

**Ministry of Defence
Defence Procurement Agency, ADRP2
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BS34 8JH**

OBSOLESCENCE NOTICE

All DTD specifications were declared obsolescent from 1st April 1999. All DTD 900 series approvals also lapsed at that time. The standards will no longer be updated but will be retained as obsolescent documents to provide for the servicing of existing equipment.

Further Guidance

The aim in declaring the specifications obsolescent is to recognise that the documents are not being updated and thus should be used with care by both purchaser and supplier. For example, a specification could contain valid technical information but may also contain type approval clauses that contradict procurement policy and/or use materials that do not comply with environmental legislation. The obsolescent specification can still be used as a basis for a purchase provided that the supplier and purchaser agree suitable changes to the specification within the purchase order/contract.

For the DTD 900 system, each specification has provided an MoD approved material and process. For these items, the declaration of obsolescence will constitute the termination of both the extant MoD approval and the continuing MoD assessment that had underpinned those approvals. Again, the technical content of the document remains valid and can be used by both purchaser and supplier as a basis for a contract but an acceptable (to the parties) approval/assessment procedure would be required.

Aerospace Material Specification
POLYCHLOROPRENE RUBBERS (HEAT RESISTANT)

NOTE 1. This specification is one of a series issued by the Procurement Executive, Ministry of Defence, either to meet a limited requirement not covered by an existing British Standard for aerospace material, or to serve as a basis for inspection of material, the properties and uses of which are not sufficiently developed to warrant submission to the British Standards Institution for standardization.

NOTE 2. It is one of a series of rubber specifications in which the material is classified by the base polymer employed.

NOTE 3. The tests employed in this specification are chosen for their reproducibility and ability to control the properties of the material. They are not intended to be simulated service tests, which, because of variability of test conditions, may be unsatisfactory for control purposes.

NOTE 4. The intended applications and the limitations of materials to this specification are given in Section 1 of the specification and are for guidance only. In case of doubt users are advised to confirm the suitability of the material for any given application.

NOTE 5. Further guidance on the choice of rubber for any particular purpose may be obtained from Appendix 1 of D R Mat. Tech. Memo. No 7 "Rubber in Engineering Design", and SBACTS No. 97 "Recommended Design Guide for Rubber Materials for Aerospace Applications".

NOTE 6. This specification calls for the use of substances and/or test procedures that may be injurious to health if adequate precautions are not taken. It refers only to technical suitability and in no way absolves either the supplier or the user from statutory obligations related to health and safety at any stage of manufacture or use.

This specification has been devised for the use of the Ministry of Defence and its contractors in the execution of contracts for the Ministry and, subject to the Unfair Contract Terms Act 1977, the Ministry will not be liable in any way whatever (including but without limitation negligence on the part of the Ministry, its servants or agents) where the specification is used for other purposes.

SECTION 1

Scope

1.1 Scope

The materials covered by this specification are intended for the production of items, such as sheets, mouldings and certain extrusions, where resistance to atmospheric ageing and ozone attack coupled with moderate resistance to petroleum-based lubricants and fuels is of prime importance. For selected applications they may be considered suitable for use between -40°C and, for continuous operation, 120°C, whilst for short periods they may be used up to 150°C.

They are not considered suitable for applications involving total immersion in petroleum-based lubricants and fuels where stability of dimensions and other properties is essential or for use in contact with ester-based liquids.

NOTE. At ordinary temperatures and in the absence of hostile environments, eg when properly stored, these rubbers deteriorate only very slowly. However, the rate of deterioration increases markedly with increased temperature and the service life of the rubber therefore depends upon the operational temperature. Conversely the maximum temperature at which the rubber may be used depends upon the useful life required.

1.2 Classification

Five different hardness values are covered (Grades 40, 50, 60, 70 and 80; Grade 40 being the softest) and the grade required must therefore be stated on all drawings and contracts. Where a nominal hardness other than those quoted is necessary, this can be specified and the basic requirements other than hardness shall be those specified for the grade embracing the proposed nominal hardness. If a tolerance is required which is tighter than those quoted, this should be specified but should not be less than ± 3 .

SECTION 2

Related Documents

2 Reference is made in this document to the following:

- BS 903 — Methods of testing vulcanized rubber.
- BS 1134 — Centre line average height. Method for the assessment of surface texture
- BS 3734 — Schedule of tolerances for rubber products in solid rubber and ebonite.
- BS 5294 — Determination of crystallisation effects in rubber by hardness measurements.
- BS F69 — Packaging and identification of vulcanized rubber items.

The related documents listed are those applicable at the date of publication of this specification. Their current applicability must be confirmed by all users of the specification. The Quality Assurance Authority will supply, on request, information concerning any changes that may be necessary due to cancellation, replacement, supersession or amendment or any related document.

