



AEROSPACE MATERIAL SPECIFICATION

AMS3281™**REV. G**Issued 1994-11
Revised 2022-06

Superseding AMS3281F

Sealing Compound, Polysulfide (T) Synthetic Rubber
for Integral Fuel Tank and Fuel Cell Cavities
Low Density for Intermittent Use to 360 °F (182 °C)

RATIONALE

This document is up for its Five-Year review/revision. Changed term "standard cure time" to "cure to hardness." Added additional verbiage clarification as needed to be consistent with recent specification releases.

1. SCOPE

1.1 Form

This specification covers three types and three classes of fuel-resistant polysulfide sealing compound with low specific gravity, supplied as a two-component system which cures at room temperature.

1.2 Application

This sealing compound has been used typically in sealing aircraft integral fuel tanks, fuel tank fillets and faying surfaces, pressure barriers and moldline surfaces, but usage is not limited to such applications. The sealing compound is resistant to jet fuels and is capable of withstanding long-term exposure from -65 to +250 °F (-54 to +121 °C) and short-term exposures (approximately 6 hours, cumulative) to 360 °F (182 °C), but usage is not limited to such applications. AMS3100 adhesion promoter may be applied prior to application of the sealant in accordance with recommendations from the sealant manufacturer for specific substrates.

1.3 Classification

Sealing compounds covered by this specification are classified as follows:

1.3.1 Types

Type 1 - Sealing compound with a specific gravity of 1.20 to 1.35.

Type 2 - Sealing compound with a specific gravity of 1.06 to 1.19.

Type 3 - Sealing compound with a specific gravity of 1.05 or less.

SAE Executive Standards Committee 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 revised, reaffirmed, stabilized, or cancelled. SAE invites your written comments and suggestions.

Copyright © 2022 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:

For more information on this standard, visit
<https://www.sae.org/standards/content/AMS3281G/>

1.3.2 Classes

Class A - Suitable for application by brushing, injecting, or spraying. Available with the following application times in hours:
A-1/2
A-2

Class B - Suitable for application by extrusion gun or spatula. Available with the following application times in hours:
B-1/2
B-2

Class C - Suitable for faying surface or shim sealing, brush coating, or wet installation. Available with the following application times in hours:

Notation: () Assembly time in hours.

C-2(2)

C-8(24)

C-12(48)

C-48(168)

C-96(336)

1.4 Safety - Hazardous Materials

Shall be in accordance with AS5502 (1.1).

2. APPLICABLE DOCUMENTS

Shall be in accordance with AS5502 (Section 2).

2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or +1 724-776-4970 (outside USA), www.sae.org.

AMS2629	Fluid, Jet Reference
AMS3020	Oil, Reference, for "L" Stock Rubber Testing
AMS3021	Fluid, Reference, for Testing Di-Ester (Polyol) Resistant Material
AMS3100	Adhesion Promoter, for Polysulfide Sealing Compounds
AMS4045	Aluminum Alloy Sheet and Plate, 5.6Zn - 2.5Mg - 1.6 Cu - 0.23 Cr, 7075: (-T6 Sheet, -T651 Plate), Solution and Precipitation Heat Treated
AMS4911	Titanium Alloy, Sheet, Strip, and Plate, 6Al - 4V, Annealed
AMS5516	Steel, Corrosion-Resistant, Sheet, Strip, and Plate, 18Cr - 9.0Ni (SAE 30302), Solution Heat Treated
AMS-C-27725	Coating, Corrosion Preventive, for Aircraft Integral Fuel Tanks for Use to 250 °F (121 °C)
AS5127	Aerospace Standard Test Methods for Aerospace Sealants, Methods for Preparing Aerospace Sealants Test Specimens
AS5127/1	Aerospace Standard Test Methods for Aerospace Sealants, Two-Component Synthetic Rubber Compounds
AS5502	Standard Requirements for Aerospace Sealants and Adhesion Promoters

2.2 U.S. Government Publications

Copies of these documents are available online at <https://quicksearch.dla.mil>.

MIL-PRF-23377	Primer Coatings: Epoxy Polyamide, High Solids
MIL-PRF-85285	Coating, Polyurethane, Aircraft and Support Equipment
MIL-PRF-85582	Primer Coatings, Epoxy, Waterborne

2.3 PRI Publications

Available from Performance Review Institute, 161 Thorn Hill Road, Warrendale, PA 15086-7527, Tel: 724-772-1616, www.pri-network.org.

