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Elastomeric EMI Shielding

SOLUTIONS

ABOUT LAIRD

Laird designs and manufactures customized, performance-critical products for wireless and other advanced electronics applications.

The company is a global market leader in the design and supply of electromagnetic interference (EMI) shielding, thermal management products, mechanical actuation systems, signal integrity components, and wireless antennae solutions, as well as radio frequency (RF) modules and systems.

Laird is the world leader in the design and manufacture of customized, performance-critical products for wireless and other advanced electronics applications. Laird partners with its customers to customize product solutions for applications in many industries including:

- Network Equipment
- Handsets
- Telecommunications
- Data Transfer & Information Technology
- Computers
- Automotive Electronics
- Aerospace
- Defense
- Medical Equipment
- Consumer Electronics
- Industrial

Laird offers its customers unique product solutions, dedication to research and development, as well as a seamless network of manufacturing and customer support facilities across the globe.

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All parts listed in this catalog are lead free and RoHS compliant.

This catalog contains a limited selection of Laird products. Refer to www.lairdtech.com for other products not included in this catalog.

Notice:

Information on the products described in this catalog is based on laboratory test data which Laird believes to be reliable. However, Laird has no control over the design of actual products which incorporate Laird® products or actual fabrication of devices using Laird® products. Accordingly, Laird cannot guarantee that the same test data as described herein will be obtained. Thus, it is recommended that each user make their own tests to confirm laboratory test data and determine suitability of Laird® products for their particular application.

INTRODUCTION

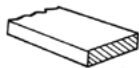
From concept to compliance, over 30 years of elastomer experience

Electrically conductive elastomers provide environmental sealing, and excellent mechanical and electromagnetic shielding properties. They are ideal for applications that demand both environmental sealing and EMI shielding, and can be used in a wide range of operating temperatures. Laird offers a wide variety of conductive filler materials in extruded, molded die-cut, dispensed form-in-place, printed and coated formats. We are constantly formulating new and custom compounds to provide you with more design options to meet your needs.

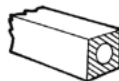
- Extrusion presses produce a multitude of conductive elastomer profiles in different compounds which are used in both military and commercial applications.
- Computerized multi axis form-in-place dispensing machines deposit conductive elastomer compounds onto miniaturized thin wall multi-compartment housing covers.
- Molding of EcE compounds is controlled from design through fabrication, from single cavity prototype to multi-cavity production or compression type molds.

VISUAL PART REFERENCE GUIDE

ELECTROSEAL CONDUCTIVE ELASTOMERS



Rectangular Strips
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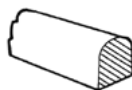
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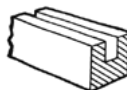
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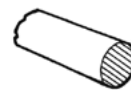
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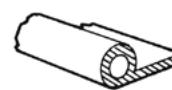
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Channel Strips
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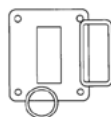


O-Strips
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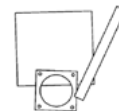
P-Strip Tubing
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ELECTROSEAL CONDUCTIVE ELASTOMER FABRICATED COMPONENTS



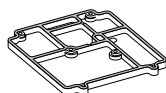
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ELECTROMET METAL IMPREGNATED MATERIALS – STRIPS / SHEETS



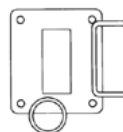
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FORM-IN-PLACE EMI DISPENSED GASKETS



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ELECTROCOAT



Page 34

BOARD TO CHASSIS CONDUCTIVE STAND-OFF



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PART NUMBER CROSS REFERENCE

| PART NUMBER | DESCRIPTION | PAGE |
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| 8560-XXXX-XX | Flat Washer Type Gaskets | Page 26 |
| 8560-XXXX-XX | Rectangular Waveguide Gaskets | Page 28 |
| 8563-XXXX-XX | Molded Emi O-Rings | Pages 24, 25 |
| 8563-XXXX-XX | Molded Waveguide Gaskets- Circular "D" | Page 27 |
| 8563-XXXX-XX | Molded Waveguide Gaskets- Rectangular "D" | Page 27 |
| 8563-XXXX-XX | Molded Waveguide Gaskets- Rectangular "O" | Page 27 |
| 8569-0127-XX | Board To Chassis Conductive Stand-Off | Page 35 |
| 8569-0131-XX | Board To Chassis Conductive Stand-Off | Page 35 |
| 8860-XXXX-XXX-XX | Electroshield Conductive Elastomer Sheet | Page 14 |
| 8861-XXXX-XX | Electroshield Rectangular Strips | Page 15 |
| 8862-XXXX-XX | Electroshield Hollow Rectangular Strips | Page 15 |
| 8863-XXXX-XX | Electroshield O-Strips | Page 19 |
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| 8865-XXXX-XX | Electroshield D-Strips | Page 18 |
| 889X-XXXX-XX | GEMI Coextrusions | Page 21 |
| 8408-01XX-XX | Electromet Metal Impregnated Materials - Strips | Page 33 |
| 8408-02XX-XX | Electromet Metal Impregnated Materials - Sheets | Page 33 |
| | ECE Material Selection Guide | Page 10, 11 |
| | FIP Paste Selection Guide | Page 32 |

INTRODUCTION TO ELECTRICALLY CONDUCTIVE ELASTOMERS

OVERVIEW

The electrically conductive elastomers are based on dispersed particles in elastomers, oriented wire in solid or sponge elastomers, impregnated wire mesh screens or expanded metals. They provide highly conductive, yet resilient gasketing materials for EMI sealing as well as pressure and environmental sealing.

Conductive elastomers are used for shielding electronic enclosures against electromagnetic interference (EMI). Usually, the shielding system consists of a conductive gasket sandwiched between a metal housing and lid. The primary function of these gaskets is to provide sufficient electrical conductivity across the enclosure/gasket/lid junction to meet grounding and EMI shielding requirements, as well as prevent intrusion of the fluids into the electrical components.

Laird offers conductive elastomers in the following forms:

1. ElectroSeal dispersed filler particles in elastomers
2. ElectroMet oriented wire in solid and sponge elastomers, and impregnated wire mesh and expanded metals

ELECTROSEAL™ GASKET INTRODUCTION

Conductive elastomer gaskets are EMI shielding and sealing devices made from highly conductive, mechanically resilient and conformable vulcanized elastomers. They are available in the following types:

1. Flat gaskets or die-cuts
2. Molded shapes such as O-rings or intricate parts
3. Extruded profiles or strips
4. Vulcanized-to-metal covers or flanges
5. Co-molded or reinforced seals
6. Form-in-place gaskets

When any two flat, but rigid surfaces are brought together, slight surface irregularities on each surface prevent them from meeting completely at all points. These irregularities may be extremely minute, yet may provide a leakage path for gas or liquid under pressure, and for high frequency electromagnetic energy. This problem remains in flange sealing even when very high closure force is applied.

However, when a gasket fabricated of resilient material is installed between the mating surfaces, and even minimal closure pressure is applied, the resilient gasket conforms to the irregularities in both mating surfaces. As a result, all surface imperfections and potential leak paths across the joint area are sealed completely against pneumatic and fluid pressure or penetration by environmental gases. If the gasket is conductive as well as resilient, with conductive matrix distributed throughout its total volume in mesh or particle form, the joint can be additionally sealed against penetration by, or exit of, electromagnetic energy.

DESIGN CONSIDERATIONS

The design requirements of the installation will usually narrow the choice considerably, particularly if the basic geometry of the enclosure is already established, or if military EMI shielding specifications are involved. In addition to choices of size and shape dictated by the enclosing structure and the joint geometry itself, the following four factors greatly influence the suitability of EMI gasket materials: shielding effectiveness, closure force, percent gland fill and compression/deflection.

