INTERNATIONAL STANDARD

ISO 6118

Second edition
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Road vehicles — Elastomeric cups and seals for cylinders for hydraulic braking systems using a non-petroleum base hydraulic brake fluid (service temperature 70 °C max.)

Véhicules routiers — Coupelles et joints en élastomère pour cylindres de systèmes de freinage hydrauliques utilisant un liquide de frein à base non pétrolière (température maximale d'utilisation: 70 °C)

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Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 2.

The main task of technical committees is to prepare International Standards. Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

ISO 6118 was prepared by Technical Committee ISO/TC 22, *Road vehicles*, Subcommittee SC 2, *Braking systems and equipment*.

This second edition cancels and replaces the first edition (ISO 6118:1980), which has been technically revised.

Road vehicles — Elastomeric cups and seals for cylinders for hydraulic braking systems using a non-petroleum base hydraulic brake fluid (service temperature 70 °C max.)

1 Scope

This International Standard specifies performance tests of brake cups and seals for hydraulic braking systems for road vehicles. It does not include requirements relating to chemical composition, tensile strength and elongation of the rubber compound. Disc brake seals are not covered by this International Standard.

This International Standard is applicable to moulded seals (cups or double-lipped type gland seals), 60 mm in diameter and smaller, compounded from rubber, for use in hydraulic actuating cylinders employing road vehicle non-petroleum base hydraulic brake fluid conforming to the requirements of ISO 4925.

NOTE The rubber used in these seals shall be suitable for operation in a temperature range of −40 °C to +70 °C.

2 Normative references

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 48, *Rubber, vulcanized or thermoplastic — Determination of hardness (hardness between 10 IRHD and 100 IRHD)*

ISO 188:1998, *Rubber, vulcanized or thermoplastic — Accelerated ageing and heat resistance tests*

ISO 4925, *Road vehicles — Specification of non-petroleum-base brake fluids for hydraulic systems*

ISO 4926, *Road vehicles — Hydraulic braking systems — Non-petroleum base reference fluids*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

3.1
sloughing
release of carbon black on the surface of the rubber

3.2
scoring
formation of grooves in the rubber, parallel to the direction of travel of the piston or seal

3.3
scuffing
visible erosion of the outer surface of the rubber

4 General requirements

4.1 Workmanship and finish

Seals shall be free from blisters, pin-holes, cracks, protuberances, embedded foreign material or other physical defects which can be detected by thorough inspection, and shall conform to the dimensions specified on the drawings.

4.2 Marking

The identification mark of the manufacturer and other details as specified on drawings shall be moulded into each seal. Each seal in conformity with this International Standard may also have the following mark: “ISO 6118”.

4.3 Packaging

Seals shall be packaged to meet requirements specified by the purchaser.

4.4 Sampling

The minimum lot on which complete specification tests shall be conducted for quality control testing, or the frequency of any specific type test used to control production, shall be agreed upon by the manufacturer and the purchaser.

5 Test requirements

5.1 Resistance to fluid at elevated temperature

After being subjected to the test for resistance to compatibility fluid at elevated temperature as prescribed in 6.1, the seals shall conform to the requirements specified in Table 1, and shall show no excessive disintegration as evidenced by blisters or sloughing.

Table 1 — Requirements for fluid resistance at elevated temperature (70 °C)

Characteristics	Permitted change
Volume	From 0,0 % to +16,0 %
Outside diameter, lip	From 0,0 % to +5,75 %
Outside diameter, base	
Hardness	From −10 IRHD to 0 IRHD

5.2 Precipitation

Not more than 0,3 % sediment by volume shall be formed in the centrifuge tube after the seals have been tested as specified in 6.2.

5.3 Wheel cylinder seals heat pressure stroking

5.3.1 General

Wheel cylinder seals when tested by the procedure specified in 6.3 shall meet the performance requirements specified in 5.3.2 to 5.3.6.

5.3.2 Lip diameter change

The minimum lip diameter of wheel cylinder seals after the stroking test shall be greater than the wheel cylinder bore by the minimum dimensions specified in Table 2.

Table 2 — Lip diameter change of wheel cylinder seals

Dimensions in millimetres

Diameter of wheel cylinder bore	Minimum excess over bore
$\leqslant$ 19,05	0,40
$>$ 19,05 $\leqslant$ 25,4	0,50
$>$ 25,4 $\leqslant$ 38,1	0,65
$>$ 38,1 $\leqslant$ 60	0,75

5.3.3 Leakage

No constant dampness past the seals and no fluid discoloration of the filter paper on two or more inspections shall occur.

5.3.4 Corrosion

Pistons and cylinder bore shall not show corrosion, as evidenced by pitting, to an extent discernible to the naked eye, but staining or discoloration shall be permitted.