OP 2007 Appendix G9 Additional Requirements for the Aerospace Sealants and Associated Materials (G9) QPG

PRI-QPL-AMS3281 Products Qualified Under AMS3281

3. TECHNICAL REQUIREMENTS

3.1 Materials

The basic ingredient shall be synthetic rubber, made from liquid polysulfide and derivations thereof. The sealing compound shall cure by the addition of a separate curing agent to the base compound and shall not depend on solvent evaporation for curing. The curing agent shall possess sufficient color contrast to the base compound to permit easy identification of an unmixed or incompletely mixed sealing compound. Neither the base compound nor the cured sealing compound shall be red or pink in color. No glass fillers shall be used.

3.2 Date of Packaging

Shall be in accordance with AS5502 (3.1).

3.3 Toxicological Formulations

Shall be in accordance with AS5502 (3.2).

3.4 Quality

Shall be in accordance with AS5502 (3.3).

3.5 Shelf Life

Shelf life shall be a minimum of 9 months from the date of packaging when stored below 80 °F. Material may be retested for shelf life extension per 4.3.3.

3.5.1 Premixed and Frozen Material

Premixed and frozen material shall have a minimum storage life of 30 days at -40 °F (-40 °C) or lower, or 10 days at -10 to -40 °F (-23 to -40 °C) from date of mix/freeze. Recommendations for longer storage lives at lower temperatures may be provided by the manufacturer. The date of mix/freeze shall be within the shelf life of the unmixed material.

3.6 Properties

The base compound and the curing agent, when mixed in accordance with manufacturers' instructions and cured in accordance with 4.5.4.5, shall conform to the requirements shown in Table 1, when determined in accordance with the specified test methods.

Table 1 - Properties

Paragraph	Property	Requirement	Test Procedures (Paragraph)
3.6.1	Nonvolatile content, by weight, min		AS5127/1 (5.1)
	Class A	85%	
	Class B	92%	
	Class C	85%	
3.6.2	Viscosity of base compound		AS5127/1 (5.3)
	Class A	100 to 500 poises	
	(Use No. 6 spindle at 10 rpm)	(10 to 50 Pa•s)	
	Class B	7000 to 18000 poises	
	(Use No. 7 spindle at 2 rpm)	(700 to 1800 Pa•s)	
	Class C	1000 to 4000 poises	
	(Use No. 6 spindle at 2 rpm)	(100 to 400 Pa•s)	
3.6.3	Flow		AS5127/1(5.5)
	Class B, max	0.75 inches (19.0 mm)	AS5127/1 (5.5.1)
	Class C, min	0.010 inch (0.25 mm)	AS5127/1 (5.5.2)
		If tack-free time is not specified, measurement to be taken after assembly time	
3.6.4	Application time, min		AS5127/1 (5.6)
	Class A - From the beginning of mixing, the viscosity shall not exceed 2500 poise (250 Pa•s), (Use No. 7 spindle at 10 rpm)		AS5127/1 (5.6.1)
	A-1/2	1/2 hour	
	A-2	2 hours	
	Class B - From the beginning of mixing, not less than 15 grams per minute shall be extruded		AS5127/1 (5.6.2)
	B-1/2	1/2 hour	
	B-2	2 hours	
	Class C - From the beginning of mixing, not less than 30 grams per minute shall be extruded		AS5127/1 (5.6.2)
	C-2(2)	2 hours	
	C-8(24)	8 hours	
	C-12(48)	12 hours	
	C-48(168)	48 hours	
	C-96(336)	96 hours	
3.6.5	Assembly time, min		AS5127/1 (5.7)
	(Class C only)		
	C-2(2)	2 hours	
	C-8(24)	24 hours	
	C-12(48)	48 hours	
	C-48(168)	168 hours	
	C-96(336)	336 hours	

Table 1 - Properties (continued)

