



400 Commonwealth Drive, Warrendale, PA 15096-0001

AEROSPACE MATERIAL SPECIFICATION

Submitted for recognition as an American National Standard

SAE

AMS 3218

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FLUOROCARBON (FKM) RUBBER High-Temperature-Fluid Resistant Low Compression Set 85 to 95

1. SCOPE:

1.1 Form:

This specification covers a fluorocarbon (FKM) rubber in the form of sheet, strip, tubing, extrusions and molded shapes.

1.2 Applications:

These products have been typically used in components in contact with air and a wide variety of fuels, synthetic lubricants and specific hydraulic fluids from -29 to +260 °C (-20 to +500 °F), but is not limited to such applications. Each application should be considered individually.

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 DOCUMENTS:

The following publications form a part of this specification to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order.

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AMS 3218**SAE****AMS 3218****2.1 SAE Publications:**

Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096-0001.

AMS 2279 Tolerances, Rubber Products

MAM 2279 Tolerances, Metric Rubber Products

AMS 2810 Identification and Packaging, Elastomeric Products

AMS 3023 Fluid, Reference, for Testing Polyol Ester (and Diester) Resistant Materials

2.2 ASTM Publications:

Available from ASTM, 100 Barr Harbor Drive, West Conshohocken, PA 19428-2959.

ASTM D 297 Rubber Products - Chemical Analysis

ASTM D 395 Rubber Property - Compression Set

ASTM D 412 Vulcanized Rubber and Thermoplastic Elastomers - Tension

ASTM D 471 Rubber Property - Effect of Liquids

ASTM D 573 Rubber Property - Deterioration in an Air Oven

ASTM D 792 Rubber Property - Specific Gravity

ASTM D 1329 Rubber Property - Retraction at Low Temperature (TR Test)

ASTM D 2240 Rubber Property - Durometer Hardness

3. TECHNICAL REQUIREMENTS:**3.1 Material:**

Shall be a compound, based on a fluorocarbon (FKM) elastomer, suitably cured to produce a product meeting the requirements of 3.2. A dihydroxy/bisphenol cure system shall be used. Material shall be based on 100% virgin fluorocarbon (FKM) elastomer. No reprocessed or non-fluorocarbon polymer is acceptable.

3.1.1 Color: Shall be black or brown. No other color shall be acceptable.

3.2 Properties:

The product shall conform to the requirements shown in Table 1 and Table 2; tests shall be performed on the product supplied and in accordance with ASTM Test Methods, insofar as practicable.

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TABLE 1 - Properties

Property	Requirement	Test Method
3.2.1 Hardness, Durometer "A" or equivalent	90 \pm 5	ASTM D 2240
3.2.2 Tensile Strength, min	1600 psi (11.02 MPa)	ASTM D 412
3.2.3 Elongation, min	100%	ASTM D 412
3.2.4 Specific Gravity	Preproduction Value \pm 0.02	ASTM D 792 (Hydrostatic Method)
3.2.5 Aromatic Fuel Resistance		ASTM D 471 ASTM Ref. Fuel B 23 °C \pm 2 (73 °F \pm 5) 70 hours \pm 0.5
3.2.5.1 Hardness Change, Durometer "A" or equivalent	-5 to +5	
3.2.5.2 Tensile Strength Change, max	-20%	
3.2.5.3 Elongation Change, max	-20%	
3.2.5.4 Volume Change	0 to +5%	
3.2.6 Synthetic Lubricant Resistance		ASTM D 471 (Note A) AMS 3023 200 °C \pm 3 (392 °F \pm 5) 70 hours \pm 0.5
3.2.6.1 Hardness Change, Durometer "A" or equivalent	-15 to 0	

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TABLE 1 - Properties (Continued)

Property	Requirement	Test Method
3.2.6.2 Tensile Strength Change, max (based on area before immersion)	-35%	
3.2.6.3 Elongation Change, max	-20%	
3.2.6.4 Volume Change	+1 to +25%	
3.2.6.5 Compression Set, Percent of Original Deflection, max	25	ASTM D 395 Method B
3.2.7 Dry Heat Resistance		ASTM D 573 270 °C ± 3 (518 °F ± 5) 70 hours ± 0.5
3.2.7.1 Hardness Change, Durometer "A" or equivalent	-5 to +10	
3.2.7.2 Tensile Strength Change, max	-45%	
3.2.7.3 Elongation Change, max	-20%	
3.2.7.4 Weight Loss, max	10%	4.5.1
3.2.8 Compression Set: Percent of Original Deflection, max	25	ASTM D 395 Method B 200 °C ± 3 (392 °F ± 5) 22 hours ± 0.5
3.2.9 Long-Term Compression Set: Percent of Original Deflection, max	65	200 °C ± 3 (392 °F ± 5) 336 hours ± 0.5

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TABLE 1 - Properties (Continued)

Property	Requirement	Test Method
3.2.10 Low-Temperature Resistance		ASTM D 1329
Temperature Retraction, TR, Point, max	-15 °C (+5 °F)	

(Note A) Do not dip specimen in acetone; blot dry residual oil from specimen.

