

**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)**  
**FLUROSILICONE TYPE**

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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 an 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 application may be obtained from Appendix 1 of DR Nat Tech Memo No 7-“ Rubber in Engineering Design ” and SBAC TS No 97 “ Recommended Design Guide for Rubber Materials for Aerospace Applications ”.*

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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 DTD 5583- “ Vulcanized Fluorosilicone Rubbers ”. They may be considered for long periods of use in applications with petroleum based fuels, hydraulic liquids and lubricants, and with silicone and certain ester based liquids (but excluding certain phosphate esters) within the temperature range -60°C to 150°C.

They are also suitable for use in air within the temperature range -60°C to 180°C for long periods and up to 200° C for intermittent periods.

They are generally not satisfactory for dynamic applications.

*NOTE. At ordinary temperatures and in the absence of hostile environments, e.g. when properly stored, these rubbers deteriorate only very slowly. For most practical purposes the effect is insignificant and storage life may be considered indefinite. 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**

Three different hardness values are covered (Grades 60, 70 and 80; Grade 60 being the softest) and the grade required must therefore be stated on all drawings and contracts.

**SECTION 2**

**Related Documents**

Reference is made in this specification to the following:

- BS 903 -Methods of testing vulcanized rubber.
- BS F69 -Packaging and identification of vulcanized rubber items.
- BS M48 -Dimensions of elastomeric toroidal sealing rings for aerospace use: inch series.
- DTD 5583 -Vulcanized fluorosilicone rubbers.
- SBAC TS 49 -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 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 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 Quality Assurance Authority that type approval to DTD 5583 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 The Quality Assurance Authority for sealing rings to this specification is the Director/Aeronautical Quality Assurance Directorate (PQO/NM1), Harefield House, Harefield, Uxbridge, Middlesex UB9 6BB.

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

4.3.1 The compound reference number approved to DTD 5583 and its agreed nominal density.

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

- (a) 18 rings (minimum) size 015 of BS M48, i.e. 1.78 mm section x 14.00 mm internal diameter;
- and (b) 12 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 those specified in 4.3.2.

#### 4.4 Tests

All the tests listed in the Table shall be carried out on the samples listed 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 Quality Assurance Authority.

## SECTION 5

### Routine Quality Control

5.1 Sealing rings shall be made only from compound which has satisfied the routine quality control requirements of DTD 5583.

5.2 From each batch of mix, samples from the first lot of finished rings shall be subjected to tests (a), (b), (c) and (d) of the Table and samples from each subsequent lot of finished rings shall be subjected to tests (a) and (c) of the Table, and in each case shall comply with the relevant test requirements.

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 and subsequently at least every tenth batch shall be tested in accordance with the appropriate routine quality control requirements of DTD 5583 and shall comply with the test requirements. For all other batches, provided that the rings made from such batches are sampled and tested as specified in 5.2, the testing of sample test 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 specified 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 (e.g. release note) the part number, the specification number and grade, date of vulcanization (quarter and year), the item lot number, and compound reference number (manufacturer's designation) of the rubber material used.

**SECTION 7****Packaging and Identification**

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

TABLE

Test	Test requirements				Test method
	Cross section (mm)	Grade 60	Grade 70	Grade 80	
(a) Apparent hardness, I.R.H.D.	1·70 to 2·79 over 2·79	60+ 5 -12 60+ 5 -10	70+ 5 -12 70+ 5 -10	80+ 5 -12 80+ 5 -10	Appendix I
(b) Density, Mg/m <sup>3</sup>	Within $\pm 0\cdot05$ of the agreed value				BS 903: Part A1 Method A
(c) Compression set, % max	All sizes	20	25	25	Appendix II
(d) Resistance to liquids Volume change after immersion in test liquid % max	1·70 to 2·79 over 2·79	-0 +30 -0 +25	-0 +30 -0 +25	-0 +25 -0 +25	Appendix III

## APPENDIX I

### Method for the determination of 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. The test pieces shall be conditioned before test by heating in air at 200°C for one hour and allowed to cool to room temperature in a dessicator.

The rings used to determine hardness shall not be used for other tests required by the specification.

## 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 having a fixed contact member with horizontal dimensions of not less than 50 mm in any direction and a moving contact member with a contact foot not less than 2 mm nor more than 4 mm in diameter, both members having flat surfaces parallel to one another. The moving member shall exert a force of not less than 0.15 N nor more than 0.22 N per mm of the diameter of the foot.
- (b) A dial gauge having fixed and moving contact members as described in (a), the moving member being loaded such as to exert a force of not less than 0.15 N nor more than 0.22 N per mm of the diameter of the foot.
- (c) A precision micrometer having flat parallel anvils of between 2 mm and 6.5 mm diameter used as a "go/no go" gauge, the distance between the anvils being set such that the test piece when inserted between the anvils gives barely perceptible friction. (*NOTE. This method, whilst capable of being used to the required degree of accuracy, does require some operator experience to give consistent and accurate results.*)

All the instruments shall be capable of measuring to an accuracy of  $\pm 0.005$  mm.

(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 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 ( $t_0$ ). 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  $\pm 0.005$  mm.

Where more than one spacer is used in the same jig space they shall not vary in thickness by more than  $\pm 0.005$  mm.

The test pieces shall not be lubricated.

The duration of the compression period shall be 24 hours and the temperature during the compression period shall be  $150 \pm 2^\circ \text{C}$ .

*NOTE. At the test temperature rubbers complying with the requirements of this specification may in time cause discolouration, etching or corrosion of the clamping surfaces, and these should be periodically cleaned.*

**APPENDIX III****Method for the determination of resistance to liquids**

Volume change measurements shall be made by the Volumetric Method of BS 903, Part A16, using Liquid B. The temperature of test shall be  $40^{\circ}\pm 1^{\circ}\text{C}$  and the period of immersion 48 hours.

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Approved for issue,

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