Paragraph	Property	Requirement	Test Procedures (Paragraph)
3.6.6	Tack-free time (measured from beginning of mixing), max		AS5127/1 (5.8)
	A-1/2	10 hours	
	A-2	24 hours	
	B-1/2	12 hours	
	B-2	24 hours	
	C-2(2)	24 hours	
	C-8(24)	96 hours	
	C-12(48)	N/A	
	C-48(168)	N/A	
	C-96(336)	N/A	
3.6.7	Cure time to hardness (time to reach 30 Durometer Type A), max		AS5127/1 (5.9)
	A-1/2	30 hours	
	A-2	72 hours	
	B-1/2	32 hours	
	B-2	72 hours	
	C-2(2)	72 hours	
	C-8(24)	168 hours	
	C-12(48)	336 hours	
	C-48(168)	8 weeks	
	C-96(336)	16 weeks	
3.6.8	Fluid immersion cure time, min (Class A-1/2 and B-1/2 only)		AS5127/1 (5.11)
	After 48 hours	25 Durometer Type A	
	After 120 hours	35 Durometer Type A	
3.6.9	Specific gravity		AS5127/1 (6.1)
	Type 1	1.20 to 1.35	
	Type 2	1.06 to 1.19	
	Type 3	1.05 or less	
3.6.10	Heat reversion resistance Class B and C only	The sealant shall not revert to a liquid or paste-like consistency, nor shall it become brittle or lose adhesion	AS5127/1 (6.5)
3.6.11	Hydrolytic stability, min	30 Durometer A	AS5127/1 (6.6)
3.6.12	Shaving and sanding	No tearing of the sealant, smooth finish	AS5127/1 (6.7)
3.6.13	Paintability	No separation from sealant	AS5127/1 (6.8)
3.6.14	Weathering	No cracking, chalking, peeling, or loss of adhesion	AS5127/1 (6.9)
3.6.15	Chalking	Slight	AS5127/1 (7.1)

Table 1 - Properties (continued)

Paragraph	Property	Requirement	Test Procedures (Paragraph)
3.6.16	Resistance to thermal rupture, max (Class A and B only), oven air aging at 300 °F (149 °C), 10 psi (69 kPa), 30 minutes	0.156 inch (3.96 mm) No blistering or sponging	AMS3281 (4.6.1) and AS5127/1 (7.2)
3.6.17	Fluid rupture resistance, Class B-1/2 only	No pressure loss	AS5127/1 (7.3)
3.6.18	Weight loss and flexibility (standard cure) Weight loss, max Flexibility	8% No cracking or checking	AS5127/1 (7.4)
3.6.19	Volume swell, max	20%	AS5127/1 (7.5)
3.6.20	Low temperature flexibility	No visual evidence of cracking or checking, no loss of adhesion	AMS3281 (4.6.2) and AS5127/1 (7.6)
3.6.21	Tensile strength and elongation, min (Class B and C only)		AS5121/1 (7.7) Ensure specimens are fully immersed in fluid.
3.6.21.1	Cure per 4.5.4.5	200 psi (1379 kPa), 250% elongation	
3.6.21.2	Cure per 4.5.4.5 + 12 days at 140 °F (60 °C), + 60 hours at 160 °F (71 °C), + 6 hours at 180 °F (82 °C) all in AMS2629 Type 1	125 psi (862 kPa), 100% elongation	
3.6.21.3	Cure per 4.5.4.5 + 12 days at 140 °F (60 °C) + 60 hours at 160 °F (71 °C) + 6 hours at 180 °F (82 °C), all in AMS2629 Type 1, + 24 hours at 120 °F (49 °C), + Standard heat cycle as in accordance with 4.5.3, in air	125 psi (862 kPa), 25% elongation	
3.6.21.4	Cure per 4.5.4.5 +, Standard heat cycle as in 4.5.3	100 psi (689kPa), 25% elongation	
3.6.21.5	Cure per 4.5.4.5 +, 72 hours at standard conditions in AMS3021	125 psi (862kPa), 100% elongation	
3.6.21.6	Cure per 4.5.4.5 +, 72 hours at standard conditions in AMS3020	125 psi (862 kPa), 100% elongation	

Table 1 - Properties (continued)

