



AEROSPACE MATERIAL

Society of Automotive Engineers, Inc.

TWO PENNSYLVANIA PLAZA, NEW YORK, N.Y. 10001

SPECIFICATION

AMS 7266

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Revised

RINGS, SEALING, FLUOROSILICONE RUBBER General Purpose, High Temperature, Fuel and Oil Resistant 65 - 75

1. SCOPE:

- 1.1 Form: This specification covers a fluorosilicone rubber in the form of molded rings.
- 1.2 Application: Sealing rings for use at temperatures from -55° to $+175^{\circ}\text{C}$ (-67° to $+347^{\circ}\text{F}$) in fuels and from -55° to $+150^{\circ}\text{C}$ (-67° to $+302^{\circ}\text{F}$) in lubricating oils. The cross-section of such rings is usually not over 0.275 in. (6.98 mm) in diameter or thickness.

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 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 fluorosilicone 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 and tensile stress 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 and tensile stress 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, elongation, and tensile stress may be made in accordance with AIR 851.

SAE Technical Board rules provide that: "All technical reports, including standards approved by the Board, are advisory only. Their use by anyone engaged in industry or trade is entirely voluntary. There is no agreement to adhere to any SAE standard or recommended practice, and no commitment to conform to or be guided by any technical report. In formulating and approving technical reports, the Board and its committees will not investigate or consider patents which may apply to the subject matter. Prospective users of the report are responsible for protecting themselves against liability for infringement of patents."

3.2.1 As Received:

3.2.1.1	Hardness, Durometer "A" or equiv.	70 ± 5
3.2.1.2	Tensile Strength, min	600 psi (4.1 MPa)
3.2.1.3	Elongation, min	120%
3.2.1.4	Tensile Stress at 100% Elongation	500 - 1000 psi (3.4 - 6.9 MPa)
3.2.1.5	Corrosion	Nil
3.2.1.6	Specific Gravity, variation from approved sample	± 0.03 max

3.2.2 Aromatic Fuel Resistance:

(Immediate Deteriorated Properties)

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

3.2.2.1	Hardness Change, Durometer "A" or equiv.	-15 to 0
3.2.2.2	Tensile Strength Change, max	-40%
3.2.2.3	Elongation Change, max	-35%
3.2.2.4	Volume Change	0 to +20%

3.2.3 Lubricating Oil Resistance:

(Immediate Deteriorated Properties)

Medium: SAE Ester Test
 Fluid No. 2
 (See 8.1)
 Temperature: $150^{\circ} \text{C} \pm 3$
 (302° F ± 5.4)
 Time: 70 hr

3.2.3.1	Hardness Change, Durometer "A" or equiv.	-15 to 0
3.2.3.2	Tensile Strength Change, max	-25%
3.2.3.3	Elongation Change, max	-35%
3.2.3.4	Volume Change	0 to +12%

3.2.4 Dry Heat Resistance:

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

3.2.4.1	Hardness Change, Durometer "A" or equiv.	0 to +10
3.2.4.2	Tensile Strength Change, max	-20%
3.2.4.3	Elongation Change, max	-30%

3.2.5 Compression Set:

Temperature: $175^{\circ}\text{C} \pm 3$
 $(347^{\circ}\text{F} \pm 5.4)$
 Time: 22 hr

Percent of Original Deflection
 Ring Cross Section Diameter
 0.066 to 0.110 in., incl 50
 (1.68 to 2.79 mm, incl
 Over 0.110 in. (2.79 mm) 30

3.2.6 Low Temperature Resistance:

Temperature Retraction,
 TR₁₀ point, max -55° C
 (-67° 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
Tensile Stress, as received	3.2.1.4
Specific Gravity, as received	3.2.1.6

4.2.2 Periodic Control Tests: Tests to determine conformance to the routine control 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	3.2.1.5
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
Temperature Retraction, TR ₁₀ point	3.2.6
Volume Change in fuel	3.2.2.4
Compression Set	3.2.5

4.2.3 Qualification Tests: Tests to determine conformance to all technical requirements of this specification are classified as qualification tests and shall be the basis for approval (See 4.4) of the compound.

4.3 Sampling: Sufficient rings shall be taken from each lot or batch to perform all tests in triplicate.

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 (Variation of $\pm 10\%$ from established limits is 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 of this specification. This report shall include the purchase order number, material specification number, vendor's compound number, batch number, part number, and quantity.

4.5.2 In addition to the reports of 4.5.1, at six-month intervals, the vendor shall furnish 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.