AEROSPACE MATERIAL SPECIFICATION

AMS3689™	REV. B

Issued 1974-03
Revised 1988-10
Reaffirmed 2022-08

Superseding AMS3689A

Adhesive, Foaming, Honeycomb, Core Splice, Structural
-54 to +177 °C (-65 to +350 °F)

RATIONALE

AMS3689B has been reaffirmed to comply with the SAE Five-Year Review policy.

1. SCOPE

1.1 Form: This specification covers a foaming-type, heat-curing, resin-base adhesive in the form of paste or sheet.

1.2 Application: Primarily for use in splicing aluminum alloy or metallic honeycomb core and for providing a shear tie between core edges and inserts or edge members in honeycomb assemblies for use over the range -54° to+177°C (-65° to +350°F). It is useful for filling gaps between core faces which are inserted into channels or similar areas where bonding pressure cannot be obtained.

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

2.1 SAE Publications: Available from SAE, 400 Commonwelth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2350 - Standards and Test Methods
AMS 2825 - Material Safety Data Sheets
AMS 4037 - Aluminum Alloy Sheet and Plate, 4.4Cu - 1.5Mg - 0.60Mn (2024 - T3 Flat Sheet, -T351 Plate), Solution Heat Treated
AMS 4348 - Honeycomb Core, Aluminum Alloy, Corrosion Inhibited, for Sandwich Construction, 5052, 350 (175)

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