SECTION 3

General requirements

3.1 Composition

The material covered by this specification shall consist of a polychloroprene polymer suitably compounded and cured to meet the requirements of Sections 4 and 5 of this specification. No factice, reclaim or ground vulcanized waste shall be used. All ingredients of the mix shall be of recognised rubber quality and shall be free from foreign matter.

3.2 Freedom from defects

The selection and processing of the ingredients shall be such that the mix is homogeneous and that the parts made from its shall be free from surface imperfections, blisters, porosity, inclusions and undispersed ingredients and other defects which would impair satisfactory performance. It shall not show excessive bloom from sulphur or accelerators.

SECTION 4

Type approval of rubber compounds

4 Type approval

4.1 Before any particular rubber compound can be accepted as complying with the requirements of this specification, it shall have received type approval. To obtain such approval, the manufacturer (of the fully compounded stock) shall satisfy the type approval authority that the compound will meet all the requirements of this specification.

4.2 The type approval authority for material to this specification is:

Director, Materials Quality Assurance (DMQA),
Headquarters Building,
Royal Arsenal East,
Woolwich, London, SE18 6TD.

4.3 When applying for type approval the manufacturer shall submit the following:

4.3.1 Full details of the composition together with details of the standard vulcanizing conditions applicable to the test sheet. This information will be treated as confidential.

4.3.2 A sample of the vulcanized material consisting of two sheets, each in the form of a two-thickness test sheet, vulcanized at a temperature appropriate to the mix for a time appropriate to the thickness of the test sheet. No additional vulcanizing shall be given to the thicker portion of the test sheet. Each sheet shall be approximately 250mm square, 2.00 ± 0.15 mm thick, with a section along one side 35-50mm wide and 6.30 ± 0.15 mm thick.

If desired for the purpose of compression set tests, part of the 6.30mm thick section may be moulded in the form of cylindrical buttons conforming to the requirements of a Type 1 test piece as defined in B.S. 903: Part A6.

When such buttons are moulded, the cavities shall be individually charged with pellets and not by the flow of excess mix from the remainder of the mould. No additional vulcanizing shall be given to the buttons. The minimum number of buttons moulded shall be nine and they shall be in a group at one end of the thick section.

4.3.3 Test results on a sample identical to the one submitted and prepared from the same batch of material.

4.3.4 The proposed value for nominal density and, if required, nominal hardness (See Clause 1.2).

4.4 Tests

The tests listed in the Table shall be carried out on test pieces cut from the sample sheet specified in Clause 4.3.2. Each property of the material, when determined by the method given in the Table, shall comply with the requirement also listed in the Table.

No absolute limits are set for density but this shall be determined and a nominal value agreed between the manufacturer and the type approval authority.

4.5 After formal type approval has been given, no change in composition or test sheet vulcanizing conditions shall be made without the consent of the type approval authority.

4.6 Duration of Approval

Type approval shall last for a period of five years.

A manufacturer may then apply for re-approval with a submission following the requirements of the specification current at the time of re-submission.

Re-approval shall also last for five years.

There is no limit to the number of re-approvals possible, provided that the material complies with all the requirements of the specification current at each re-submission.

SECTION 5

Routine quality control

5 Frequency of testing

5.1 The first production batch and subsequently at least every tenth batch of mix shall be tested for compliance with the requirements of tests (a) to (h) inclusive of the Table by tests on a sample sheet as described in 4.3.2.

5.2 All other batches shall be similarly tested for compliance with the requirements of tests (a), (b), (e), and (f) of the Table.

5.3 The Quality Assurance Authority named in the contract may, at any time, require any batch to be checked for compliance with any requirement in the Table.

SECTION 6

Rubber items (parts or components)

6 Manufacture and inspection

6.1 Manufacture

Rubber items shall be manufactured from material which complies with all the requirements of Sections 3, 4 and 5 of this specification.

6.2 Inspection

If the finished items are required to comply with a specification relevant to that item, they shall be inspected and tested for compliance with the requirements of that specification. In the absence of such a specification, the following shall apply:

6.2.1 Sampling

Unless otherwise agreed with the customer or Quality Assurance Authority concerned, sample items shall be taken from each lot produced from each batch of mix.

6.2.2 Freedom from defects

Finished rubber items shall be free from surface imperfections, porosity, voids, inclusions, flow marks, inadequate joint of moulding blank, and other defects which would impair satisfactory performance, eg excessive grain in calendered sheet or extrusions. Surface finish shall be smooth, unless otherwise stated in the relevant drawing, contract or order, eg items may be specified with shallow cloth marking on one or more surfaces.

6.2.3 Dimensions

The dimensions and tolerances of finished rubber items shall be as stated on the relevant drawing, contract or order. Methods of measurement of dimensions shall be in accordance with BS. 3734 unless otherwise stated.

