Avenue, Philadelphia, PA 19111-5094, Tel: 215-697-6257, <http://assist.daps.dla.mil/quicksearch/>.

FED-STD-4 Glossary of Fabric Imperfections

FED-STD-191 Textile Test Methods

MIL-STD-1487 Glossary of Cloth Coating Imperfections

2.2 ASQ Documents

Available from American Society for Quality, Quality Press, 600 North Plankinton Avenue, Milwaukee, WI 53203, Tel: 800-248-1946, <http://qualitypress.asq.org>.

ANSI/ASQ Z1.4 Sampling Procedures and Tables for Inspection by Attributes

3. TECHNICAL REQUIREMENTS

3.1 Materials

3.1.1 Base Cloth

The warp and filling yarns used in the manufacture of the base cloth shall be 100% continuous filament glass yarns.

3.1.2 Coated Cloth

The cloth shall consist of a base fabric of glass yarn which has been evenly and uniformly coated on one surface with a suitably-compounded silicone rubber. On the opposite surface shall be a highly-reflective layer of vacuum distilled aluminum directly adhered to the warp face by means of a curable, highly-flexible, solvent resistant adhesive bonding composition.

3.2 Properties

Cloth shall conform to the following requirements, determined in accordance with specified test methods of FED-STD-191 except as otherwise specified herein:

3.2.1 Base Cloth

Shall be as follows:

TABLE 1

Paragraph	Property	Requirement	Test Method
3.2.1.1	Construction, ends and picks per inch (25.4 mm)	64 x 60	5050
3.2.1.2	Thickness, maximum	0.008 inch (0.20 mm)	5030
3.2.1.3	Weight, maximum	6.70 ounces/square yard (227.2 g/m ²)	5041
3.2.1.4	Breaking Strength, minimum Warp Filling	130 pounds force/inch (22 766 N/m) 90 pounds force/inch (15 761 N/m)	5102
3.2.1.5	Weave	Crowfoot Satin	Visual

3.2.2 Coated Cloth

Shall be as follows:

TABLE 2

Paragraph	Property	Requirement	Test Method
3.2.2.1	Weight	16 ounces/square yard $\pm$ 2 (542 g/m ² $\pm$ 68)	5041
3.2.2.2	Thickness	0.0150 inch $\pm$ 0.0015 (0.381 mm $\pm$ 0.038)	5030
3.2.2.3	Width	As Ordered	5020
3.2.2.4	Breaking Strength (Cut Strip), minimum Warp Filling	150 pounds force/inch (26 269 N/m) 150 pounds force/inch (26 269 N/m)	5102
3.2.2.5	Tear Strength, minimum Warp Filling	3.0 pounds force (13.3 N) 3.0 pounds force (13.3 N)	5134
3.2.2.6	Cold Crack Rubber Coating Warp and Filling Aluminum Coating Warp and Filling	No Cracking No Cracking	4.5.1
3.2.2.7	Coating Adhesion, minimum	4.0 pounds force/inch (701 N/m)	5970
3.2.2.7.1	Adhesive shall be cured in accordance with FED-STD-191, Method 5970, except that the cure cycle shall be 48 hours $\pm$ 1 at 77 °F $\pm$ 5 (25 °C $\pm$ 3)		

Paragraph	Property	Requirement	Test Method
3.2.2.8	Resistance to Blocking Cloth heated for 2 hours $\pm$ 0.1 Aluminum to Rubber Aluminum to Aluminum Rubber to Rubber	No Blocking No Blocking No Blocking	5872
3.2.2.9	Stiffness, maximum Warp Filling	0.015 inch-pound (0.0017 Nm) 0.015 inch-pound (0.0017 Nm)	5202
3.2.2.10	Thermal Radiation Resistance Thermal Response, maximum First Exposure First Exposure Second Exposure Third Exposure	 2.0 °F x ft ² per BTU (0.84 °C x m ² /k cal) 2.1 °F x ft ² per BTU (0.88 °C x m ² /k cal) 2.1 °F x ft ² per BTU (0.88 °C x m ² /k cal)	4.5.2
3.2.2.11	Abrasion Resistance Thermal Response after Abrasion, maximum First Exposure Second Exposure Third Exposure	 3.0 °F x ft ² per BTU (1.26 °C x m ² /k cal) 3.1 °F x ft ² per BTU (1.30 °C x m ² /k cal) 3.1 °F x ft ² per BTU (1.30 °C x m ² /k cal)	4.5.3
3.2.2.12	Flame Resistance, maximum Flame Time Glow Time	10 seconds 2 seconds	5903
3.2.2.13	Visible Damage	No burning, blistering, or delamination	Visual

3.3 Quality

The cloth, as received by purchaser, shall be evenly woven, and free from foreign materials and from imperfections detrimental to usage of the cloth.