Paragraph	Property	Requirement	Test Procedures (Paragraph)
3.6.22	Shear strength, min (Class C only)	200 psi (1379 kPa), 100% cohesive failure	AS5127/1 (7.8)
3.6.23	Corrosion resistance	No corrosion under sealant or signs of deterioration	AS5127/1 (7.9)
3.6.24	Peel strength, min	20 lbf/in (3503 N/m) /100% cohesive failure	AMS3281 (4.6.3) and AS5127/1 (8.1)
3.6.25	Repairability, min	20 lbf/in (3503 N/m) /100% cohesive failure	AMS3281 (4.6.4) and AS5127/1 (8.2)
3.6.26	Storage stability		
3.6.26.1	Accelerated storage		AS5127/1 (9.1)
3.6.26.1.1	Viscosity of base compound	Same as 3.6.2	
3.6.26.1.2	Flow	Same as 3.6.3	
3.6.26.1.3	Application time	Same as 3.6.4	
3.6.26.1.4	Assembly time	Same as 3.6.5	
3.6.26.1.5	Tack free time	Same as 3.6.6	
3.6.26.1.6	Standard cure time	Same as 3.6.7	
3.6.26.1.7	Peel strength, min	Same as 3.6.24	AMS3281 (4.6.3.2) and AS5127/1 (8.1)
3.6.26.2	Long-term storage		AMS3281 (4.6.5) and AS5127/1 (9.2)
3.6.26.2.1	Application time	Same as 3.6.4	
3.6.26.2.2	Tack-free time	Same as 3.6.6	
3.6.26.2.3	Standard cure time	Same as 3.6.7	

4. QUALITY ASSURANCE PROVISIONS

4.1 Responsibility for Inspection

Shall be in accordance with AS5502 (4.1).

4.1.1 Source Inspection

Shall be in accordance with AS5502 (4.1.1).

4.1.2 Sampling and Testing

Shall be in accordance with AS5502 (4.3).

4.2 Classification of Tests

Shall be in accordance with AS5502 (4.2).

4.2.1 Qualification Tests

Shall be in accordance with AS5502 (4.2.1).

4.2.1.1 Qualification Requirements for Class B-2

Class B-2 shall be the first material that is qualified for each supplier of sealing compound. Class B-2 sealing compound shall be tested for and shall meet all technical requirements of this specification with the exception of requirements unique to other classes or application times of the sealing compound.

4.2.1.2 Qualification Requirements for Other Classes and Application Times

Once qualification for Class B-2 has been obtained, other classes of the sealing compound and application times of qualified classes may be qualified. The formulation for other classes, and for other application times of qualified classes, shall be the same as Class B-2 except for minor variations necessary for conformance to viscosity and application time requirements. All compounds shall meet all technical requirements of this specification. Other classes of the sealing compound need only to be tested to the initial acceptance tests listed in Table 2, plus all peel strength tests listed in Table 6, or as defined by QPL agency. Application times of qualified classes need only to be tested to the initial acceptance tests listed in Table 2 or as defined by QPL agency. Any unique qualification tests for the sealant's class and application time shall also be tested per OP 2007 Appendix G9.

4.2.2 Initial Acceptance Tests

Requirements shown in Table 2 are initial acceptance tests and shall be performed on each batch in accordance with AS5502 (4.2.2.1).

4.2.3 Final Acceptance Tests

Requirements shown in Table 3 are final acceptance tests and shall be performed on each lot in accordance with AS5502 (4.2.2.2).

Table 2 - Initial acceptance tests

Test	Requirement Paragraph
Nonvolatile content	3.6.1
Viscosity of the base compound (Note 1)	3.6.2
Flow (Class B only)	3.6.3
Application time	3.6.4
Assembly time (Class C only)	3.6.5
Tack-free time	3.6.6
Cure time to hardness	3.6.7
Fluid immersion cure time (Class A-1/2 and B-1/2 only)	3.6.8
Specific gravity	3.6.9
Resistance to thermal rupture (Class A and B only)	3.6.16
Weight loss and flexibility	3.6.17
Volume swell	3.6.18
Shear strength (Class C only)	3.6.22
Peel strength (Note 2)	3.6.24 and 4.6.3.2

Note 1: Testing is not required if material is provided in sectional-type containers or premixed and frozen cartridges for initial acceptance testing. Testing is required for qualification testing per the qualification and requalification testing per OP 2007 Appendix G9 (5.8.4.5 and 5.8.5.4).

Note 2: For acceptance tests, sealant may be subjected to an accelerated cure per 4.5.4.5.

Table 3 - Final acceptance tests

Test	Requirement Paragraph
Flow (Class B only)	3.6.3
Application time	3.6.4
Tack-free time	3.6.6
Cure time to hardness	3.6.7

4.3 Sampling and Testing

Shall be in accordance with AS5502 (4.3).