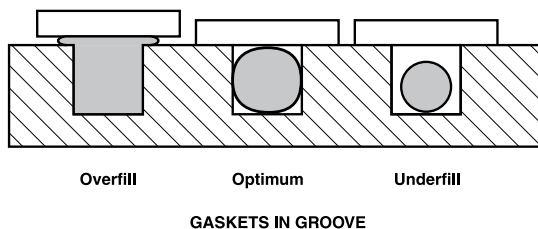
CLOSURE FORCE REQUIREMENTS

Solid conductive elastomer materials such as ElectroSeal stand up better to high closure forces, environmental pressures, and repeated opening and closing of the joint. Unlike sponge elastomers, solid conductive elastomers do not actually compress. They accommodate pressures by changing shape, rather than volume. This is an important difference in flange joint design requirements between the two material types, since additional gland volume must be allowed for the potential expansion of the elastomer under heat and/or pressure. Greater flange strength must often be provided to allow for increased closure force requirements. If low closure force is a consideration, however, the use of hollow extruded profiles such as the ElectroSeal hollow “O” and hollow “D” in conjunction with softer durometer elastomers will dramatically reduce closure force requirements.

PERCENT GLAND FILL (VOLUME/VOID RATIO)

Design of an elastomeric O-ring gland, or groove and contacting surfaces which make up the seal assembly, is as important as percent gland fill. For most static seal applications, it is necessary to calculate the area of the seal and the gland it will occupy, to determine whether the latter is large enough to receive the ring. Always try to avoid designs that stretch the elastomer more than 5%. If the seal element is stretched or compressed more than one or two percent, calculation based on the volume should be used unless volume swell is a factor. Irrespective of whether the calculations are based on volumes or cross-sectional areas, it is important to compare the largest possible seal cross-sectional area with the smallest gland, taking all tolerances into consideration. Never allow groove and seal tolerances to create an “overfilled” groove condition. Sufficient volume must be provided within the groove area to provide for a 90% to 95% gland fill. Figure 1 shows underfilled, overfilled, and optimum filled grooves.

FIGURE 1. GROOVE FILL LEVELS



GUIDELINES FOR GROOVE DIMENSIONS:

As a general rule we recommend a gland fill of 85% – 95% for optimum shielding effectiveness. However, for critical applications that require both shielding and environmental sealing, a 95% gland fill is suggested. For applications that require special design, please contact Laird applications engineering staff.

Recommended groove dimensions are provided on pages 18-19 for the solid D and solid O extruded profiles.

COMPRESSION/DEFLECTION

Compression/deflection data provide the engineer or designer with a qualitative comparison of the deformability of different profiles of conductive elastomers. Deflection is defined as the change in the cross-sectional height of a gasket under compressive load and is a function of material hardness and profile. The recommended deflection ranges of various conductive elastomer profiles are shown in Table 1. In no case however, should the amount of actual deflection be less than 10% for ElectroSeal materials. Remember that the minimum unevenness of the mating flanges must be taken into consideration in determining the original (uncompressed) and installed (compressed) height of the seal. Note that wall thickness of hollow profiles has a major effect on deflection

TABLE 1.
RECOMMENDED DEFLECTION FOR ELECTROSEAL PROFILES

| CROSS SECTION SHAPE | DEFLECTION |
|---------------------|---------------|
| Flat Strip | 5-10 Percent |
| Solid O | 20-25 Percent |
| Solid D | 15-20 Percent |
| Hollow O | 20-50 Percent |
| Hollow D | 25-50 Percent |
| Hollow P | 25-50 Percent |
| Interference Fit | 15-25 Percent |

Note: Selection of a proper profile has a bearing on the design and the performance of an EMI gasket.

INTRODUCTION TO ELECTRICALLY CONDUCTIVE ELASTOMERS

SERVICE LIFE

Three fundamental factors are involved when considering the service life of an EMI gasket:

1. The presence of detrimental chemicals and fluids, ozone aging and temperature extremes.
2. The number of times the joint will be opened and closed during the projected operating life of the equipment.
3. Potential exposure to inadvertent damage during initial installation and future maintenance.

ENVIRONMENTAL CONSIDERATIONS

Proper material selection for effective EMI shielding depends on the total environmental envelope within which the seal/shield will be expected to function. The material selection process should begin with a careful analysis of the following major environmental conditions:

- Temperature
- Aging/Shelf Life
- Pressure/Vacuum
- Fluid Compatibility
- Galvanic Compatibility

TEMPERATURE

Temperature, though seemingly elementary, is often the most misunderstood and exaggerated of all sealing environment parameters; hence, it is all too often over-specified.

Low Temperature

Low temperature induced changes in the elastomer properties are generally physical in nature. As the temperature decreases below allowable limits, the elastomeric properties are lost and the material becomes very hard and brittle. Duration of the effects of low temperature exposure is not significant and the original properties are regained upon resumption of moderate temperatures.

High Temperature

High temperatures also affect the properties of elastomers in the same way as the low temperatures. As the temperature begins to rise, the elastomer will soften, lowering its extrusion resistance. Tensile strength and modulus also decrease under high temperatures, and elongation is increased. But these initial changes reverse if exposure to high temperatures is brief. Changes due to prolonged high temperature exposure are chemical in nature rather than physical, and are not reversible.

The temperature capabilities of various ElectroSeal elastomers are shown in Table 2.

TABLE 2.
TEMPERATURE CAPABILITIES OF
PRINCIPAL ELECTROSEAL ELASTOMERS

| ELASTOMER TYPE | LOW TEMPERATURE | UPPER TEMPERATURE |
|----------------|-----------------|-------------------|
| EPDM | -58°F (-50°C) | 257°F (125°C) |
| Silicone | -49°F (-45°C) | 392°F (200°C) |
| Fluorosilicone | -67°F (-55°C) | 347°F (175°C) |

AGING/SHELF LIFE

Another major factor in the selection of any elastomer destined for sealing/shielding service is time, or more properly, seal life. The expected life of a seal may involve only a few seconds in the case of some highly specialized seals used in solid propellant rocket casings, to as much as 10 to 20 years and beyond in the case of seals used in deep-space vehicles.

Deterioration with time or aging relates to the type of polymer and storage conditions. Exposure may cause deterioration of elastomers whether installed or in storage. Resistance to deterioration in storage varies greatly between the elastomers. Military Handbook 695 (MIL-HDBK-695) divides synthetic elastomers in the following groups according to age resistance as shown in Table 3.

TABLE 3.
AGE RESISTANCE OF PRINCIPAL ELECTROSEAL ELASTOMERS

| BASE POLYMER | ASTM DESIGNATION | SHELF LIFE (YEARS) |
|----------------------------------|------------------|--------------------|
| Ethylene Propylene Diene Monomer | EPDM | 5 to 10 Years |
| Silicone MQ, VMQ, | PVMQ | Up to 20 Years |
| Fluorosilicone | FVMQ | Up to 20 Years |

PRESSURE VACUUM

Conductive elastomer seals are rarely used for high-pressure systems, with the exception of waveguide seals. Pressure has a bearing on the choice of material and hardness. Low durometer materials are used for low pressure applications, whereas high pressure may require a combination of material hardness and design.

Outgassing and/or sublimation in a high vacuum system can cause seal shrinkage (loss of volume), resulting in a possible loss of sealing ability. When properly designed and confined, an O-ring, molded shape, or a molded-to-the-cover plate seal can provide adequate environmental sealing as well as EMI shielding for vacuum (to 1 x 10⁻⁶ Torr) applications.

FLUID COMPATIBILITY

The primary function of elastomeric EMI seals is to provide sufficient electrical conductivity across the enclosure/port/flange junction, while at the same time provide at least minimal environmental sealing capability. Consideration must be given to the basic compatibility between the elastomer seal/shield element and any fluids with which it may come in prolonged contact. Table 4 lists the general reaction to common fluid media for the polymer types commonly used in ElectroSeal conductive elastomers. Note that any proposed conductive material and design should be thoroughly tested by the user under all possible conditions prior to production.

The complex chemistry involved in the combination of the polymer and metallic fillers in conductive elastomers makes it imperative that such tests be conducted to determine suitability for use with a given fluid.

