



AEROSPACE MATERIAL SPECIFICATIONS

SOCIETY OF AUTOMOTIVE ENGINEERS, Inc.

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AMS 3657

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Revised

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POLYTETRAFLUOROETHYLENE EXTRUSIONS Premium Strength, As Sintered, Radiographically Inspected

1. **ACKNOWLEDGMENT:** A vendor shall mention this specification number in all quotations and when acknowledging purchase orders.
2. **FORM:** Extruded rods, tubes, and shapes.
3. **APPLICATION:** Primarily for parts, such as seals, bearings, insulators, and back-up rings, for use up to 260 C (500 F) requiring chemical inertness with higher mechanical and electrical properties than AMS 3656. When dimensional stability is important, material may be stress-relief annealed but best results will be obtained by machining almost to size, stress-relief annealing, and taking a thin finishing cut.
4. **MATERIAL:** Shall be extruded from polytetrafluoroethylene powder without admixture of fillers, pigments, or adulterants.
5. **TECHNICAL REQUIREMENTS:**
 - 5.1 **General:**
 - 5.1.1 **Color:** May vary from white to mottled gray or brown. Small gray, brown, or black spots shall not in themselves be cause for rejection.
 - 5.2 **Properties:** The product shall conform to the following requirements; tests shall be performed on the product supplied and in accordance with the issue of specified ASTM methods listed in the latest issue of AMS 2350 insofar as practicable.

5.2.1 Tensile Strength at 23 C \pm 1 (73.4 F \pm 1.8), psi, min	See Note 1
Nominal Diameter, Inches	
Up to 0.500, excl, and all tubes	1800
0.500 to 1.500, incl	1900
Over 1.500	2000
 - 5.2.2 Elongation at 23 C \pm 1
(73.4 F \pm 1.8), %, min
 - 5.2.3 Specific Gravity at 23 C/23 C
(73.4 F/73.4 F)
 - 5.2.1 **Tensile Strength at 23 C \pm 1**
(73.4 F \pm 1.8), psi, min
 - 5.2.2 **Elongation at 23 C \pm 1**
(73.4 F \pm 1.8), %, min
 - 5.2.3 **Specific Gravity at 23 C/23 C**
(73.4 F/73.4 F)

5.2.4 Dielectric Strength (Short time test),
v per mil, minASTM D149
(See Note 2)

Nominal Diameter, Inches	
Up to 0.500, excl and all tubes	700
0.500 to 1.500, incl	750
Over 1.500	800

Note 1. Tensile strength and elongation shall be determined in accordance with ASTM D638 using a testing speed of 2 in. per min. and measuring elongation over a 2 in. gage length. The test specimen for rod shall conform to Fig. 1 of this specification except that rods 0.250 in. and under in diameter may be tested in full cross-section.

Note 2. Specimens shall be 0.040 in. \pm 0.001 thick. Test under oil using 1/16 in. diameter corrosion resistant steel electrodes with rounded edges. If flashover is a problem on small diameter rod, specimens shall be prepared by drilling holes from opposite ends of a rod section, leaving a web 0.040 in. \pm 0.001 thick in the middle of the specimen. Electrodes shall be the same as used for the wafer specimen and shall be inserted in the holes in the specimen.

5.3 Voids: The product shall be subjected to radiographic inspection. Standards for acceptance and rejection shall be as agreed upon by purchaser and vendor.

6. QUALITY: The product shall be uniform in quality and condition, clean, smooth, and free from foreign materials and from imperfections detrimental to fabrication, appearance, or performance of parts.

7. TOLERANCES: Unless otherwise specified, the following tolerances apply at 23 - 30 C (73.4 - 86 F):

7.1 Rod:

Nominal Diameter Inches	Tolerance, Inch Plus Only
Up to 0.250, incl	0.008
Over 0.250 to 0.500, incl	0.016
Over 0.500 to 0.750, incl	0.020
Over 0.750 to 1.000, incl	0.024
Over 1.000 to 1.250, incl	0.030
Over 1.250 to 1.500, incl	0.038
Over 1.500 to 1.750, incl	0.046
Over 1.750 to 2.000, incl	0.052
Over 2.000 to 2.250, incl	0.068
Over 2.250 to 2.500, incl	0.076

7.2 Tubing:

Nominal OD or ID Inches	ID Tolerance, Inch Minus Only	OD Tolerance, Inch Plus Only
Over 0.187 to 2, incl	0.062	0.062

8. REPORTS:

8.1 Unless otherwise specified, the vendor of the product shall furnish with each shipment three copies of a report stating that the product conforms to the requirements of this specification. This report shall include the purchase order number, material specification number, vendor's compound number, form or part number, and quantity.