5.3.5 Change in hardness

Rubber seals shall not decrease in hardness by more than 10 IRHD when tested in accoprdance with the procedure specified in 6.7.

5.3.6 Condition of test seals

Wheel cylinder seals shall not show excessive deterioration such as scoring, scuffing, blistering, cracking, chipping (heel abrasion) or change in shape from original appearance.

5.4 Master cylinder seals heat pressure stroking

5.4.1 General

Master cylinder seals when tested by the procedure specified in 6.4 shall meet the performance requirements specified in 5.4.2 to 5.4.6.

5.4.2 Lip diameter change

The minimum lip diameter of master cylinder seals after the stroking test shall be greater than the master cylinder bore by the minimum dimensions specified in Table 3.

Table 3 — Lip diameter change of master cylinder seals

Dimensions in millimetres

Diameter of wheel cylinder bore	Minimum excess over bore
$\leqslant$ 19,05	0,30
$>$ 19,05 $\leqslant$ 25,4	0,40
$>$ 25,4 $\leqslant$ 38,1	0,50
$>$ 38,1 $\leqslant$ 60	0,65

5.4.3 Leakage

Same requirement as specified for wheel cylinder seals shall be applied (see 5.3.3).

5.4.4 Corrosion

Same requirement as specified for wheel cylinder seals shall be applied (see 5.3.4).

5.4.5 Change in hardness

Same requirement as specified for wheel cylinder seals shall be applied (see 5.3.5).

5.4.6 Condition of the test seals

Same requirement as specified for wheel cylinder seals shall be applied (see 5.3.6).

5.5 Low temperature performance

5.5.1 Leakage

No leakage of fluid shall occur when seals are tested according to the procedure specified in 6.5.1.

5.5.2 Bend test

The seal shall not crack and shall return to its approximately original shape within 1 min when tested in accordance with the procedure specified in 6.5.2.

5.6 Oven ageing

5.6.1 General

Seals when tested according to the procedure specified in 6.6 shall meet the requirements specified in 5.6.2 and 5.6.3.

5.6.2 Change in hardness

The change in hardness shall be within the limits of $\pm$5 IRHD.

5.6.3 Condition of the test seals

The seal shall show no evidence of deterioration, or change in shape from original appearance.

5.7 Corrosion

5.7.1 General

Seals when tested in accordance with the procedure specified in 6.8 shall meet the requirements specified in 5.7.2 and 5.7.3.

5.7.2 Corrosion of metal strips

The seals shall not cause corrosion exceeding the limits shown in Table 4. The metal strips outside of the area where the strips are in contact shall be neither pitted nor roughened to the extent discernible to the naked eye, but staining or discoloration is permitted.

Table 4 — Permissible change in mass of corrosion test strips

Test strips	Permissible change in mass mg/cm^2 of surface
Tinned iron	±0,2
Steel	±0,2
Aluminium	±0,1
Cast iron	±0,2
Brass	±0,4
Copper	±0,4
Zinc	±0,4

5.7.3 Fluid-water mixture characteristics

The fluid-water mixture at the end of the test shall show no gelling at 23 °C ± 5 °C. No crystalline-type deposits shall form and adhere to either the glass wall or the surface of metal strips. The fluid-water mixture shall contain no more than 0,2 % sediment by volume.

5.8 Storage corrosion test

After 12 cycles in the humidity cabinet when operated in accordance with the procedure specified 6.9, there shall be no evidence of corrosion adhering to or penetrating the wall of the cylinder bore that was in contact with the test seal.

Slight discoloration (staining) or any corrosion or spots away from the contact surface of the test seals may be permissible.

6 Test procedures

6.1 Resistance to fluid at elevated temperature — Dimensional test

6.1.1 Apparatus and material

The following apparatus and material shall be used for the test.

6.1.1.1 Micrometer, shadowgraph or other suitable apparatus, to measure accurately to 0,02 mm.

6.1.1.2 Glass container, of capacity approximately 250 ml and diameter 50 mm, which can be tightly sealed.

6.1.1.3 Chemical balance, capable of weighing to 1 mg.

6.1.1.4 Oven, uniformly heated dry air type, conforming to the requirements for method B of ISO 188:1998.

6.1.1.5 Two glass-stoppered weighing bottles, of adequate mouth size to hold the seals under test.

6.1.1.6 Isopropyl or ethyl alcohol, of 95 % (by volume) reagent grade for washing purpose.

6.1.2 Test specimens

Two seals shall be used for testing at 70 °C.