TABLE 4.
RESISTANCE OF PRINCIPAL ELECTROSEAL ELASTOMERS TO FLUIDS

| FLUID | SILICONE | FLUROSILICONE | EPDM |
|------------------------------------|-----------|---------------|-----------|
| Impermeability to Gases | Poor | Fair | Good |
| Ozone and Ultraviolet | Excellent | Excellent | Excellent |
| ASTM 1 Oil | Fair | Good | Don't use |
| Hydraulic Fluids (Organic) | Fair | Good | Don't use |
| Hydraulic Fluids (Phosphate ester) | Fair | Fair | Excellent |
| Hydrocarbon Fuels | Don't use | Good | Don't use |
| Dilute Acids | Fair | Good | Good |
| Concentrated Acids | Don't use | Don't use | Fair/Good |
| Dilute Bases | Fair | Good | Excellent |
| Concentrated Bases | Don't use | Don't use | Good |
| Esters/Ketones | Don't use | Don't use | Excellent |
| DS (Decontaminating Fluid) | Poor | Poor | Good |
| STB (Decontaminating Fluid) | Good | Good | Good |
| Low Temperature | Excellent | Excellent | Excellent |
| High Temperature | Excellent | Good | Good |
| Compression Set | Good | Good | Good |
| Radiation Resistance | Good | Poor | Good |

GALVANIC COMPATIBILITY

Compatibility between the gasket and the mating flanges is another area which must be given proper attention when designing a gasket for sealing/shielding. This problem can be minimized by various means, the simplest and most effective of which is proper gasket and flange design. This must be coupled with the judicious selection of a gasket material compatible with the mating surfaces. A large difference in corrosion potential between the mating surface and the conductive elastomer and the presence of a conductive electrolyte, such as salt water or a humid environment, will accelerate galvanic corrosion.

Under dry conditions, such as the typical office environment, there will be little danger of galvanic corrosion. However, when the gasket is exposed to high humidity or salt-water environments, galvanic corrosion will occur between dissimilar metals. The likelihood of galvanic corrosion increases as the potential difference between the mating surface and the elastomer increases. The charts on pages 47-48 indicate which mating surfaces and elastomer combinations minimize the corrosion potential. In addition, the less permeable elastomers, such as EPDM and fluorosilicone, limit galvanic corrosion by restricting the access of the electrolyte to the conductive fillers in the gasket. For further details on galvanic corrosion of elastomeric materials, see pages 43-48.

INTRODUCTION TO ELECTRICALLY CONDUCTIVE ELASTOMERS

MATERIAL SELECTION GUIDE

Laird offers a series of products to meet a wide range of customer requirements for military and commercial applications. The classifications of the most common materials are based on cost and specific applications and are outlined in Table 5.

TABLE 5

| PARAMETER | TEST METHOD | ECE93 | ECE72 | ECE92 | ECE115 | ECE125 | ECE85A | ECE116 | ECE126 | ECE118 | ECE88 |
|---|----------------------------|----------|----------|----------------|---------------|----------------|----------|---------------|----------------|---------------|----------------|
| ECE Name | | | | | | | | | | | |
| MIL-DTL-83528C Material Type | | | | | Type M | | | Type B | Type D | Type A | |
| Filler | | Ni/C | Ni/C | Ni/C | Ag/Glass | Ag/Glass | Ag/Glass | Ag/Al | Ag/Al | Ag/Cu | Ag/Cu |
| Elastomer | | Silicone | Silicone | Fluorosilicone | Silicone | Fluorosilicone | Silicone | Silicone | Fluorosilicone | Silicone | Fluorosilicone |
| Color | | Black | Gray | Dark Gray | Tan | Tan | Tan | Tan | Tan | Tan | Tan |
| Electrical Properties | | | | | | | | | | | |
| Volume Resistivity, Ω cm, max | MIL-DTL-83528C para 4.5.10 | 0.1 | 0.1 | 0.1 | 0.006 | 0.01 | 0.004 | 0.008 | 0.01 | 0.004 | 0.01 |
| Shielding Eff, 10 GHz, dB, min | MIL-DTL-83528C para 4.5.12 | 100 | 100 | 100 | 100 | 90 | 100 | 100 | 100 | 120 | 110 |
| Physical Properties | | | | | | | | | | | |
| Density, g/cm ³ (± 0.25) | ASTM D792 | 1.9 | 2.3 | 2.2 | 1.9 | 2 | 2 | 2 | 2 | 3.3 | 4.1 |
| Hardness, Shore A (± 7) | ASTM D2240 | 55 | 75 | 75 | 65 | 75 | 70 | 65 | 70 | 70 | 75 |
| Tensile Strength, psi, min | ASTM D412 | 150 | 280 | 150 | 200 | 200 | 200 | 200 | 200 | 450 | 180 |
| Elongation | ASTM D412 | 100-300% | 150% | 60-250% | 100-300% | 60-200% | 60% | 100-300% | 60-260% | 100-300% | 100-300% |
| Tear Strength, ppi, min | ASTM D624, die C | 30 | 55 | 40 | 30 | 30 | 30 | 30 | 35 | 55 | 30 |
| Compression Set, max | ASTM D395 | 30% | 30% | 30% | 30% | 30% | | 32% | 30% | 32% | 35% |
| Compression / Deflection, %, min | ASTM D575 | 8 | 8 | 5 | 3.5 | 3 | | 3.5 | 3.5 | 3.5 | 3.5 |
| Max Oper. Temp., °C | MIL-DTL-83528C para 4.5.15 | 160 | 160 | 160 | 160 | 160 | 150 | 160 | 160 | 125 | 125 |
| Min. Oper. Temp., °C | ASTM D1329 | -55 | -55 | -55 | -55 | -50 | -45 | -55 | -55 | -55 | -55 |
| Flame Retardance | UL 94 | HB | V0 | - | V0 | V0 | - | V0 | V0 | V0 | - |
| Fluid Immersion ¹ | MIL-DTL-83528C para 4.5.17 | N/S | - | SUR | N/S | SUR | - | - | SUR | - | SUR |
| Electrical Stability | | | | | | | | | | | |
| After Heat Aging, Ω cm, max | MIL-DTL-83528C para 4.5.15 | 0.2 | - | 0.2 | 0.015 | - | - | 0.01 | 0.015 | 0.01 | 0.015 |
| After Break, Ω cm, max | MIL-DTL-83528C para 4.5.9 | 0.2 | - | 0.2 | 0.009 | - | - | 0.015 | 0.015 | 0.008 | 0.015 |
| During Vibration, Ω cm, max | MIL-DTL-83528C para 4.5.13 | 0.2 | - | 0.2 | 0.009 | - | - | 0.015 | 0.015 | 0.006 | 0.015 |
| After Exposure to EMP, Ω cm, max | MIL-DTL-83528C para 4.5.16 | 0.1 | - | 0.1 | 0.015 | - | - | 0.01 | 0.015 | 0.01 | 0.015 |
| Manufacturing Processes | | | | | | | | | | | |
| Molded sheet / diecut parts | | x | x | x | x | x | x | x | x | x | x |
| Molded shapes / O-rings | | x | x | x | x | x | x | x | x | x | x |
| Extruded profiles | | x | x | x | x | x | | x | x | x | x |

