



AEROSPACE MATERIAL SPECIFICATION

Society of Automotive Engineers, Inc.

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AMS 7276

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Revised

RINGS, SEALING, FLUOROCARBON RUBBER High-Temperature-Fluid-Resistant, Very-Low-Compression-Set FKM Type 70 - 80

1. SCOPE:

- 1.1 Form: This specification covers a high-temperature-fluid-resistant, very low compression set fluorocarbon rubber in the form of molded rings.
- 1.2 Application: Sealing rings for use in contact with air or a variety of fuels, lubricants, and hydraulic fluids at temperatures from -15°C ($+5^{\circ}\text{F}$) to $+260^{\circ}\text{C}$ ($+500^{\circ}\text{F}$). The very low compression set of these rings gives longer life than rings of other fluorocarbon rubbers, such as AMS 7278 and AMS 7280, at equal temperatures. The cross section of such rings is usually not over 0.275 in. (6.98 mm) in diameter or thickness. Standard sizes are as shown in AS 568.
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), Aerospace Standards (AS), and Aerospace Information Reports (AIR) 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., Two Pennsylvania Plaza, New York, New York 10001.
 - 2.1.1 Aerospace Material Specifications:

AMS 2350 - Standards and Test Methods
AMS 2817 - Packaging and Identification, Preformed Packings
 - 2.1.2 Aerospace Standards:

AS 568 - Aerospace Size Standard for O-Rings
AS 871 - Manufacturing and Inspection Standards for Preformed Packings (O-Rings)
 - 2.1.3 Aerospace Information Report:

AIR 851 - O-Ring Tension Testing Calculations
 - 2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, Pennsylvania 19103.

ASTM D1414 - Testing Rubber O-Rings
3. TECHNICAL REQUIREMENTS:
 - 3.1 Material: Shall be a compound based on a fluorocarbon elastomer, suitably cured to produce a product meeting all requirements of this specification.

- 3.2 **Properties:** The product shall conform to the following requirements; tests shall be performed on the product supplied and in accordance with ASTM D1414 insofar as practicable. Testing for tensile strength is not required on rings which are too small to permit assembly on rollers and are, after cutting, too short to permit testing as a single strand. Eliminating testing for tensile strength does not eliminate testing for elongation; elongation test can be made by stretching a ring over a mandrel of a size which will stretch the ring sufficiently to produce the required elongation when figured on the ID of the ring. Calculations of tensile strength and elongation may be made in accordance with AIR 851.

3.2.1 As Received:

3.2.1.1	Hardness, Durometer "A" or equiv.	75 $\pm$ 5
3.2.1.2	Tensile Strength, min	1400 psi (9.65 MPa)
3.2.1.3	Elongation, min	125%
3.2.1.4	Corrosion	Nil
3.2.1.5	Specific Gravity, variation from approved sample, max	$\pm$ 0.02

3.2.2 Aromatic Fuel Resistance:
(Immediate Deteriorated Properties)

Medium: ASTM Ref. Fuel B
Temperature: 20° - 30° C
(68° - 86° F)
Time: 70 hr

3.2.2.1	Hardness Change, Durometer "A" or equiv.	-5 to +5
3.2.2.2	Tensile Strength Change, max	-15%
3.2.2.3	Elongation Change, max	-15%
3.2.2.4	Volume Change	0 to +5%

3.2.3 Synthetic Lubricant Resistance:
(Immediate Deteriorated Properties)

Medium: SAE Ester Test
Fluid No. 2
(See 8.1)
Temperature: 200 °C $\pm$ 3
(392° F $\pm$ 5.4)
Time: 70 hr

3.2.3.1	Hardness Change, Durometer "A" or equiv.	-10 to +5
3.2.3.2	Tensile Strength Change, max (based on area before immersion)	-30%
3.2.3.3	Elongation Change, max	-20%
3.2.3.4	Volume Change	0 to +20%

3.2.4 Dry Heat Resistance:

Temperature: 250° C $\pm$ 3
(482° F $\pm$ 5.4)
Time: 70 hr

3.2.4.1	Hardness Change, Durometer "A" or equiv.	0 to +5
3.2.4.2	Tensile Strength Change, max	-20%
3.2.4.3	Elongation Change, max	-20%
3.2.4.4	Weight Loss, max	5.0%
3.2.4.5	Bend (flat)	No cracking or checking