6.1.3 Test procedure

Rinse the cups in the alcohol (6.1.1.6) and wipe dry with a clean, lint-free cloth to remove dirt and packing debris. Do not leave the seals in the alcohol for more than 30 s.

Measure the lip and base diameters to the nearest 0,02 mm, taking the average of two readings at right angles to one another. Take care when measuring the diameters before and after ageing that the measurements are made in the same manner and at the same locations.

Determine and record the initial hardness of the test seals. (See 6.7 and Figure 3.)

Determine the volume of each seal in the following manner: weigh the seals in air (m_1) to the nearest 0,001 g and then weigh the seals immersed in distilled water at room temperature (m_2). Quickly dip each specimen in alcohol and then blot dry with filter paper free of lint and foreign material.

Immerse two seals completely in 75 ml $\pm$ 1 ml of compatibility reference fluid as defined in ISO 4926, in the glass container (6.1.1.2) and seal the container to prevent vapour loss. Place the container in the oven (6.1.1.4) set at 70 °C $\pm$ 2 °C for a period of 120 h $\pm$ 2 h. At the end of the heating period, remove the container from the oven and allow the seals to cool in the container at 23 °C $\pm$ 5 °C for 60 min to 90 min. At the end of the cooling period, remove the seals from the container and rinse in the alcohol and wipe dry with a clean, lint-free cloth. Do not allow the seals to remain in the alcohol for more than 30 s.

After removal from the alcohol and drying, place each seal in a separate, tarred, stoppered weighing bottle (6.1.1.5) and weigh (m_3). Remove each seal from its weighing bottle and weigh immersed in distilled water (m_4) to determine water displacement after hot fluid immersion. Make all weighings to the nearest 0,001 g.

Determine the final volume, dimensions and hardness of each seal within 60 min of rinsing in the alcohol.

6.1.4 Expression of results

6.1.4.1 Volume change

Volume change ΔV shall be reported as a percentage of the original volume. The change in volume is given by the formula:

$$\Delta V = \frac{(m_3 - m_4) - (m_1 - m_2)}{(m_1 - m_2)} \times 100$$

where

m_1 is the initial mass in air, in grams;

m_2 is the initial apparent mass in water, in grams;

m_3 is the mass in air after immersion in test fluid, in grams;

m_4 is the apparent mass in water after immersion test fluid, in grams.

6.1.4.2 Dimensional change

The original measurements of the lip and base diameters shall be subtracted from measurements taken after the test and the difference reported in millimetres and as percentages of the original diameters.

6.1.4.3 Hardness

Change in hardness shall be determined and recorded.

6.1.4.4 Disintegration

The seals shall be examined for disintegration as evidenced by blisters or sloughing.

6.2 Precipitation test

6.2.1 Apparatus

The following apparatus shall be used for the test.

6.2.1.1 Glass containers, of capacity approximately 250 ml and diameter 50 mm, which can be tightly sealed.

6.2.1.2 Cone-shaped centrifuge tube, of capacity 100 ml.

6.2.1.3 Oven, uniformly heated dry air type, conforming to the requirements for Method B of ISO 188:1998.

6.2.2 Test specimen

From two or more seals to be tested, obtain a sample of mass 4,0 g ± 0,5 g. Since sizes of seals vary, small pieces may be cut from the seal to arrive at the mass. Use the minimum number of pieces to obtain a mass of 4,0 g ± 0,5 g.

6.2.3 Test procedure

To determine the precipitation compatibility characteristics of the test seals, place the sample (6.2.2) in one of the specified glass containers (6.2.1.1) containing 75 ml of compatibility fluid of ISO 4926. Seal the container to prevent vapour loss and place in an oven (6.2.1.3) at 70 °C ± 2 °C for 120 h ± 2 h.

As an optional test, a blank test may be run on the brake fluid prior to the test and any sediment from the blank test may be subtracted from the sediment amount obtained from the test.

At the end of the heating period, remove the container from the oven and allow to cool at room temperature for 24 h, after which remove the seals.

Agitate thoroughly the contents of the jar and transfer the fluid and suspended particles to a cone-shaped centrifuge tube (6.2.1.2) of 100 ml capacity and determine the sediment as follows.

a) Measure a 10 ml sample of the fluid and suspended particles to be tested in each of two clean, dry centrifuge tubes at room temperature. Fill each tube to the 100 ml mark with the naphtha (see caution below) and close tightly with a softened cork (not a rubber stopper). Then invert each tube at least 20 times, allowing the liquid to drain thoroughly from the tapered tip of the tube each time. Place the tubes in a water bath at 32 °C to 35 °C for 5 min. Momentarily remove the corks to relieve any pressure, and invert each tube again at least 20 times, exactly as before. The success of this method depends to a large degree upon