Notes:
N/S = Not Survivable
SUR = Survivable

INTRODUCTION TO ELECTRICALLY CONDUCTIVE ELASTOMERS

| PARAMETER | | | | | | | | | |
|---|---------------|---------------|----------|----------------|----------|----------|---------|---------|----------------|
| ECE Name | ECE82 | ECE83 | ECE84 | ECE90 | ECE87 | ECE13 | ECE95 | ECE96 | ECE89 |
| MIL-DTL-83528C Material Type | Type E | Type J | | | | | | | |
| Filler | Ag | Ag | Ag/Ni | Ag/Ni | C | C | Ni/C | Ag/Al | Ag/Al |
| Elastomer | Silicone | Silicone | Silicone | Fluorosilicone | Silicone | EPDM | EPDM | EPDM | Fluorosilicone |
| Color | Beige | Beige | Tan | Tan | Black | Black | Black | Tan | Blue |
| Electrical Properties | | | | | | | | | |
| Volume Resistivity, Ω cm, max | 0.002 | 0.01 | 0.005 | 0.005 | 5 | 30 | 0.15 | 0.01 | 0.012 |
| Shielding Eff, 10 GHz, dB, min | 120 | 80 | 100 | 100 | 30 | 30 | 70 | 90 | 100 |
| Physical Properties | | | | | | | | | |
| Density, g/cm ³ (± 0.25) | 3.5 | 1.8 | 4 | 4.1 | 1.3 | 1.2 | 2.2 | 2.2 | 2.2 |
| Hardness, Shore A (± 7) | 65 | 45 | 75 | 75 | 75 | 80 | 80 | 80 | 70 |
| Tensile Strength, psi, min | 300 | 150 | 200 | 300 | 700 | 2000 | 200 | 200 | 180 |
| Elongation | 100-300% | 50-250% | 100-300% | 100-300% | 100-300% | 100-400% | 70-260% | 70-260% | 60-260% |
| Tear Strength, pli, min | 50 | 20 | 30 | 50 | 50 | 100 | 60 | 60 | 30 |
| Compression Set, max | 45% | 35% | 32% | 25% | 45% | 30% | 40% | 50% | 30% |
| Compression / Deflection, %, min | 2.5 | 8 | 3.5 | 3 | 3.5 | 3 | 3 | 3 | 3.5 |
| Max Oper. Temp., °C | 160 | 160 | 125 | 160 | 160 | 125 | 125 | 125 | 160 |
| Min. Oper. Temp., °C | -55 | -55 | -55 | -50 | -55 | -40 | -40 | -40 | -55 |
| Flame Retardance | - | - | - | - | - | - | - | - | - |
| Fluid Immersion ¹ | N/S | N/S | N/S | SUR | N/S | N/S | N/S | N/S | SUR |
| Electrical Stability | | | | | | | | | |
| After Heat Aging, Ω cm, max | 0.01 | 0.015 | 0.01 | 0.01 | 7 | 40 | - | - | 0.015 |
| After Break, Ω cm, max | 0.01 | 0.02 | 0.01 | 0.01 | 7 | - | - | - | 0.015 |
| During Vibration, Ω cm, max | 0.01 | 0.015 | 0.01 | 0.01 | - | - | - | - | 0.015 |
| After Exposure to EMP, Ω cm, max | 0.01 | 0.015 | 0.01 | 0.01 | - | - | - | - | 0.015 |
| Manufacturing Processes | | | | | | | | | |
| Molded sheet / diecut parts | x | x | x | x | x | x | x | x | x |
| Molded shapes / O-rings | x | x | x | x | x | x | x | x | x |
| Extruded profiles | x | x | x | x | | x | x | x | x |

INTRODUCTION TO ELECTRICALLY CONDUCTIVE ELASTOMERS

EMI GASKET MOUNTING TECHNIQUES

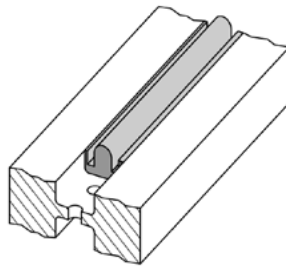
Common EMI gasket mounting techniques are:

POSITIONING IN A GROOVE

This is a highly recommended method if a suitable groove can be provided at a relatively low cost. Placing the EMI gasket in such a groove provides several advantages:

- a. metal-to-metal contact of mating flange surfaces provides a compression stop and prevents overcompression of the gasket material;
- b. is cost-effective by reducing assembly time;
- c. best overall seal for EMI, EMP, salt fog, NBC, and fluids by providing metal-to-metal flange contact and reducing exposure of the seal element to attack by outside elements.

FIGURE 2



INTERFERENCE FIT APPLICATIONS

Allow 0.005 in. (0,1 mm) to 0.100 in. (2,5 mm) interference for part to hold and eliminate the need for adhesive. Groove depth should be set to ensure that the channel is not over-filled.

WATER TIGHT APPLICATIONS

Fill channel with as much material as possible, taking tolerances into account. Use caution to avoid overfill conditions.

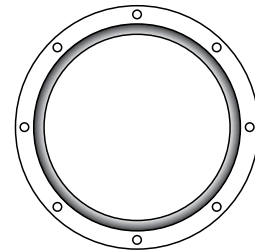
BONDING WITH ADHESIVES

The EMI gasket may be attached to one of the mating flanges by the application of pressure sensitive or permanent adhesives. A suitable conductive adhesive is always preferable over a nonconductive adhesive for mounting EMI gaskets as they can provide adequate electrical contact between the EMI gasket and the mounting surface.

BOLT-THROUGH HOLES

This is a common and inexpensive way to hold an EMI gasket in position. Locator bolt holes can be accommodated in the tab or in rectangular flat gaskets as shown in Figure 3.

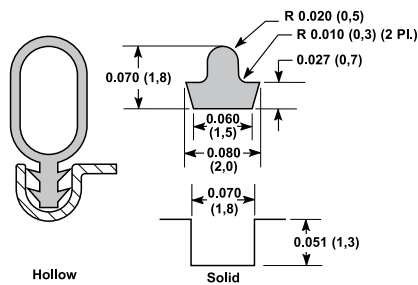
FIGURE 3



INTERFERENCE FIT

For applications such as face seals or where the gasket must be retained in the groove during assembly, interference fit is an excellent and inexpensive choice. The gasket is simply held in the groove or against a shoulder by mechanical friction as shown in Figure 4.

FIGURE 4

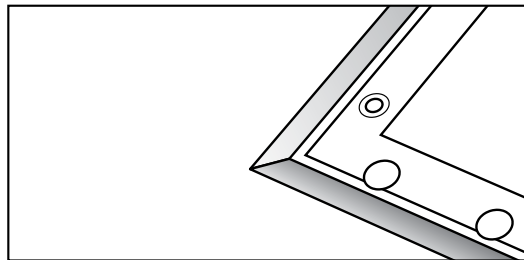


VULCANIZED MOUNTING

In this case, the seal element is vulcanized directly to the metal flange or cover under heat and pressure. The vulcanized to-the-metal mounting offers a homogeneous one-piece gasket with superior conductivity between the gasket and the metal.

Laird provides EMI seals bonded to covers and retainers. Such devices may have the conductive element bonded in a groove or vulcanized to the edge of a thin sheet metal retainer. Figure 5 shows a vulcanized mounted and frame mounted gasket.

FIGURE 5



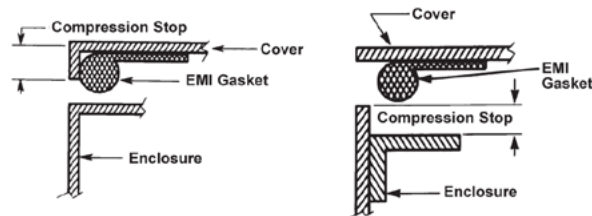
FRICITION, ABRASION AND IMPACT CONSIDERATIONS

The physical positioning of EMI gaskets in an environment where friction, abrasion and impact are possible needs special consideration. EMI gaskets in such an environment should be positioned so that they receive little or no sliding or side-to-side motion when being compressed. Examples of common attachments for access door gaskets are shown in Figure 6.