3.2.11 Physical Properties After Humidity Aging on Brown Parts Only: The following properties shall be determined on brown specimens that have been aged for 28 days \pm 2 hours at 25 °C \pm 2 (77 °F \pm 5) and 95% \pm 3 relative humidity.

TABLE 2 - Humidity Aged Properties

Property	Requirement	Test Method
3.2.11.1 Tensile Strength, min	1600 psi (11.02 MPa)	
3.2.11.2 Elongation, min	125%	
3.2.11.3 Tensile Strength Change, max ⁽¹⁾	-15%	
3.2.11.4 Elongation Change, max ⁽¹⁾	-15%	
3.2.12 Synthetic Lubricant Resistance		ASTM D 471 (Note A) AMS 3023 200 °C \pm 3 (392 °F \pm 5) 70 hours \pm 0.5
3.2.12.1 Tensile Strength Change, max ⁽²⁾	-35%	
3.2.12.2 Elongation Change, max ⁽²⁾	-20%	

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TABLE 2 - Humidity Aged Properties (Continued)

Property	Requirement	Test Method
3.2.12.3 Compression Set: Percent of Original Deflection, max	20	
3.2.13 Dry Heat Resistance After Humidity Age		ASTM D 573 200 °C ± 3 (392 °F ± 5) 70 hours ± 0.5
3.2.13.1 Tensile Strength Change, max	-45%	
3.2.13.2 Elongation Change, max	-25%	
3.2.14 Compression Set Percent of Original Deflection, max	25	ASTM 395 Method B 200 °C ± 3 (392 °F ± 5) 22 hours ± 0.5
(Note A) Do not dip specimens in acetone, blot dry residual oil from specimens.		
(1) Shall be based on the original tensile strength and elongation found when tested to the requirements of Table 1.		

3.3 Quality:

The product, as received by purchaser, shall be uniform in quality and condition, smooth as free from foreign material, and free from internal imperfections detrimental to usage of the product.

3.4 Sizes and Tolerances:

Shall conform to all applicable requirements of AMS 2279 or MAM 2279.

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4. QUALITY ASSURANCE PROVISIONS:

4.1 Responsibility for Inspection:

The manufacturer shall supply all samples and shall be responsible for all required tests. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure the product conforms to the requirements of this specification.

4.2 Classification of Tests:

4.2.1 Acceptance Tests: Requirements shown in Table 3 are acceptance tests and shall be performed on each lot.

TABLE 3 - Acceptance Requirements

Requirements	Paragraph Reference
Hardness	3.2.1
Tensile Strength	3.2.2
Elongation	3.2.3
Specific Gravity	3.2.4
Compression Set	3.2.8
Quality	3.3

4.2.2 Preproduction Tests: All technical requirements are preproduction tests and shall be performed prior to or on the initial shipment of the product by the manufacturer, when any change in ingredients and/or processing requires reapproval as in 4.4.2 and when purchaser deems confirmatory testing to be required.

4.3 Sampling and Testing:

Shall be as follows:

4.3.1 Acceptance Tests: Sufficient product 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, except as otherwise specified in 4.3.1.4.

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- 4.3.1.1 If specimens cannot be prepared from the product, ASTM test specimens prepared from the same batch and state of cure shall be used. When the product supplied is an extrusion of such shape that suitable test specimens cannot be cut from the product, a separate flat strip shall be prepared from the tubing 1.000 inch \pm 0.063 (25.40 mm \pm 0.20) in wall thickness, mechanically slit and flattened into a strip while being extruded and cured in the same manner as the production product. When the product is a molded shape from which test specimens cannot be cut, a slab 6 inches (152 mm) square by 0.075 inch \pm 0.008 (1.90 mm \pm 0.020) thick molded from the same batch of compound shall be supplied upon request.
- 4.3.1.2 A lot shall be all product produced from the same batch of compound processed in one continuous run and presented for manufacturers inspection at one time.
- 4.3.1.3 A batch shall be the quantity of compound run through a mill or mixer at one time.
- 4.3.1.4 A statistical sampling plan acceptable to the purchaser may be used in lieu of sampling as in 4.3.1. Sample size for visual and dimensional requirements shall be as shown in Table 4; sample unit shall be one molded part and acceptable based on zero defects.

TABLE 4 - Visual and Dimensional Inspection

Lot Size	Sample Size
2 to 8	Entire Lot
9 to 90	8
91 to 150	12
151 to 280	19
281 to 500	21
501 to 1200	27
1201 to 3200	35
3201 to 10,000	38
10,001 to 35,000	46
35,001 to 150,000	56
150,001 and Over	65

- 4.3.2 Preproduction Tests: Acceptable to purchaser or as stated in the contract.