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**AEROSPACE
MATERIAL
SPECIFICATION**

Submitted for recognition as an American National Standard

SAE AMS 3652B

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Superseding AMS 3652A

**POLYTETRAFLUOROETHYLENE FILM
Non-Critical Grade**

1. SCOPE:

1.1 Form: This specification covers one grade of polytetrafluoroethylene resin in the form of film, normally produced by skiving.

1.2 Application: Primarily for gaskets and other parts for use up to 260°C (550°F) where chemical resistance and anti-stick characteristics are required but where high mechanical or electrical characteristics are not important.

2. APPLICABLE DOCUMENTS: 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 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2350 - Standards and Test Methods

2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM D638 - Tensile Properties of Plastics

ASTM D792 - Specific Gravity and Density of Plastics by Displacement

ASTM D1708 - Tensile Properties of Plastics by Use of Microtensile Specimens

2.3 U.S. Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

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2.3.1 Military Standards:

MIL-STD-794 - Parts and Equipment, Procedures for Packaging and Packing of

3. TECHNICAL REQUIREMENTS:

3.1 Material: Film shall, unless otherwise permitted by purchaser, be produced by skiving billets molded or extruded from polytetrafluoroethylene powder without admixture of fillers, pigments, or adulterants.

3.2 Color: May vary from white to light gray. Small gray, brown, or black spots shall not in themselves be unacceptable.

3.3 Properties: Film shall conform to the following requirements; tests shall be performed on the film supplied and in accordance with specified test methods, insofar as practicable.

3.3.1 Tensile Strength at 23°C ± 1 (73°F ± 2), min	1500 psi (10.5 MPa)	4.5.1
3.3.2 Elongation (Applicable only to widths 0.375 in. (9.5 mm) and over) at 23°C ± 1 (73°F ± 2), min	100%	4.5.1
3.3.3 Specific Gravity at 23°/23°C (73°/73°F)	2.14 - 2.20	ASTM D792 Add 2 drops of wetting agent to the water

3.4 Quality: Film, as received by purchaser, shall be uniform in quality and condition, clean, smooth, and free from foreign materials and from imperfections detrimental to usage of the film.

3.5 Tolerances: Shall be as follows, determined at 23° - 30°C (73° - 86°F):

TABLE I

Nominal Thickness Inch	Nominal Width Inches	Thickness Tolerance Inch	
		plus	minus
0.002 to 0.003, incl	Up to 2, incl	0.0005	0.0003
Over 0.003 to 0.005, incl	2 to 12, incl	0.0005	0.0005
Over 0.005 to 0.015, incl	2 to 12, incl	0.0010	0.0010
Over 0.015 to 0.040, incl	2 to 12, incl	0.0015	0.0015
Over 0.040 to 0.061, incl	2 to 12, incl	0.0020	0.0020
Over 0.061 to 0.125, incl	2 to 12, incl	0.005	0.005

TABLE I (SI)

Nominal Thickness Millimetres	Nominal Width Millimetres	Thickness Tolerance Millimetre	
		plus	minus
0.05 to 0.08, incl	Up to 50, incl	0.012	0.008
Over 0.08 to 0.12, incl	50 to 300, incl	0.012	0.012
Over 0.12 to 0.38, incl	50 to 300, incl	0.025	0.025
Over 0.38 to 1.00, incl	50 to 300, incl	0.038	0.038
Over 1.00 to 1.52, incl	50 to 300, incl	0.050	0.050
Over 1.52 to 3.12, incl	50 to 300, incl	0.12	0.12