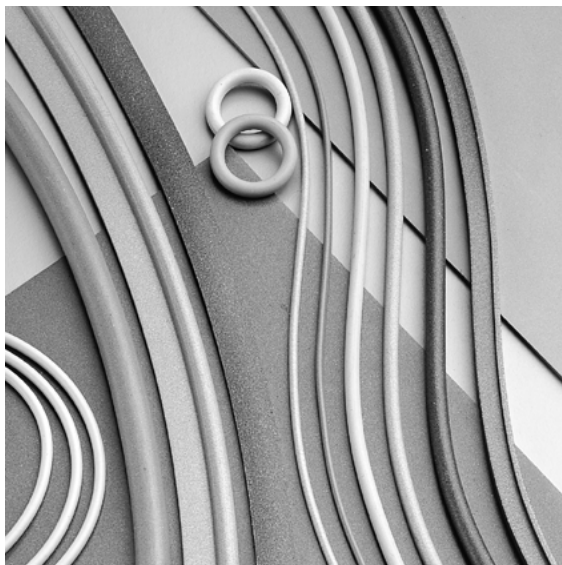
MOUNTING TIPS

Care should be taken to avoid excess handling of conductive elastomers, including excessive stretching, bending or exposure to grease.

FIGURE 6 COVER WITH COMPRESSION STOP



ELECTROSEAL CONDUCTIVE ELASTOMER MATERIAL



ELECTROSEAL™ CONDUCTIVE ELASTOMER EMI SHIELDING

Laird electrically conductive elastomer products are ideal for both military and commercial applications requiring both environmental sealing and EMI shielding. Compounds can be supplied in molded or extruded shapes, sheet stock, custom extruded, or die-cut shapes to meet a wide variety of applications.

Our conductive extrusions offer a wide choice of profiles to fit a large range of applications. The cross-sections shown on the following pages are offered as standard. Custom dies can be built to accommodate your specific design.

- Available in a wide variety of conductive filler materials
- Shielding effectiveness up to 120 dB at 10 GHz

SHEET MATERIAL

Table 1 lists thicknesses and sizes for our molded sheet material, while Table 2, pages 10-11, shows the compounds available for all of our conductive silicone elastomers.

HOW TO SPECIFY ECE

Decide on molded sheet stock or extruded shapes. Select the desired configuration and dimensions from Table 1 (for sheet stock) or Figures 1–8 (for extruded shapes). Select the desired material from Table 2. Insert material number from Table 2, |pages 14–17, in place of the letters XX in the Laird part number.

Example

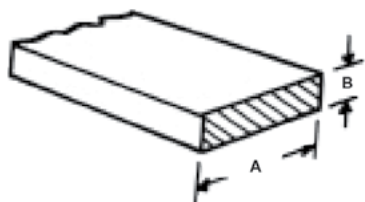
1. From Figure 1, on page 18, for a rectangular strip measuring 0.500 in. (12,7 mm) x 0.075 in. (1,9 mm), part number is 8861-0130-XX.
2. From Table 2, on page 16, for silver-nickel filler, material number is 84.
3. Ordering part number is 8861-0130-84.*

Note: Rectangular and D-shaped extrusions can be supplied with pressure sensitive adhesive tape.

| THICKNESS | 10 X 10 SHEET | 10 X 15 SHEET | 15 X 20 SHEET | 18 X 18 SHEET |
|-------------|------------------|------------------|------------------|------------------|
| 0.020 (0,5) | 8860-0020-100-XX | 8860-0020-150-XX | 8860-0020-300-XX | N/A |
| 0.032 (0,8) | 8860-0032-100-XX | 8860-0032-150-XX | 8860-0032-300-XX | 8860-0032-324-XX |
| 0.045 (1,1) | 8860-0045-100-XX | 8860-0045-150-XX | 8860-0045-300-XX | 8860-0045-324-XX |
| 0.062 (1,5) | 8860-0062-100-XX | 8860-0062-150-XX | 8860-0062-300-XX | 8860-0062-324-XX |
| 0.093 (2,3) | 8860-0093-100-XX | 8860-0093-150-XX | 8860-0093-300-XX | 8860-0093-324-XX |
| 0.100 (2,5) | 8860-0100-100-XX | 8860-0100-150-XX | 8860-0100-300-XX | 8860-0100-324-XX |
| 0.125 (3,2) | 8860-0125-100-XX | 8860-0125-150-XX | 8860-0125-300-XX | 8860-0125-324-XX |

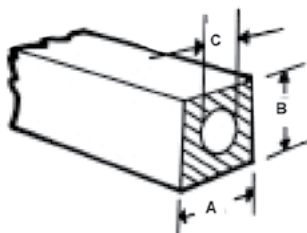
EXTRUSIONS GUIDE

Rectangular Strips



| MIL-DTL-85328 PART NUMBER | PART NUMBER | NOMINAL DIMENSIONS INCH(MM) | |
|------------------------------|----------------|--------------------------------|-------------|
| | | A | B |
| M83528/009X001 | 8861-0100 | 0.063 (1,6) | 0.042 (1,1) |
| | 8861-0179 | 0.079 (2,0) | 0.039 (1,0) |
| | 8861-0181 | 0.079 (2,0) | 0.059 (1,5) |
| M83528/009X002 | 8861-0105 | 0.095 (2,4) | 0.062 (1,6) |
| M83528/009X003 | 8861-0110 | 0.120 (3,0) | 0.075 (1,9) |
| M83528/009X004 | 8861-0115 | 0.125 (3,2) | 0.062 (1,6) |
| M83528/009X005 | 8861-0120 | 0.156 (4,0) | 0.062 (1,6) |
| | 8861-0121 | 0.187 (4,8) | 0.125 (3,2) |
| | 8861-0167 | 0.188 (4,8) | 0.062 (1,6) |
| | 8861-0193 | 0.189 (4,8) | 0.189 (4,8) |
| M83528/002X006 | 8861-0125 | 0.250 (6,4) | 0.062 (1,6) |
| | 8861-0173 | 0.250 (6,4) | 0.125 (3,2) |
| | 8861-0174 | 0.250 (6,4) | 0.188 (4,8) |
| | 8861-0136 | 0.250 (6,4) | 0.200 (5,1) |
| | 8861-0175 | 0.252 (6,4) | 0.031 (0,8) |
| | 8861-0183 | 0.378 (9,6) | 0.063 (1,6) |
| | 8861-0172 | 0.500 (12,7) | 0.020 (0,5) |
| | 8861-0131 | 0.500 (12,7) | 0.042 (1,1) |
| | 8861-0182 | 0.500 (12,7) | 0.059 (1,5) |
| M83528/009X007 | 8861-0130 | 0.500 (12,7) | 0.075 (1,9) |
| | 8861-0188 | 0.500 (12,7) | 0.094 (2,4) |
| M83528/009X008 | 8861-0135 | 0.500 (12,7) | 0.125 (3,2) |
| M83528/009X009 | 8861-0140 | 0.500 (12,7) | 0.188 (4,8) |
| | 8861-0142 | 0.750 (19,1) | 0.040 (1,0) |
| | 8861-0141 | 0.750 (19,1) | 0.042 (1,1) |
| M83528/009X010 | 8861-0145 | 0.750 (19,1) | 0.062 (1,6) |
| | 8861-0184 | 0.827 (21,0) | 0.071 (1,8) |
| | 8861-0189 | 0.827 (21,0) | 0.094 (2,4) |
| M83528/009X011 | 8861-0150 | 0.880 (22,4) | 0.062 (1,6) |
| | 8861-0103 | 0.984 (25,0) | 0.043 (1,1) |
| | 8861-0169 | 1.00 (25,4) | 0.062 (1,6) |
| | 8861-0192 | 1.00 (25,4) | 0.126 (3,2) |
| M83528/009X012 | 8861-0155 | 1.00 (25,4) | 0.250 (6,4) |
| M83528/009X013 | 8861-0160 | 1.18 (30,0) | 0.062 (1,6) |