4.3.1 Qualification Tests

Samples shall be produced using production scaled equipment. Enough material shall be supplied to perform all required tests. Samples shall be identified as specified herein and below:

SEALING COMPOUND, POLYSULFIDE (T) SYNTHETIC RUBBER, FOR INTEGRAL FUEL TANK AND FUEL CELL CAVITIES, LOW DENSITY FOR INTERMITTENT USE TO 360 °F (182 °C)

AMS3281G Type and Class

MANUFACTURER'S IDENTIFICATION _____

BATCH/LOT NUMBER _____

DATE OF PACKAGING _____

SHELF LIFE EXPIRATION DATE _____

STORE BELOW 80 °F (27 °C)

4.3.2 Acceptance Tests

Shall be in accordance with AS5502 (4.3.1).

4.3.2.1 Batch and Lot

A batch shall be defined as the quantity of material run through a mill or mixer at one time. A lot shall be defined as material from one batch of each component assembled (packaged) as finished product in one size and/or type of container at the same time. The lot, when used, shall be traceable to the batches of base compound and curing agent.

4.3.2.2 Initial and Final Acceptance Tests

Sufficient material of each batch shall be prepared for initial and final acceptance testing and shall be packaged in the same type containers that are being procured. After successful completion of the initial acceptance tests listed in Table 2, the batch shall be released for final packaging. During packaging, test kits from each lot shall be selected at random for final acceptance testing. Final acceptance testing shall be conducted on the final packaged product and consist of those tests outlined in Table 3.

4.3.2.3 Final Acceptance Tests for Different Types and/or Size Containers

If the batch is being packaged in different types and/or size containers, the final acceptance tests shall be conducted on each type and/or each size containers. If the sealing compound is being procured under different purchase orders, but the purchase orders call for the same type and size containers, it is only necessary to conduct the final acceptance tests one time.

4.3.3 Shelf-Life Extension

4.3.3.1 Shelf-Life Testing

The tests to be conducted for shelf-life extensions are listed in Table 4.

Table 4 - Shelf-life testing

Test	Requirement Paragraph
Appearance	3.4
Viscosity of base compound (Note 1)	3.6.2
Flow (Class B only)	3.6.3
Application time	3.6.4
Assembly time (Class C only)	3.6.5
Tack-free time	3.6.6
Cure time to hardness	3.6.7
Peel strength	3.6.24 and 4.6.3.2

Note 1: Not required for sectional-type containers or premixed and frozen cartridges.

4.3.3.2 Time and Limits of Shelf-Life Extensions

If the tests are being performed at the end of the stated shelf life to update the shelf-life of the sealing compound and all tests passed, then the shelf life may be extended an additional three months. A maximum of three extensions are permissible.

4.4 Approval

Shall be in accordance with AS5502 (4.4).

4.5 Test Methods

4.5.1 Standard Tolerances

Unless otherwise specified herein, standard tolerances of AS5127 (Section 3) shall apply.

4.5.2 Standard Conditions

Standard laboratory conditions shall be as specified in AS5127 (Section 4).

4.5.3 Standard Heat Cycle

When directed herein, the standard heat cycle to which sealants shall be exposed shall consist of six cycles of exposures as follows:

4 hours at 250 °F (121 °C), followed by
40 minutes at 320 °F (160 °C), followed by
1 hour at 360 °F (182 °C).

Temperature shall be reduced to below 100 °F (38 °C) between cycles.

4.5.4 Preparation of Test Specimens

4.5.4.1 Cleaning and Surface Preparation of Test Panels

Panels shall be prepared, cleaned, surface treated, and coated in accordance with AS5127 (Section 6) prior to application of sealant for testing.

4.5.4.2 Preparation of Sealing Compound

Sealing compound shall be prepared in accordance with AS5127/1 (Section 4) and 4.1, 4.2, and 4.3, as applicable.

4.5.4.3 Application of Adhesion Promoter

If adhesion promoter is used, it shall be an adhesion promoter qualified to AMS3100. It shall be applied in accordance with AS5127 (6.9). If adhesion promoter is used for qualification or initial acceptance testing, the adhesion promoter product shall be reported.

4.5.4.4 Application of Sealing Compound

Unless otherwise specified herein, freshly mixed sealing compound shall be applied to test panels in accordance with AS5127 (6.10). For Class A materials, the sealant may be applied in layers with a time equal to the application life used between the applications to permit release of solvents.

