

**Ministry of Defence  
Defence Procurement Agency, ADRP2  
Abbey Wood  
Bristol  
BS34 8JH**

## **OBSOLESCENCE NOTICE**

All DTD specifications were declared obsolescent from 1<sup>st</sup> 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**  
**ELASTOMERIC TOROIDAL SEALING RINGS (O RINGS)**  
**BUTADIENE-ACRYLONITRILE TYPE (MINERAL OIL RESISTANT)**

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*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 any existing British Standard (Aerospace Series) or to serve as a basis for inspection of material, the properties and uses of which are not sufficiently established to warrant submission to the British Standards Institution for standardization.*

*NOTE 2. 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 3. Further guidance on the choice of rubber for any particular purpose may be obtained from Appendix 1 of DR Mat Tech Memo No 7 - "Rubber in Engineering Design" and SBAC TS No 97 "Recommended Design Guide for Rubber Materials for Aerospace Applications".*

*NOTE 4. 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.*

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## SECTION 1

### Scope

#### 1.1 Scope

This specification defines the requirements for toroidal sealing rings ('O' rings) manufactured from materials which have been approved to D.T.D. 5594 - "Vulcanized Butadiene-Acrylonitrile Rubbers (Mineral Oil Resistant)". They may be used in reciprocating mechanisms or for static purposes particularly in contact with petroleum-based lubricants and hydraulic fluids (eg fluids complying with D.T.D. 585) within a temperature range of approximately -40°C up to 120°C for continuous operation.

*Note. At ordinary temperature 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

Four different hardness values are covered (Grades 60, 70, 80 and 90; Grade 60 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.

## SECTION 2

### Related Documents

Reference is made in this specification to the following:

- BS 903 - Methods of testing vulcanized rubber.
- BS 907 - Dial gauges for linear measurement.
- BS F69 - Packaging and identification of vulcanized rubber items.
- BS M48 - Dimensions of elastomeric toroidal sealing rings for aerospace use: inch series.
- DTD 5594 - Vulcanized Butadiene-Acrylonitrile Rubbers (Mineral Oil Resistant)
- SBAC TS49 - Elastomeric toroidal sealing rings ('O' rings), manufacturing and inspection standards for aerospace applications.

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 this specification. The Quality Assurance Authority will supply, on request, information concerning any changes that may be necessary due to cancellation, replacement, supersession or amendment of any related document.

## SECTION 3

### General Requirements

#### 3.1 Dimensions

The dimensions shall be in accordance with BS M48 or other approved specification, standard or drawing stated on the order.

#### 3.2 Freedom from Defects

The sealing rings shall be uniform in quality and condition, clean, smooth and free from foreign matter and imperfections detrimental to the performance of the parts as defined in SBAC TS 49.

## SECTION 4

### Type Approval

#### 4.1 Type Approval

Before sealing rings can be accepted as complying with the requirements of this specification, they shall have received type approval. To obtain such approval the manufacturer of the rings shall satisfy the type approving authority that type approval to DTD 5594 has been given for the particular compound and that the rings made from the compound will meet all the requirements of this specification.

#### 4.2 Type approving authority

The type approving authority for sealing rings to this specification is the Director/Aeronautical Quality Assurance Directorate Harefield House, Harefield, Uxbridge, Middlesex UB9 6BB.

#### 4.3 Test Samples

When applying for type approval the manufacturer shall submit the following.

4.3.1 The compound reference number approved to D.T.D 5594

4.3.2 A representative test sample, together with details of the curing conditions used, as follows:

- a. 30 rings (minimum) size 015 of BS M48, i.e. 1.78 mm section x 14 mm internal diameter,
- and b. 30 rings (minimum) size 215 of BS M48, i.e. 3.53 mm section x 26.57 mm internal diameter.

4.3.3 Test results on samples from the same lot as 4.3.2.

#### 4.4 Tests

All the tests listed in the Table shall be carried out on the samples specified in 4.3.2. Each property, when determined by the method given in the Table, shall comply with the requirement also listed in the Table.

4.5 After formal type approval has been given, no change in the compound or vulcanizing conditions shall be made without the consent of the type approving 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

5.1 Sealing rings shall be made only from compound which has satisfied the routine quality control requirements of D.T.D. 5594.

5.2 From every batch of rubber mix, samples from the first lot of finished rings shall be tested for compliance with the requirements of tests (a), (b), (c) and (d) of the Table, and samples from each subsequent lot of finished rings shall be tested for compliance with the requirements of tests (a) and (c) of the Table.

- 5.3** As an alternative to 5.1, where batches of mix are intended solely for the manufacture of rings to this specification, the first production batch of rubber mix and subsequently at least every tenth batch of rubber mix shall be tested in accordance with the appropriate routine quality control requirements of DTD 5594 and shall comply with the test requirements.

For all other batches of rubber mix, provided that the rings are sampled and tested as specified in 5.2, the testing of sample sheets may be dispensed with, but a test sheet must nevertheless be available for the Quality Assurance Authority.