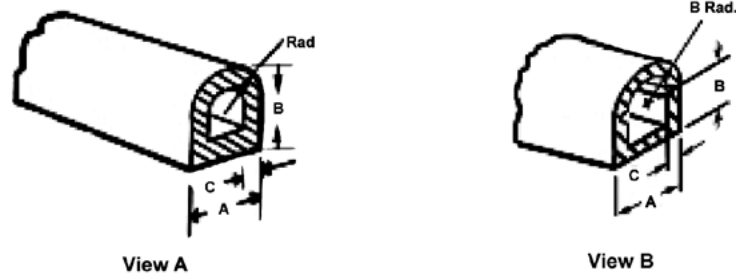
Hollow Rectangular Strips



| PART NUMBER | NOMINAL DIMENSIONS INCH(MM) | | |
|-------------|-----------------------------|-------------|-------------|
| | A | B | C |
| 8862-0112 | 0.125 (3,2) | 0.125 (3,2) | 0.078 (2,0) |
| 8862-0113 | 0.200 (5,1) | 0.130 (3,3) | 0.090 (2,3) |
| 8862-0114 | 0.250 (6,4) | 0.250 (6,4) | 0.156 (4,0) |
| 8862-0100 | 0.330 (8,4) | 0.305 (7,7) | 0.125 (3,2) |
| 8862-0105 | 0.375 (9,5) | 0.375 (9,5) | 0.188 (4,8) |

EXTRUSIONS GUIDE

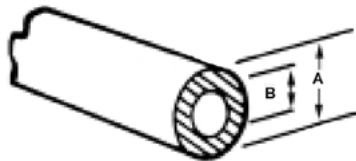
Hollow D-Strips



| MIL-DTL-83528 PART NUMBER | PART NUMBER | DIMENSIONS INCH(MM) | | | | |
|------------------------------|-------------|---------------------|--------------|-------------|-------------|------|
| | | A | B | RAD | C | VIEW |
| | 8866-0135 | 0.093 (2,4) | 0.093 (2,4) | 0.046 (1,2) | 0.027 (0,7) | A |
| | 8866-0160 | 0.098 (2,5) | 0.098 (2,5) | 0.049 (1,2) | 0.020 (0,5) | A |
| | 8866-0130 | 0.100 (2,5) | 0.094 (2,4) | 0.050 (1,3) | 0.025 (0,6) | A |
| | 8866-0162 | 0.109 (2,8) | 0.125 (3,2) | 0.054 (1,4) | 0.024 (0,6) | A |
| M83528/007X001 | 8866-0100 | 0.156 (4,0) | 0.156 (4,0) | 0.078 (2,0) | 0.045 (1,1) | A |
| | 8866-0111 | 0.156 (4,0) | 0.156 (4,0) | 0.078 (2,0) | 0.027 (0,7) | A |
| | 8866-0103 | 0.158 (4,0) | 0.240 (6,1) | 0.079 (2,0) | 0.040 (1,0) | A |
| | 8866-0136 | 0.160 (4,1) | 0.120 (3,0) | 0.080 (2,0) | 0.025 (0,6) | A |
| M83528/007X002 | 8866-0105 | 0.187 (4,8) | 0.187 (4,8) | 0.093 (2,4) | 0.050 (1,3) | A |
| | 8866-0131 | 0.250 (6,4) | 0.145 (3,7) | 0.125 (3,2) | 0.030 (0,8) | A |
| | 8866-0050 | 0.250 (6,4) | 0.250 (6,4) | 0.125 (3,2) | 0.050 (1,3) | B |
| M83528/007X007 | 8866-0110 | 0.250 (6,4) | 0.250 (6,4) | 0.125 (3,2) | 0.065 (1,7) | A |
| M83528/007X005 | 8866-0120 | 0.312 (7,9) | 0.312 (7,9) | 0.112 (2,8) | 0.062 (1,6) | A |
| M83528/007X004 | 8866-0116 | 0.312 (7,9) | 0.312 (7,9) | 0.156 (4,0) | 0.062 (1,6) | B |
| | 8866-0127 | 0.325 (8,3) | 0.575 (14,6) | 0.287 (7,3) | 0.080 (2,0) | A |
| | 8866-0168 | 0.358 (9,1) | 0.374 (9,5) | 0.179 (4,5) | 0.039 (1,0) | A |
| | 8866-0166 | 0.374 (9,5) | 0.252 (6,4) | 0.187 (4,8) | 0.039 (1,0) | A |
| | 8866-0134 | 0.375 (9,5) | 0.250 (6,4) | 0.090 (2,3) | 0.050 (1,3) | B |
| | 8866-0137 | 0.375 (9,5) | 0.250 (6,4) | 0.187 (4,8) | 0.032 (0,8) | A |
| | 8866-0169 | 0.421 (10,7) | 0.427 (10,8) | 0.210 (5,3) | 0.039 (1,0) | A |
| | 8866-0126 | 0.480 (12,2) | 0.335 (8,5) | 0.240 (6,1) | 0.035 (0,9) | A |
| M83528/007X006 | 8866-0125 | 0.487 (12,4) | 0.324 (8,2) | 0.244 (6,2) | 0.062 (1,6) | A |
| | 8866-0148 | 0.488 (12,4) | 0.312 (7,9) | 0.244 (6,2) | 0.055 (1,4) | A |
| | 8866-0139 | 0.488 (12,4) | 0.324 (8,2) | 0.244 (6,2) | 0.063 (1,6) | A |
| | 8866-0129 | 0.500 (12,7) | 0.312 (7,9) | 0.250 (6,4) | 0.050 (1,3) | A |
| | 8866-0155 | 0.625 (15,9) | 0.400 (10,2) | 0.312 (7,9) | 0.057 (1,4) | A |

EXTRUSIONS GUIDE

O-Strip Tubing



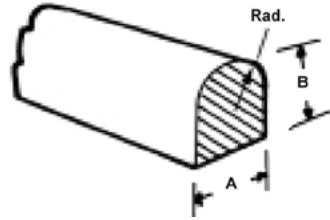
| MIL-DTL-85328 PART NUMBER | PART NUMBER | NOMINAL DIMENSIONS INCH(MM) | |
|------------------------------|----------------|--------------------------------|-------------|
| | | A | B |
| | 8864-0136 | 0.085 (2,2) | 0.035 (0,9) |
| | 8864-0060 | 0.085 (2,2) | 0.040 (1,0) |
| | 8864-0173 | 0.085 (2,2) | 0.050 (1,3) |
| | 8864-0156 | 0.090 (2,3) | 0.040 (1,0) |
| | 8864-0161 | 0.090 (2,3) | 0.045 (1,1) |
| | 8864-0090 | 0.090 (2,3) | 0.050 (1,3) |
| M83528/011X007 | 8864-0095 | 0.103 (2,6) | 0.040 (1,0) |
| | 8864-0142 | 0.103 (2,6) | 0.050 (1,3) |
| | 8864-0172 | 0.110 (2,8) | 0.062 (1,6) |
| | 8864-0153 | 0.115 (2,9) | 0.062 (1,6) |
| M83528/011X001 | 8864-0100 | 0.125 (3,2) | 0.045 (1,1) |
| M83528/011X006 | 8864-0101 | 0.125 (3,2) | 0.062 (1,6) |
| | 8864-0102 | 0.130 (3,3) | 0.062 (1,6) |
| | 8864-0104 | 0.145 (3,7) | 0.070 (1,8) |
| | 8864-0171 | 0.149 (3,8) | 0.125 (3,2) |
| M83528/011X002 | 8864-0105 | 0.156 (4,0) | 0.050 (1,3) |
| | 8864-0163 | 0.156 (4,0) | 0.062 (1,6) |
| | 8864-0139 | 0.168 (4,3) | 0.069 (1,8) |
| | 8864-0162 | 0.177 (4,5) | 0.092 (2,3) |