3.2.5 Compression Set:

Percent of Original Deflection, max 20

Temperature: $200^{\circ}\text{C} \pm 3$
($392^{\circ}\text{F} \pm 5.4$)
Time: 70 hr

3.2.6 Long Time Compression Set:

Percent of Original Deflection, max 40

Temperature: $200^{\circ}\text{C} \pm 3$
($392^{\circ}\text{F} \pm 5.4$)
Time: 336 hr

3.2.7 Low Temperature Resistance:

Temperature Retraction,
TR₁₀ point, max -15°C (+5°F)

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 internal imperfections detrimental to performance of parts. Surface imperfections shall, unless otherwise specified, be no greater than permitted by AS 871 for minor defects.

3.4 Sizes and Tolerances: Shall be as specified on the drawing. Inspection for conformance to dimensional requirements shall be made in accordance with AS 871, unless otherwise agreed upon by purchaser and vendor.

4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of rings 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 4.5. Purchaser reserves the right to perform such confirmatory testing as he deems necessary to assure that the rings conform to the requirements of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Tests to determine conformance to the following requirements are classified as acceptance or routine control tests and shall be performed on each lot of rings. A lot of rings is defined as all rings of the same size from the same batch of compound processed in one continuous run and submitted for the vendor's inspection at one time. A batch shall be the quantity of compound run through a mill or mixer at one time.

Test	Paragraph Reference
Hardness, as received	3.2.1.1
Tensile Strength, as received	3.2.1.2
Elongation, as received	3.2.1.3
Specific Gravity, as received	3.2.1.5
Volume Change in fuel	3.2.2.4
Compression Set	3.2.5

4.2.2 Periodic Control Tests: Tests to determine conformance to the acceptance tests of 4.2.1 plus the following tests are classified as periodic control tests and shall be performed on rings produced from a production batch of compound at intervals not greater than 6 months.

Test	Paragraph Reference
Corrosion, as received	3.2.1.4
Tensile Strength Change in oil	3.2.3.2
Elongation Change in oil	3.2.3.3
Volume Change in oil	3.2.3.4
Hardness Change after dry heat exposure	3.2.4.1
Bend after dry heat exposure	3.2.4.5
Temperature Retraction, TR ₁₀ point	3.2.7

4.2.3 Qualification Tests: Tests to determine conformance to all technical requirements of this specification are classified as qualification tests and may be the basis for approval of the compound (See 4.4.1).

4.3 Sampling: A sufficient number of rings shall be taken from each lot or batch to perform each required test on three specimens.

4.4 Approval:

4.4.1 Sample rings shall be approved by purchaser before rings for production use are supplied. Results of tests on production rings shall be essentially equivalent to those on the approved samples.

4.4.2 Vendor shall establish for each size of ring the control factors of processing which will produce rings meeting all requirements of this specification. These shall constitute the approved procedures and shall be used for manufacturing production rings. If necessary to make any change in control factors of processing which could affect quality or properties of the rings, vendor shall submit for reapproval a statement of the revised procedures and, when requested, sample rings. No production rings incorporating the revised procedures shall be shipped prior to receipt of reapproval.

4.4.2.1 Control factors for producing rings include, but are not limited to, the following:

Compound ingredients or proportions thereof within established limits
 Sequence of mixing compound ingredients
 Type of mixing equipment
 Method and equipment for preparing preforms
 Basic molding procedure (compression, transfer, injection)
 Curing time and pressure (variations of $\pm 10\%$ are permissible)
 Basic and minimum curing temperatures
 Finishing methods
 Methods of routine inspection

4.4.2.1.1 Any of the above control factors of processing considered proprietary by the vendor may be assigned a code designation. Each variation in such factors shall be assigned a modified code designation.

4.5 Reports:

4.5.1 The vendor of rings shall furnish with each shipment three copies of a report showing the results of tests to determine conformance to the acceptance test requirements and a statement that the rings conform to all other technical requirements of this specification. This report shall include the purchase order number, material specification number, vendor's compound number, batch number, and quantity.

4.5.2 In addition to the reports of 4.5.1, the vendor shall furnish at six-month intervals the results of tests to determine conformance to the periodic control test requirements. This report shall be included with, or shall form a part of, the report of results of acceptance tests on the first lot of parts shipped following determination of conformance to the periodic control test requirements.