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

The vendor of cloth shall supply all samples for vendor's tests and shall be responsible for performing all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the cloth conforms to the requirements of this specification.

4.2 Classification of Tests

4.2.1 Acceptance Tests

Tests for the following requirements are acceptance tests and shall be performed on each lot:

4.2.1.1 Weight (3.2.1.3), breaking strength (3.2.1.4), and weave (3.2.1.5) of the base cloth.

4.2.1.2 Weight (3.2.2.1), breaking strength (3.2.2.4), tear strength (3.2.2.5), cold crack (3.2.2.6), thermal radiation resistance (3.2.2.10), flame resistance (3.2.2.12), and quality (3.3) of the coated cloth.

4.2.2 Preproduction Tests

Tests for all technical requirements are preproduction tests and shall be performed prior to or on the initial shipment of cloth to a purchaser, when 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 Tests

Except as specified in 4.3.1.6, sufficient cloth shall be taken 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 cloth produced in a single production run under the same fixed conditions and presented for vendor's inspection at one time.

4.3.1.2 The sample unit for the base cloth shall be 2.5 yards (2.3 m) full width. The sample size (number of units) shall be as shown below. The lot size shall be expressed in units of 1 linear yard (1 linear m). The lot shall be unacceptable if one or more sample units fail to meet any specified requirements.

TABLE 3

Lot Size Yards	Lot Size Meters	Sample Size
Up to 800, incl	Up to 732, incl	2
Over 800 to 2000, incl	Over 732 to 1829, incl	3
Over 2000	Over 1829	5

4.3.1.3 Yard-by-Yard (Meter-by-Meter) Examination

4.3.1.3.1 Base Cloth

The sample unit for the base cloth shall be 0.25 yard (0.2 m) full width. A sample shall be taken from each lot. A lot of cloth shall consist of 2000 yards (1829 m), or fraction thereof. The lot shall be unacceptable if the sample fails to meet any requirement specified. The sample shall be examined on the face side only for all imperfections as defined in FED-STD-4, Section I. All imperfections which are noticeable at the normal inspection distance of 3 feet (1 m) shall be scored and assigned demerit points as specified in 4.3.1.3.2. The lot shall be unacceptable if the demerit points per 100 square yards (84 m²) of the total examined exceed 20. Point computation for lot quality shall be as follows:

4.3.1.3.1.1 In inch/pound units:

$$\frac{\text{Total points scored in sample} \times 3600}{\text{Width of cloth, inch,} \times \text{total length inspected, yard}} = \frac{\text{Points per}}{100 \text{ square yards}} \quad (\text{Eq. 1})$$

4.3.1.3.1.2 In SI units:

$$\frac{\text{Total points scored in sample} \times 100,000}{\text{Width of cloth, mm,} \times \text{total length inspected, m}} = \frac{\text{Points per}}{100 \text{ m}^2} \quad (\text{Eq. 2})$$

4.3.1.3.2 Demerit Points

Shall be assigned as follows:

TABLE 4

Imperfection	Points
For imperfections 3 inches (76 mm) or under in any dimension	1
For imperfections over 3 to 6 inches (76 to 152 mm), incl, in any dimension	2
For imperfections over 6 to 9 inches (152 to 229 mm), incl in any dimension	3
For imperfections over 9 inches (229 mm) in any dimension	4

4.3.1.3.3 Coated Cloth

All coated cloth shall be examined on both sides. The visual imperfections shall be scored for imperfections as classified in Table 5. The visual imperfections shall be counted regardless of their proximity to each other, except where two or more imperfections represent a single local condition of the cloth; in which case, the imperfection shall be counted only once in a single yard (meter). The same yard (meter) shall be given a through-lighting inspection for pinholes and areas of missing film. The through-lighting equipment shall be as specified in MIL-STD-1487. The sample unit shall be 1 linear yard (1 linear m). The inspection level shall be in accordance with ANSI/ASQ Z1.4, Level II.