- 5.4** The Quality Assurance Authority may, at any time, require any of the tests listed in the Table to be carried out on further rings in addition to those specified in 5.2.

*NOTE* The term 'lot of finished rings' is defined as a number of rings from the same batch of rubber mix cured in the same production run. A production run is defined as a continuous operation interrupted only by normal working breaks and may include the concurrent or consecutive operation of different moulds to produce rings of different sizes.

## SECTION 6

### 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 compound reference (manufacturer's designation) of the rubber material used.

## SECTION 7

### Packaging and Identification

Unless otherwise stated on the drawing or in the order or contract, the 'O' rings shall be packaged and the page identified in accordance with the requirements of BS F69.

**TABLE**

Test	Test Requirement					Test Method
	Cross section (mm)	Grade 60	Grade 70	Grade 80	Grade 90	
(a) Apparent hardness, IRHD	1.70 to 2.79	60 + 5 - 12	70 + 5 - 12	80 + 5 - 12	90 + 3 - 8	Appendix I
	over 2.79	60 + 5 - 10	70 + 5 - 10	80 + 5 - 10	90 + 3 - 7	
(b) Density, Mg/m <sup>3</sup>	All Sections	Within ±0.02 of the agreed value				BS 903 Part A1 Method A
(c) Compression Set, % max	1.70 to 2.79	28	23	23	23	Appendix II
	Over 2.79	25	20	20	20	
(d) Resistance to liquids, volume change, % max.	All Sections	+5 +25	+5 +23	+5 +18	+0 +15	Appendix III

## APPENDIX I

### Method for the Determination of Apparent Hardness

Hardness measurements required for test (a) shall be made by Method CM of BS 903 Part A26, except that wax shall not be used to locate the test piece. Three test pieces shall be used.

## APPENDIX II

### Method for the Determination of Compression Set

Compression set measurements shall be made by Method A of BS 903 Part A6 with the following modifications necessitated by the use of sealing rings as test pieces:

#### i Thickness Gauge

One of the following measuring instruments shall be used:

- a. An electronic thickness comparator firmly held in a rigid stand over a flat base plate not less than 50 mm in any direction, and having a moving contact member with a flat circular contact area of diameter  $5 \text{ mm} \pm 0.05 \text{ mm}$ . The force exerted by the moving contact member shall be  $0.85 \text{ N} \pm 0.03 \text{ N}$ .
- b. A dial gauge firmly held in a rigid stand above a flat base plate not less than 50 mm in any direction, and having a moving contact member with a flat circular contact area of diameter  $5 \text{ mm} \pm 0.05 \text{ mm}$ . The gauge shall have a scale graduated in unit divisions of 0.01 mm and shall comply where relevant with the requirements of BS 907. The force exerted by the moving contact member shall be  $0.85 \text{ N} \pm 0.03 \text{ N}$ .

Both instruments shall be capable to measuring to an accuracy of  $\pm 0.005 \text{ mm}$ . (NOTE: This applies to the instruments only, not to their capability of measuring 'O' ring cross sections.)

#### ii Test Pieces

In the case of sealing rings having an internal diameter of 13 mm or greater the test piece shall consist of a section approximately 25 mm in length cleanly cut from a ring by straight cuts across the cord of the ring. In the case of sealing rings having an internal diameter of less than 13 mm, the test piece shall be a whole ring vented by a single cut through the cord section. The variation in cord diameter along the length of the test piece shall not exceed  $\pm 2\%$  of the nominal cord diameter.

Three test pieces shall be used for each determination.

#### iii Measurement of the Test Pieces

The cord diameter of each test piece shall be measured at a marked point approximately midway along its length, the measurement being made across the cord diameter at right angles to the plane of the ring (designated 'W' in BS M48). If an instrument with a moving contact member is used, the axis of movement shall be vertical and in line with the dimension being measured.

The measurement shall be taken as the original test piece thickness ( $t_o$ ). The thickness of the test piece after recovery ( $t_r$ ) shall be measured in a similar manner at the same point.

The ink or other agent used for marking shall have no deleterious effect on the rubber and shall be of contrasting colour to that of the rubber. It shall be so applied that it does not come into contact with the plates when the 'O' rings are under compression.

#### iv Spacers

The spacer(s) shall be chosen so that each test piece shall be compressed to a value ( $t_s$ ) of  $75 \pm 2\%$  of its original thickness.  $t_s$  shall be measured to an accuracy of  $\pm 0.01 \text{ mm}$ .

Where more than one spacer is used in the same jig space they shall not vary in thickness by more than  $\pm 0.01 \text{ mm}$ .

The test pieces shall not be lubricated.

The duration of the compression period shall be 24 hours, and the temperature shall be  $100^\circ \pm 2^\circ \text{C}$ .

## APPENDIX III

### Method for the determination of resistance of liquids

3. Volume change measurements shall be made by the volumetric method of BS 903 Part A16, using Oil No.

The temperature of test shall be  $40^\circ \pm 1^\circ \text{C}$ , and the period of immersion 48 hours.

Approved for issue:

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