4. QUALITY ASSURANCE PROVISIONS:

- 4.1 Responsibility for Inspection: The vendor of film shall supply all samples for vendor's tests and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.6. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the film conforms to the requirements of this specification.
- 4.2 Classification of Tests: Tests to determine conformance to all technical requirements of this specification are classified as acceptance tests and as preproduction tests and shall be performed prior to or on the initial shipment of film to a purchaser, on each lot, when a change in material, processing, or both requires reapproval as in 4.4.2, and when purchaser deems confirmatory testing to be required.
- 4.2.1 For direct U.S. Military procurement, substantiating test data and, when requested, preproduction film shall be submitted to the cognizant agency as directed by the procuring activity, the contracting officer, or the request for procurement.
- 4.3 Sampling: Shall be as follows:
- 4.3.1 For Acceptance Tests: Sufficient film shall be taken at random 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 film of the same thickness made from the same batch of compound in one production run and presented for vendor's inspection at one time.
- 4.3.1.2 An inspection lot shall be not more than 200 lb (90 kg) of film. A lot may be packaged and delivered in smaller quantities under the basic lot approval provided lot identification is maintained.
- 4.3.1.3 When a statistical sampling plan and acceptance quality level (AQL) have 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 4.6.1 shall state that such plan was used.

4.3.2 For Preproduction Tests: As agreed upon by purchaser and vendor.

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4.4 Approval:

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

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

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4.5 Test Methods:

4.5.1 Tensile Strength and Elongation: Shall be determined in accordance with ASTM D638, using the microtensile specimen of ASTM D1708. The initial jaw separation shall be 0.875 in. \pm 0.005 (22.00 mm \pm 0.12) and the speed of testing shall be in 2 in. (50 mm) per minute. Specimens shall be cut with the long axis parallel to the skive marks. Product over 0.062 in. (1.55 mm) thick shall be machined to 0.062 in. \pm 0.016 (1.55 mm \pm 0.40) thick before cutting specimens.

4.6 Reports:

4.6.1 The vendor of film shall furnish with each shipment a report showing the results of tests to determine conformance to the technical requirements of this specification. This report shall include the purchase order number, lot number, AMS 3652B, vendor's compound number, size, and quantity.

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4.6.2 The vendor of finished or semi-finished parts shall furnish with each shipment a report showing the purchase order number, AMS 3652B, contractor or other direct supplier of film, supplier's compound number, part number, and quantity. When film for making parts is produced or purchased by the parts vendor, that vendor shall inspect each lot of film to determine conformance to the requirements of this specification and shall include in the report either a statement that the film conforms or copies of laboratory reports showing the results of tests to determine conformance.

4.7 Resampling and Retesting: If any specimen used in the above tests fails to meet the specified requirements, disposition of the film may be based on the results of testing three additional specimens for each original nonconforming specimen. Failure of any retest specimen to meet the specified requirements shall be cause for rejection of the film represented and no additional testing shall be permitted. Results of all tests shall be reported.

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5. PREPARATION FOR DELIVERY:

5.1 Packaging and Identification:

5.1.1 Packaging shall be accomplished in such a manner as to ensure that the film, during shipment and storage, will not be permanently distorted and will be protected against damage from exposure to weather or any other normal hazard.

5.1.2 Each package shall be permanently and legibly marked with not less than the following information:

POLYTETRAFLUOROETHYLENE FILM

Non-Critical Grade

AMS 3652B

SIZE _____

LOT NUMBER _____

PURCHASE ORDER NUMBER _____

QUANTITY _____

MANUFACTURER'S IDENTIFICATION _____

5.1.3 Packages of film shall be prepared for shipment in accordance with commercial practice and in compliance with applicable rules and regulations pertaining to the handling, packaging, and transportation of the film to ensure carrier acceptance and safe delivery. Packaging shall conform to carrier rules and regulations applicable to the mode of transportation.

5.1.4 For direct U.S. Military procurement, packaging shall be in accordance with MIL-STD-794, Level A or Level C, as specified in the request for procurement. Commercial packaging as in 5.1.1 and 5.1.3 will be acceptable if it meets the requirements of Level C.

6. ACKNOWLEDGMENT: A vendor shall mention this specification number and its revision letter in all quotations and when acknowledging purchase orders.

7. REJECTIONS: Film not conforming to this specification or to modifications authorized by purchaser will be subject to rejection.

8. NOTES:

8.1 Marginal Indicia: The phi (ϕ) symbol is used to indicate technical changes from the previous issue of this specification.

8.2 Dimensions and properties in inch/pound units and the Celsius temperatures are primary; dimensions and properties in SI units and the Fahrenheit temperatures are shown as the approximate equivalents of the primary units and are presented only for information.