| MIL-DTL-85328 PART NUMBER | PART NUMBER | NOMINAL DIMENSIONS INCH(MM) | |
|------------------------------|----------------|--------------------------------|--------------|
| | | A | B |
| M83528/011X008 | 8864-0143 | 0.177 (4,5) | 0.079 (2,0) |
| | 8864-0168 | 0.188 (4,8) | 0.120 (3,0) |
| | 8864-0147 | 0.216 (5,5) | 0.125 (3,2) |
| | 8864-0167 | 0.228 (5,8) | 0.169 (4,3) |
| M83528/011X003 | 8864-0110 | 0.250 (6,4) | 0.125 (3,2) |
| | 8864-0160 | 0.312 (7,9) | 0.188 (4,8) |
| M83528/011X004 | 8864-0120 | 0.312 (7,9) | 0.192 (4,9) |
| | 8864-0144 | 0.330 (8,4) | 0.250 (6,4) |
| | 8864-0050 | 0.375 (9,5) | 0.235 (6,0) |
| M83528/011X005 | 8864-0125 | 0.375 (9,5) | 0.250 (6,4) |
| | 8864-0127 | 0.400 (10,2) | 0.200 (5,1) |
| | 8864-0170 | 0.422 (10,7) | 0.319 (8,1) |
| | 8864-0166 | 0.490 (12,4) | 0.414 (10,5) |
| | 8864-0135 | 0.513 (13,0) | 0.438 (11,1) |
| | 8864-0055 | 0.550 (14,0) | 0.447 (11,4) |
| | 8864-0159 | 0.623 (15,8) | 0.366 (9,3) |
| | 8864-0053 | 0.630 (16,0) | 0.375 (9,5) |

| | | | |
|--|-------------|-------------|-------------|
| | 8864-010462 | 0.146 (3,7) | 0.091 (2,3) |
| | 8864-3714 | 0.146 (3,7) | 0.055 (1,4) |
| | 8864-0103 | 0.138 (3,5) | 0.071 (1,8) |
| | 8864-0091 | 0.094 (2,4) | 0.059 (1,5) |
| | 8864-3515 | 0.138 (3,5) | 0.059 (1,5) |
| | 8864-2618 | 0.102 (2,6) | 0.071 (1,8) |
| | 8864-3824 | 0.150 (3,8) | 0.094 (2,4) |
| | 8864-0137 | 0.094 (2,4) | 0.035 (0,9) |
| | 8864-0141 | 0.126 (3,2) | 0.087 (2,2) |
| | 8864-0231 | 0.071 (1,8) | 0.039 (1) |
| | 8864-0180 | 0.063 (1,6) | 0.039 (1) |
| | 8864-3715 | 0.146 (3,7) | 0.059 (1,5) |

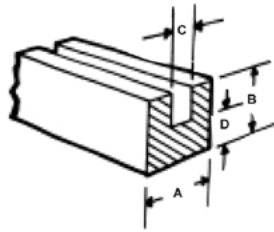
EXTRUSIONS GUIDE

D-Strips



| MIL-DTL-83528 PART NUMBER | PART NUMBER | DIMENSIONS INCH(MM) | | | RECOMMENDED GROOVE DIMENSIONS (±0.002) | |
|------------------------------|-------------|---------------------|-------------|-------------|---|-------------|
| | | A | B | RAD | WIDTH | DEPTH |
| | 8865-0100 | 0.055 (1,4) | 0.064 (1,6) | 0.031 (0,8) | 0.067 (1,7) | 0.053 (1,3) |
| MB83528/003X001 | 8865-0105 | 0.062 (1,6) | 0.068 (1,7) | 0.031 (0,8) | 0.074 (1,9) | 0.057 (1,4) |
| MB83528/003X005 | 8865-0120 | 0.062 (1,6) | 0.100 (2,5) | 0.031 (0,8) | 0.076 (1,9) | 0.084 (2,1) |
| MB83528/003X010 | 8865-0140 | 0.075 (1,9) | 0.178 (4,5) | 0.089 (2,3) | 0.093 (2,4) | 0.150 (3,8) |
| MB83528/003X004 | 8865-0116 | 0.093 (2,4) | 0.093 (2,4) | 0.047 (1,2) | 0.109 (2,8) | 0.077 (2,0) |
| MB83528/003X002 | 8865-0110 | 0.094 (2,4) | 0.078 (2,0) | 0.047 (1,2) | 0.109 (2,8) | 0.065 (1,7) |
| MB83528/003X008 | 8865-0135 | 0.118 (3,0) | 0.156 (4,0) | 0.059 (1,5) | 0.140 (3,6) | 0.131 (3,3) |
| MB83528/003X007 | 8865-0130 | 0.122 (3,1) | 0.135 (3,4) | 0.061 (1,5) | 0.141 (3,6) | 0.113 (2,9) |
| MB83528/003X006 | 8865-0125 | 0.150 (3,8) | 0.110 (2,8) | 0.075 (1,9) | 0.165 (4,2) | 0.092 (2,3) |
| MB83528/003X003 | 8865-0115 | 0.178 (4,5) | 0.089 (2,3) | 0.039 (1,0) | 0.182 (4,3) | 0.074 (1,9) |
| MB83528/003X011 | 8865-0144 | 0.188 (4,8) | 0.188 (4,8) | 0.094 (2,4) | 0.220 (5,6) | 0.160 (4,1) |
| MB83528/003X012 | 8865-0145 | 0.250 (6,4) | 0.250 (6,4) | 0.125 (3,2) | 0.286 (7,3) | 0.212 (5,4) |

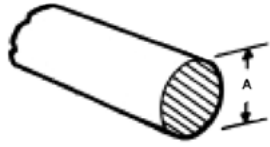
Channel Strips



| MIL-DTL-83528 PART NUMBER | PART NUMBER | DIMENSIONS INCH(MM) | | | |
|------------------------------|-------------|---------------------|--------------|-------------|-------------|
| | | A | B | C | D |
| M83528/010X001 | 8868-0100 | 0.100 (2,5) | 0.100 (2,5) | 0.034 (0,9) | 0.033 (0,8) |
| | 8868-0055 | 0.114 (2,9) | 0.082 (2,1) | 0.030 (0,8) | 0.026 (0,7) |
| M83528/010X002 | 8868-0105 | 0.126 (3,2) | 0.110 (2,8) | 0.025 (0,6) | 0.050 (1,3) |
| M83528/010X003 | 8868-0056 | 0.156 (4,0) | 0.114 (2,9) | 0.030 (0,8) | 0.062 (1,6) |
| M83528/010X004 | 8868-0115 | 0.156 (4,0) | 0.156 (4,0) | 0.062 (1,6) | 0.047 (1,2) |
| | 8868-0067 | 0.175 (4,4) | 0.500 (12,7) | 0.047 (1,2) | 0.075 (1,9) |
| M83528/010X005 | 8868-0120 | 0.175 (4,4) | 0.156 (4,0) | 0.047 (1,2) | 0.075 (1,9) |
| | 8868-0081 | 0.189 (4,8) | 0.189 (4,8) | 0.063 (1,6) | 0.063 (1,6) |
| | 8868-0084 | 0.250 (6,4) | 0.250 (6,4) | 0.062 (1,6) | 0.062 (1,6) |
| | 8868-0085 | 0.252 (6,4) | 0.252 (6,4) | 0.126 (3,2) | 0.063 (1,6) |
| M83528/010X006 | 8868-0125 | 0.327 (8,3) | 0.235 (6,0) | 0.062 (1,6) | 0.115 (2,9) |
| | 8868-0070 | 0.395 (1,0) | 0.120 (3,0) | 0.275 (7,0) | 0.060 (1,5) |
| | 8868-0075 | 0.530 (13,5) | 0.130 (3,3) | 0.390 (9,9) | 0.060 (1,5) |