6.2.4 Physical tests

Sample items shall be tested as agreed with the customer or Quality Authority concerned, due regard being paid to whether standard test pieces can be obtained from them. The requirements for the results of such tests, if not complying with the requirements of the Table (eg where results are reported as apparent hardness or are obtained on test pieces which have been buffed during preparation), shall be agreed with the customer or Quality Assurance Authority concerned.

6.2.5 Chemical tests

Chemical analysis may be carried out on sample items, as practicable, to verify that the composition is essentially in accordance with Section 3.

6.3 Quality assurance documents

The manufacturer shall state on each quality assurance document (eg certificate of conformity) the part number, the specification number and grade, date of vulcanization (quarter and year), the item lot number, and composition reference (manufacturer's designation) of the rubber material used.

6.4 Packaging and identification

Unless otherwise stated on the drawing or in the contract or order, components shall be packaged and the package identified in accordance with the requirements of BS F69.

TABLE

Test	Test requirements					Test Method
	Grade 40	Grade 50	Grade 60	Grade 70	Grade 80	
(a) Hardness, IRHD	40+5 -4	50+5 -4	60+5 -4	70+5 -4	80+5 -4	Appendix I
(b) Density, Mg/m ³	Within ± 0.02 of the agreed value					BS 903: Part A1 Method A
(c) Tensile strength, MPa, min.	11.0	13.0	13.0	15.0	15.0	BS 903: Part A2 Dumb-bell test pieces
(d) Elongation at break, % min	550	450	350	250	150	
(e) Compression set, % max	25	25	20	20	20	Appendix II
(f) Resistance to liquids, volume change, % max, after immersion in Liquid B	100	90	75	70	70	BS 903: Part A16 Volumetric Method 24 hours at 40 \pm 1°C
(g) Resistance to heat ageing						BS 903: Part A19, Method A or B 168 hours at 100 \pm 1°C
(i) Change in hardness, IRHD max.	+6 -2	+4 -1	+4 -1	+4 -1	+4 -1	
(ii) Change in tensile strength, % of original value, max	+15 -10	+15 -5	+15 -5	+15 -5	+15 -5	
(iii) Change in elongation at break, % of original value, max.	+5 -20	+5 -20	+5 -20	+5 -15	+5 -15	
(h) Resistance to low temperature (°C)	-35	-35	-30	-30	-30	Appendix III
(j) Resistance to crystallisation, change in hardness, IRHD max	+5	+5	+5	+5	+5	BS 5294 168 hours at -10°C
(k) Freedom from adhesion to and corrosion of metals	No adhesion to the metal surfaces nor corrosion or pitting of the metal. Discoloration of the metal surfaces will not be considered objectionable.					Appendix IV
(l) Resistance to ozone	The test piece shall show no signs of cracking as defined in the test method.					BS 903: Part A23 72 hours, 20% extension, 50pphm, 30 \pm 1°C

APPENDIX I**Method for the determination of hardness**

- (i) Hardness measurements required for test (a) of the Table shall be made by Method N of BS 903: Part A26 using one specimen of the thicker part of the test sheet specified in clause 4.3.2 superimposed upon the thinner part of the same test sheet.
- (ii) For the determination of the change in hardness required for test (g) (i) of the Table, the measurements shall be carried out, before and after ageing, by Method N of BS 903: Part A26 using two specimens plied together, of the thinner part of the test sheet specified in clause 4.3.2

APPENDIX II**Method for the determination of compression set**

Compression set measurements shall be made by Method A of BS 903: Part A6, using Type I test pieces from the thicker section of the test sheet specified in clause 4.3.2. The test pieces shall be lubricated.

The time of test shall be 24 hours and the temperature during the compression period shall be $70 \pm 1^\circ\text{C}$.

APPENDIX III**Method for the determination of resistance to low temperature**

Two alternative procedures are permitted:

- 1 A temperature-retraction procedure according to BS 903 Part A29 using a retraction of 10%, ie the temperatures given in the Table are the TR 10 temperatures.
- 2 A determination of the stiffness of the vulcanized rubber at low temperature according to BS 903 Part A 13. The requirements are expressed in the Table as the temperatures at which the rigidity modulus shall not exceed 70 MPa.

The temperature-retraction procedure is the preferred test method, and shall be the procedure used in all cases of dispute.

APPENDIX IV**Method of test for freedom from adhesion to and corrosion of metals**

The test shall be made by Method A of BS 903 Part A37 with the following exception.

The surface of the metal test pieces shall be finished to a surface texture of $0.41\mu\text{CLA}$ (as defined in BS 1134) or better, before polishing with pumice powder which passes through a $53\mu\text{m}$ sieve.

Test conditions shall be $70^\circ\text{C} \pm 1^\circ\text{C}$ for 168 hours, using aluminium and carbon steel standard test metals.

Approved for issue,

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