

RINGS, SEALING, BUTADIENE-ACRYLONITRILE (NBR) RUBBER  
Synthetic Lubricant Resistant  
65 - 75

1. SCOPE:

- 1.1 Form: This specification covers a butadiene-acrylonitrile (NBR) rubber in the form of molded rings.
- 1.2 Application: Sealing rings for use up to 150°C (300°F) in contact with diester synthetic lubricants. The cross-section of such rings is usually not over 0.275 in. (7.0 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, Aerospace Standards, and Aerospace Information Reports 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  
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 Reports:

- AIR 851 - O-Ring Tension Testing Calculations

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

ASTM D471 - Rubber Property - Effect of Liquids

ASTM D1414 - Testing Rubber O-Rings

### 3. TECHNICAL REQUIREMENTS:

3.1 Material: Shall be a compound based on a butadiene-acrylonitrile (NBR) elastomer, suitably cured to produce sealing rings meeting the requirements of 3.2.

3.2 Properties: Rings shall conform to the following requirements; tests shall be performed on the rings supplied and, except as otherwise specified herein, 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 for tensile strength, elongation, and tensile stress may be made in accordance with AIR 851.

#### 3.2.1 As Received:

- |         |   |                              |
|---------|---|------------------------------|
| 3.2.1.1 | Hardness, Durometer "A<br>or equiv.       | 70 ± 5                       |
| 3.2.1.2 | Tensile Strength, min                     | 1500 psi<br>(10.5 MPa)       |
| 3.2.1.3 | Elongation, min                           | 250%                         |
| 3.2.1.4 | Tensile Stress at 100%<br>Elongation, min | 500 psi<br>(3.45 MPa)        |
| 3.2.1.5 | Corrosion                                 | Nil                          |
| 3.2.1.6 | Specific Gravity                          | Preproduction<br>Value ±0.02 |

3.2.2 Synthetic Lubricant  
Resistance:  
(Immediate Deteriorated  
Properties)

Medium: ASTM Service  
Fluid No. 101  
(ASTM D471)  
Temperature: 150°C + 3  
(300°F + 5)  
Time: 70 hr ± 0.5  
Prepare specimens as in 4.5.1

3.2.2. Tensile Strength  
Change, max

-70%, but  
actual strength  
shall be not  
lower than  
600 psi (4.15 MPa)

3.2.2.2	Elongation Change, max	-70%		
3.2.2.3	Volume Change	0 to +15%		
3.2.2.4	Decomposition	None		
3.2.2.5	Surface Tackiness	None		
3.2.3	<u>Aromatic Fuel Resistance:</u> (Immediate Deteriorated Properties)		Medium:	ASTM Ref. Fuel B (ASTM D471)
			Temperature:	20° - 30°C (68° - 86°F)
			Time:	70 hr ± 0.5
3.2.3.1	Tensile Strength Change, max (based on area before immersion)	-60%		
3.2.3.2	Elongation Change, max	-55%		
3.2.3.3	Volume Change	0 to +35%		
3.2.3.4	Volume Change after 70 hr + 0.5 immersion in 30% aromatic fuel followed by 48 hr + 0.5 drying at 70°C + 1 (160°F + 2), max (based on unimmersed volume)	-10%		
3.2.4	<u>Dry Heat Resistance:</u>		Temperature:	125°C + 2 (257°F + 4)
3.2.4.1	Tensile Strength Change, max	-25%	Time:	70 hr ± 0.5
3.2.4.2	Elongation Change, max	-50%		
3.2.4.3	Bend (flat)	No cracking or checking		
3.2.5	<u>Compression Set:</u>		Temperature:	125°C + 2 (257°F + 4)
3.2.5.1	Percent of Original Deflection, max Ring Cross Section Diameter, 0.066 to 0.110 in. (1.68 to 2.75 mm), incl 85 Over 0.110 in. (2.75 mm) 75		Time:	70 hr ± 5

### 3.2.6 Low-Temperature Resistance:

3.2.6.1 Temperature Retraction -26°C  
TR<sub>10</sub> point, max (-15°F)

3.3 Quality: Rings, as received by purchaser, shall be uniform in quality and condition, clean, smooth, as free from foreign material as commercially practicable, and free from internal imperfections detrimental to usage of the rings. Surface imperfections shall 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.

## 4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection: The vendor of rings 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 confirmatory testing deemed necessary to ensure 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 tests and shall be performed on each lot:

Requirement	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	3.2.1.6
Volume Change in Synthetic Lubricant	3.2.2.3
Decomposition in Synthetic Lubricant	3.2.2.4
Surface Tackiness in Synthetic Lubricant	3.2.2.5
Compression Set	3.2.5

- 4.2.2 Periodic Tests: Tests to determine conformance to the following requirements are classified as periodic tests and shall be performed at a frequency selected by the vendor unless frequency of testing is specified by purchaser.

Requirement	Paragraph Reference
Tensile Stress, as received	3.2.1.4
Corrosion, as received	3.2.1.5
Tensile Strength Change in Synthetic Lubricant	3.2.2.1
Elongation Change in Synthetic Lubricant	3.2.2.2
Tensile Strength Change in Aromatic Fuel	3.2.3.1
Elongation Change in Aromatic Fuel	3.2.3.2
Volume Change in Aromatic Fuel	3.2.3.3 and 3.2.3.4
Tensile Strength Change after dry heat exposure	3.2.4.1
Elongation Change after dry heat exposure	3.2.4.2
Bend after dry heat exposure	3.2.4.3
Temperature Retraction, TR <sub>10</sub> point	3.2.6.1

- 4.2.3 Preproduction Tests: Tests to determine conformance to all technical requirements of this specification are classified as preproduction tests and shall be performed prior to or on the first-article shipment of rings to a purchaser, when a change in material, processing, or both requires reapproval as in 4.4.2, and when purchaser deems confirmatory testing to be required.

- 4.2.3.1 For direct U.S. Military procurement, substantiating test data and, when requested, preproduction test material 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 rings 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 rings of the same nominal size from the same batch of compound processed in one continuous run and presented for vendor's inspection at one time but shall not exceed 1000 rings or 200 lb (90 kg), whichever is the greater mass.

- 4.3.1.2 A batch shall be the quantity of compound run through a mill or mixer at one time.

- 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 shall state that such plan was used.