

AEROSPACE MATERIAL SPECIFICATION



AMS 3670/3B

Issued JAN 1981
Revised APR 1995

Reaffirmed JUN 2004

Superseding AMS 3670/3A

Polyamide-Imide Bar, Rod, and Shapes 12% Graphite - 3% Polytetrafluoroethylene Filled

1. SCOPE:

1.1 Form:

This specification covers a polyamide-imide plastic filled with graphite and polytetrafluoroethylene (PTFE) in the form of molded or extruded bar, rod, and shapes.

1.2 Application:

These products have been used typically for parts requiring low coefficient of friction, wear resistance, thermal resistance, and toughness up to 250 °C (482 °F), but usage is not limited to such applications.

2. APPLICABLE DOCUMENTS:

See AMS 3670.

3. TECHNICAL REQUIREMENTS:

3.1 Basic Specification:

The complete requirements for procuring the product described herein shall consist of this document and the latest issue of the basic specification, AMS 3670.

3.2 Material:

Shall be a molded, polyamide-imide polymer filled with 12% $\pm$ 3 by weight graphite and 3% $\pm$ 1 by weight polytetrafluoroethylene (PTFE).

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3.3 Properties:

The product shall conform to the requirements shown in Table 1, determined on injection-molded, post-cured test specimens and in accordance with specified test methods. Specimens for elevated temperature tests shall be held at the test temperature for not less than 30 minutes prior to testing. Values for tensile strength, elongation, flexural strength, and compressive strength shall be reported as the average of three determinations for each test; no individual value shall be less than 90% of the minimum average value specified.

TABLE 1 - Properties

	Property	Requirement	Test Method
3.3.1	Color	Black, as approved on preproduction sample	
3.3.2	Tensile Strength, min average At 23 °C ± 1 (73 °F ± 2) At 250 °C ± 5 (482 °F ± 9)	16.5 ksi (114 MPa) 5000 psi (34.5 MPa)	ASTM D 1708
3.3.3	Elongation, min average At 23 °C ± 1 (73 °F ± 2)	5%	ASTM D 1708
3.3.4	Flexural Strength, min average At 23 °C ± 1 (73 °F ± 2) At 250 °C ± 5 (482 °F ± 9)	23.0 ksi (159 MPa) 5000 psi (34.5 MPa)	ASTM D 790 or ASTM D 790M
3.3.5	Compressive Strength, min average At 23 °C ± 1 (73 °F ± 2)	18.0 ksi (124 MPa)	ASTM D 695 or ASTM D 695M
3.3.6	Specific Gravity at 23/23 °C (73/73 °F)	1.43 to 1.48	ASTM D 792 Method A

4. QUALITY ASSURANCE PROVISIONS:

See AMS 3670.

5. PREPARATION FOR DELIVERY:

See AMS 3670.

6. ACKNOWLEDGMENT:

See AMS 3670.