4.5.4.5 Curing of Sealing Compounds

Shall be in accordance with AS5127 (6.11). For qualification testing, Class A and B sealing compounds shall be cured for 14 days at standard conditions. For acceptance testing, Class A and B sealing compounds may be given an accelerated cure for 48 hours at standard conditions followed by 24 hours at 140 °F (60 °C). For qualification testing and acceptance testing of Class C sealing compounds, accelerated cure shall be 48 hours at standard conditions, followed by the number of hours listed in Table 5 at 140 °F (60 °C) according to the sealing compound designation. Tests on the cured sealing compound shall commence not more than two days after the completion of the specified cure.

Table 5 - Class C accelerated cure times

Sealing Compound	Hours at 140 °F (60 °C)
C-2(2)	24
C-8(24)	24
C-12(48)	48
C-48(168)	168
C-96(336)	336

4.6 Test Procedures

Standard test methods are in accordance with AS5127 and AS5127/1. In the event of a conflict between the text of this document and AS5127 and/or AS5127/1, the text of this document takes precedence.

4.6.1 Resistance to Thermal Rupture

Resistance to thermal rupture shall be conducted in accordance with AS5127/1 (7.2). The air circulating oven shall be preset at 300 °F (149 °C) and the clamp fixture shall be placed in the oven at 10 psi +1/-0 psi (69 kPa +6.9/-0 kPa) for 30 minutes.

4.6.2 Low Temperature Flexibility

Low temperature flexibility shall be conducted in accordance with AS5127/1 (7.6). At the end of the standard cure in accordance with 4.5.4.5, two of the four panels shall be immersed in AMS2629 Type 1 for 120 hours at 140 °F (60 °C) followed by 60 hours at 160 °F (71 °C) and 6 hours at 180 °F (82 °C). At the completion of the fluid exposure, the specimens shall be removed from the fluid. All four specimens shall be exposed to the standard heat cycle in accordance with 4.5.3, after which all four panels shall be immediately placed in a low temperature flexibility fixture and tested in accordance with AS5127/1 (7.6).

4.6.3 Peel Strength

The type and quantity of panels listed in Table 6 shall be used for the evaluation of peel strength. Test panel preparation and testing shall be performed in accordance with 4.5.4, AS5127/1 (8.1), and AS5127/1 (Figure 22). When 70-day exposures are specified, the fluid shall be changed every 14 days.

4.6.3.1 Fuel/Saltwater Heat Cycle

A total of six fuel/saltwater heat cycles shall be performed. Each cycle consists of 100 hours at 140 °F (60 °C) in AMS2629 Type 1/3% saltwater, followed by 10 hours at 160 °F (71 °C) in AMS2629 Type 1/3% saltwater, followed by 1 hour at 180 °F (82 °C) in AMS2629 Type 1/3% saltwater. After each cycle, the panels shall be cooled to room temperature and shall be directly transferred to fresh test fluid for each succeeding cycle.

4.6.3.2 Acceptance Test, Accelerated Storage, and Shelf-Life Testing (Only)

For acceptance, accelerated storage, and shelf-life testing, prepare four AMS4045 aluminum alloy panels measuring 0.040 x 2.75 x 6 inches (1.02 x 69.8 x 152 mm), sulfuric acid anodized in accordance with AS5127 (6.3), and coat with AMS-C-27725 Type 2 corrosion preventative coating (see 8.5). Apply sealing compound per AS5127/1 (Figure 22) and cure sealing compound in accordance with 4.5.4.5. The panels will be aged in AMS2629 Type 1 for 7 days at 140 °F (60 °C) and two of the panels will be unexposed (no fuel exposure or aging) prior to peel strength testing per AS5127/1 (8.1).

4.6.4 Repairability

Panels shall be prepared and tested in accordance with AS5127/1 (8.2), with the following exceptions. AMS4045 aluminum alloy panels measuring to 0.040 x 2.75 x 6 inches (1.02 x 69.8 x 152 mm), shall be sulfuric acid anodized in accordance with AS5127 (6.3) and overcoated with AMS-C-27725 Type 2 corrosion preventative coating (see 8.5).

4.6.5 Long-Term Storage

Long-term storage shall be conducted in accordance with AS5127/1 (9.2). The period of storage shall be 9 months.

4.7 Reports

Shall be in accordance with AS5502 (4.5).

4.8 Resampling and Retesting

Shall be in accordance with AS5502 (4.6).

SAENORM.COM : Click to view the full PDF of AMS3281G