

**AEROSPACE  
MATERIAL  
SPECIFICATION**

**AMS 3136C**  
Superseding AMS 3136B

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COATING MATERIAL, PHENOLIC RESIN  
PTFE Pigmented, 150°C (300°F) Cure

1. SCOPE:

1.1 Type: This specification covers a phenolic-resin-base coating material pigmented with polytetrafluorethylene resin, supplied in kit form.

1.2 Application: Primarily for use where lubricity is required on materials not adversely affected by the 300°F (150°C) curing temperature.

2. APPLICABLE DOCUMENTS: The following publications form a part of this specification to the extent specified herein. The latest issue of Aerospace Material Specifications (AMS) shall apply. The applicable issue of other documents shall be as specified in AMS 2350.

2.1 SAE Publications: Available from SAE, 400 Commonwealth Drive, Warrendale, PA 15096.

2.1.1 Aerospace Material Specifications:

AMS 2350 - Standards and Test Methods  
AMS 2825 - Material Safety Data Sheets

2.2 ASTM Publications: Available from American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.

ASTM B117 - Salt Spray (Fog) Testing

2.3 U.S. Government Publications: Available from Commanding Officer, Naval Publications and Forms Center, 5801 Tabor Avenue, Philadelphia, PA 19120.

2.3.1 Federal Specifications:

PPP-P-1892 - Paint, Varnish, Lacquer, and Related Materials; Packaging, Packing, and Marking of

## 3. TECHNICAL REQUIREMENTS:

### 3.1 Material:

- 3.1.1 Composition: Shall consist of a two-part formulation, one part being a phenolic resin base with dye and dispersing agents and the other being colloidal dispersion of polytetrafluorethylene (PTFE) with necessary wetting and dispersing agents. After mixing in accordance with manufacturer's recommendations, the mixed product shall conform to the following, by weight:

|             |          |
|-------------|----------|
| Nonvolatile | 19 - 21% |
| Volatile    | 79 - 81% |

- 3.1.1.1 The composition of the individual components shall be as follows:

3.1.1.1.1 Phenolic Resin Component (by weight):

|             |          |
|-------------|----------|
| Nonvolatile | 10 - 12% |
| Volatile    | 88 - 90% |

- 3.1.1.1.1.1 Nonvolatile: Shall be a thermosetting phenolic resin with dye and dispersing agents.

- 3.1.1.1.1.2 Volatile: Shall be an organic solvent composed of alcohols, esters, and diluents.

3.1.1.1.2 PTFE Pigment Component (by weight):

|             |          |
|-------------|----------|
| Nonvolatile | 59 - 61% |
| Volatile    | 39 - 41% |

- 3.1.1.1.2.1 Nonvolatile: Shall be polytetrafluoroethylene resin particles with necessary wetting agents and dispersing agents.

- 3.1.1.1.2.2 Volatile: Shall be water.

- 3.1.2 Shelf Life: The PTFE pigment component shall show no evidence of gelation after storage for at least 60 days at  $25^{\circ}\text{C} \pm 1$  ( $77^{\circ}\text{F} \pm 2$ ) in a full, closed container and, at the end of this period, shall produce a uniform dispersion free from curds when mixed with the phenolic resin component in accordance with manufacturer's recommendations.

- 3.1.3 Pot Life: After mixing in accordance with manufacturer's recommendations, the mixed product, in 100-g batches, shall have a useful pot life of not less than 22 hr when maintained at  $15^{\circ} - 27^{\circ}\text{C}$  ( $60^{\circ} - 80^{\circ}\text{F}$ ).

- 3.2 Properties: The product shall conform to the following requirements:

- 3.2.1 Curing: When mixed and applied in accordance with manufacturer's recommendations and cured at  $150^{\circ}\text{C} \pm 5$  ( $300^{\circ}\text{F} \pm 10$ ) for  $1 \text{ hr} \pm 0.1$ , the phenolic resin shall polymerize to produce a coating with a uniform dispersion of polytetrafluoroethylene resin solids.
- 3.2.2 Corrosion Resistance: A low-carbon steel panel with a cured coating  $0.0002 - 0.0007 \text{ in.}$  ( $5 - 18 \mu\text{m}$ ) thick shall show no evidence of deterioration of the coating or corrosion of the basis metal after exposure for not less than 100 hr to salt spray test conducted in accordance with ASTM B117.
- 3.2.3 Heat Resistance: The coating shall show no evidence of chalking, blistering, or loss of adhesion after exposure for not less than 100 hr at  $175^{\circ}\text{C} \pm 2$  ( $350^{\circ}\text{F} \pm 5$ ).
- 3.2.4 Adhesion: An anodized aluminum alloy test panel with a cured coating  $0.0002 - 0.0007 \text{ in.}$  ( $5 - 18 \mu\text{m}$ ) thick shall have one half of its surface immersed in distilled water at room temperature for  $24 \text{ hr} \pm 0.2$ . The panel shall then be removed and wiped dry with a soft cloth. Immediately thereafter, two parallel scratches  $1 \text{ in.}$  ( $25 \text{ mm}$ ) apart shall be made by a sharp stylus on the coated surface subjected to immersion. Within 1 min. after the panel has been removed from the water, a piece of pressure-sensitive, paper masking tape shall be placed across the two scratches and sufficient pressure applied to ensure adhesion. Removal of the tape, using an abrupt motion, shall cause no separation of the coating from the basis metal.
- 3.2.5 Coefficient of Friction: The cured coating shall have a coefficient of friction not greater than 0.1, determined at a speed of 25 fpm ( $127 \text{ mm/sec}$ ) and a force of 10 lb ( $44.5 \text{ N}$ ) on a Timken Tester, or equivalent, at  $20^{\circ} - 30^{\circ}\text{C}$  ( $70^{\circ} - 85^{\circ}\text{F}$ ).
- 3.3 Quality: The cured coating shall be smooth, uniform, and free from tackiness, craters, pin holes, sags, runs, bubbles, heavy edges, and other imperfections detrimental to usage of coated parts.

#### 4. QUALITY ASSURANCE PROVISIONS:

- 4.1 Responsibility for Inspection: The vendor of the coating material shall supply all samples for vendor's tests and shall be responsible for performing all required tests. Results of such tests shall be reported to the purchaser as required by 4.5. Purchaser reserves the right to sample and to perform any confirmatory testing deemed necessary to ensure that the coating material conforms to the requirements of this specification.
- 4.2 Classification of Tests:

4.2.1 Acceptance Tests: Tests to determine conformance to requirements for composition (3.1.1), pot life (3.1.3), curing (3.2.1), and adhesion (3.2.4) are classified as acceptance tests and shall be performed on each lot.

4.2.2 Preproduction Tests: Tests to determine conformance to all technical requirements of this specification are classified as preproduction tests and shall be performed prior to or on the initial shipment of coating material to a purchaser, when a change in material or processing, or both, requires reapproval as in 4.4.2, and when purchaser deems confirmatory testing to be required.

4.2.2.1 For direct U.S. Military procurement, substantiating test data and, when requested, preproduction test material shall be submitted to the cognizant agency as directed by the procuring activity, the contracting officer, or the request for procurement.

4.3 Sampling: Shall be as follows:

4.3.1 For Acceptance Tests: Sufficient coating material shall be taken at random from each lot to perform the following tests:

| Requirement | Reference Paragraph | Number of Determinations |
|-------------|---------------------|--------------------------|
| Composition | 3.1.1               | 1                        |
| Pot Life    | 3.1.3               | 1                        |
| Curing      | 3.2.1               | 2 (See 4.3.1.1)          |
| Adhesion    | 3.2.4               | 2                        |

4.3.1.1 This requirement is to be determined on the panels prepared for the adhesion test.

4.3.1.2 A lot shall be all coating material produced in one continuous manufacturing operation from the same lots of raw materials and presented for vendor's inspection at one time.

4.3.1.3 When a statistical sampling plan and acceptance quality level (AQL) have been agreed upon by purchaser and vendor, sampling shall be in accordance with such plan in lieu of sampling as in 4.3.1 and the report of 4.5 shall state that such plan was used.

4.3.2 For Preproduction Tests: As agreed upon by purchaser and vendor.

4.4 Approval:

4.4.1 Coating material shall be approved by purchaser before coating material for production use is supplied, unless such approval be waived by purchaser. Results of tests on production coating material shall be essentially equivalent to those on the approved sample.