TABLE 5 - CLASSIFICATION OF IMPERFECTIONS FOR COATED CLOTH

Imperfection	Description
Aluminum Side Abrasion Marks Coating Unmetallized Spots	Where aluminum is missing from fabric. Improperly adhering to fabric. Any unmetallized spots.
Silicone Rubber Side Blisters or Loose Coating	Over 0.250 inch (6.35 mm) square or 4 under 0.250 inch (6.35 mm) square per 5 running yards (4.6 m).
Creases	Creased area is uncoated.
Cuts	All sizes.
Light Area	Coating missing under 1 inch (25 mm) square in area. Over 1 inch (25 mm) square is a critical imperfection.
Lumps and Foreign Matter	Over 0.250 inch (6.35 mm) square or 4 under 0.250 inch (6.35 mm) square per 5 running yards (4.6 m).
Pinholes	All sizes.
Splice Marks and Coating Impressions	All sizes when coating is missing and under 1 inch (25 mm) square in area. Over 1 inch (25 mm) square in area is a critical imperfection.
Stains	Oil and dirt stains over 1 inch (25 mm) square in area or 5 stains under 1 inch (25 mm) square in 5 running yards (4.6 m).
Streaks	Coating missing under 1 inch (25 mm) square in area. Coating missing over 1 inch (25 mm) square in area is a critical imperfection.
Strike-through	All strike-through marks of coating compound to aluminum face of cloth are imperfections.
Tears	All sizes.

4.3.1.4 Examination for Length

The roll shall be examined for gross length. Any gross length found to be less than the specified minimum length or any gross length found to be more than 2 yards (1.8 m) below the gross length marked on the piece ticket shall be considered an imperfection with respect to length.

4.3.1.5 When a statistical sampling plan has been agreed upon by purchaser and vendor, sampling shall be in accordance with such plan in lieu of sampling as in 4.3.1 and the report of 4.6 shall state that such plan was used.

4.3.2 For Preproduction Tests

As agreed upon by purchaser and vendor.

4.4 Approval

4.4.1 Sample cloth shall be approved by purchaser before cloth for production use is supplied, unless such approval be waived by purchaser. Results of tests on production cloth shall be essentially equivalent to those on the approved sample cloth.

4.4.2 Vendor shall use ingredients, manufacturing procedures, processes, and methods of inspection on production cloth which are essentially the same as those used on the approved sample cloth. If necessary to make any change in ingredients or processing, in type of equipment for processing, or in manufacturing procedures, vendor shall submit for reapproval a statement of the proposed changes in ingredients and/or processing and, when requested, sample cloth. Production cloth made by the revised procedure shall not be shipped prior to receipt of reapproval.

4.5 Test Methods

4.5.1 Cold Crack

A 1 x 4 inch (25 x 102 mm) specimen with the long direction warpwise and a 1 x 4 inch (25 x 102 mm) specimen with the long dimension fillingwise shall be exposed for 4 hours $\pm$ 0.1 at $-67^{\circ}\text{F} \pm 2$ ($-55^{\circ}\text{C} \pm 1$) in a jig assembly as specified in Figure 1. While still at this temperature, the specimen shall be bent sharply, aluminum side out, over a 0.125 inch (3.18 mm) diameter rod so that the back of the specimen touches within 0.125 inch (3.18 mm) distance directly behind the rod. An additional set of specimens shall be tested with the rubber side to the outside of the bend. The specimen shall be examined visually for evidence of cracking, stiffening, flaking, or separation of either coating from the cloth.

4.5.2 Thermal Radiation Resistance

This test is to determine the resistance to multiple exposures from a high energy source of intense thermal radiation. The aluminum surface shall be irradiated at a level of 6.0 to 6.5 cal/cm²/second. The temperature of the silicone rubber coated surface shall be measured by a thermocouple connected to a recording device capable of recording temperature as a function of time. Three specimens from each sample shall be tested. Each specimen shall have a thermocouple attached to the silicone coated face, immediately opposite the aluminum face to be tested, with a suitable adhesive. The sample shall be exposed for 10 seconds. The temperature rise, as a function of time during the exposure period, shall be recorded. The exposure shall be repeated three successive times on the same specimen allowing the specimen to cool to ambient temperature between exposures.

4.5.2.1 Thermal Response

The results of the test shall be reported as thermal response. Thermal response is defined as the rate of temperature rise of the silicone coated side of the cloth divided by the radiant energy flux.