EXTRUSIONS GUIDE

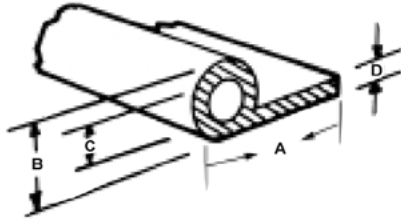
O-Strips



| MIL-DTL-85328 PART NUMBER | PART NUMBER | DIMENSIONS INCH(MM) | RECOMMENDED GROOVE DIMENSIONS (±0.002) | |
|------------------------------|-------------|------------------------|--|-------------|
| | | A | WIDTH | HEIGHT |
| | 8863-0184 | 0.032 (0,8) | 0.036 (0,9) | 0.026 (0,7) |
| M83528/001X001 | 8863-0100 | 0.040 (1,0) | 0.045 (1,1) | 0.032 (0,8) |
| M83528/001X002 | 8863-0105 | 0.053 (1,3) | 0.059 (1,5) | 0.042 (1,1) |
| M83528/001X003 | 8863-0110 | 0.062 (1,6) | 0.066 (1,7) | 0.050 (1,3) |
| M83528/001X004 | 8863-0115 | 0.070 (1,8) | 0.076 (1,9) | 0.056 (1,4) |
| M83528/001X005 | 8863-0120 | 0.080 (2,0) | 0.086 (2,2) | 0.064 (1,6) |
| M83528/001X006 | 8863-0125 | 0.093 (2,4) | 0.100 (2,5) | 0.074 (1,9) |
| | 8863-0196 | 0.098 (2,5) | 0.105 (2,7) | 0.078 (2,0) |
| M83528/001X007 | 8863-0130 | 0.103 (2,6) | 0.110 (2,8) | 0.082 (2,1) |
| | 8863-0135 | 0.112 (2,8) | 0.119 (3,0) | 0.089 (2,3) |
| M83528/001X008 | 8863-0140 | 0.119 (3,0) | 0.126 (3,2) | 0.095 (2,4) |
| M83528/001X009 | 8863-0145 | 0.125 (3,2) | 0.133 (3,4) | 0.100 (2,5) |
| | 8863-0150 | 0.130 (3,3) | 0.137 (3,5) | 0.104 (2,6) |
| M83528/001X010 | 8863-0160 | 0.139 (3,5) | 0.147 (3,7) | 0.111 (2,8) |
| | 8863-0165 | 0.150 (3,8) | 0.158 (4,0) | 0.120 (3,0) |
| | 8863-0170 | 0.160 (4,1) | 0.168 (4,3) | 0.128 (3,3) |
| | 8863-0197 | 0.186 (4,7) | 0.197 (5,0) | 0.149 (3,8) |
| M83528/001X011 | 8863-0183 | 0.188 (4,8) | 0.200 (5,1) | 0.150 (3,8) |
| | 8863-0198 | 0.194 (4,9) | 0.209 (5,3) | 0.156 (4,0) |
| | 8863-0199 | 0.197 (5,0) | 0.210 (5,3) | 0.158 (4,0) |
| M83528/001X0012 | 8863-0175 | 0.216 (5,5) | 0.229 (5,8) | 0.173 (4,4) |
| M83528/001X013 | 8863-0180 | 0.250 (6,4) | 0.267 (6,8) | 0.200 (5,1) |
| | 8863-0200 | 0.256 (6,5) | 0.274 (7,0) | 0.205 (5,2) |
| | 8863-0201 | 0.312 (7,9) | 0.337 (8,6) | 0.250 (6,4) |
| | 8863-0202 | 0.374 (9,5) | 0.400 (10,2) | 0.300 (7,6) |

EXTRUSIONS GUIDE

P-Strips



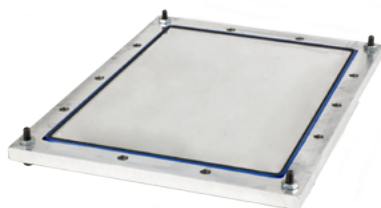
| MIL-DTL-83528 PART NUMBER | PART NUMBER | DIMENSIONS INCH(MM) | | | |
|------------------------------|----------------|---------------------|--------------|--------------|-------------|
| | | A | B | C | D |
| | 8867-0136 | 0.275 (7,0) | 0.140 (3,6) | 0.085 (2,2) | 0.030 (0,8) |
| | 8867-0147 | 0.290 (7,4) | 0.095 (2,4) | 0.062 (1,6) | 0.025 (0,6) |
| | 8867-0128 | 0.415 (10,5) | 0.200 (5,1) | 0.060 (1,5) | 0.062 (1,6) |
| | 8867-0141 | 0.425 (10,8) | 0.250 (6,4) | 0.151 (3,8) | 0.050 (1,3) |
| M83528/008X007 | 8867-0101 | 0.475 (12,1) | 0.200 (5,1) | 0.080 (2,0) | 0.062 (1,6) |
| | 8867-0127 | 0.500 (12,7) | 0.200 (5,1) | 0.076 (1,9) | 0.062 (1,6) |
| M83528/008X002 | 8867-0105 | 0.500 (12,7) | 0.250 (6,4) | 0.125 (3,2) | 0.062 (1,6) |
| | 8867-0126 | 0.600 (15,2) | 0.250 (6,4) | 0.125 (3,2) | 0.062 (1,6) |
| M83528/008X004 | 8867-0102 | 0.640 (16,3) | 0.208 (5,3) | 0.080 (2,0) | 0.072 (1,8) |
| | 8867-0158 | 0.752 (19,1) | 0.252 (6,4) | 0.189 (4,8) | 0.063 (1,6) |
| | 8867-0165 | 0.752 (19,1) | 0.437 (11,1) | 0.347 (8,8) | 0.060 (1,5) |
| M83528/008X006 | 8867-0130 | 0.780 (19,8) | 0.360 (9,1) | 0.255 (6,5) | 0.070 (1,8) |
| M83528/008X001 | 8867-0100 | 0.850 (21,6) | 0.200 (5,1) | 0.080 (2,0) | 0.062 (1,6) |
| | 8867-0166 | 0.874 (22,2) | 0.500 (12,7) | 0.400 (10,2) | 0.065 (1,7) |
| M83528/008X005 | 8867-0125 | 0.875 (22,2) | 0.312 (7,9) | 0.187 (4,8) | 0.062 (1,6) |

GEMINI™ COEXTRUSIONS

MULTI-EXTRUSION, BI-FUNCTIONAL ELASTOMER GASKET

Laird' Gemini™ product line is a high-performance gasket solution that combines a reliable environmental silicone elastomer seal with an electrically conductive elastomer. Conductive particle filler results in a product with lower material cost and an improved environmental seal against water, moisture, dust and mildly corrosive atmospheric conditions due to smog.

Our conductive extrusions offer a wide choice of profiles to fit a large range of applications. The cross-sections shown on the following pages are offered as standard. Custom dies can be built to accommodate your specific design.



FEATURES

- Combines the strength of silicone rubber with Laird' proprietary conductive elastomer EMI shielding materials and knowledge
- Improved environmental seal
- Improved EMI performance over lifetime
- Cost-effective
- Available in both standard and custom profiles
- Ability to use finite element analysis to design the best custom gasket for your application

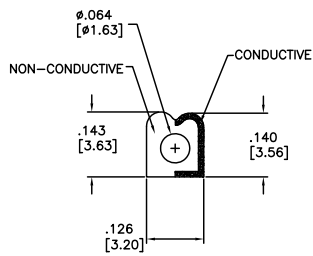
MARKETS

- Wireless infrastructure
- Remote radio units
- Telecom cabinets
- Radar
- IT cabinets
- All electronic cabinets or electronic chassis that require both an environmental seal and EMI shielding

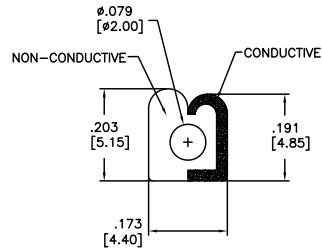
| | | TYPICAL COEXTRUSION GASKET DESIGN | | | | | | |
|-----------------------------|---------------------------|-----------------------------------|----------|----------|----------------------|-------------|----------|----------|
| | | NONCONDUCTIVE ELASTOMER | | | CONDUCTIVE ELASTOMER | | | |
| PARAMETER | TEST METHOD | NCE220 | NCE251 | NCE250 | ECE72 | ECE93 | ECE116 | ECE115 |
| Polymer matrix | | Silicone | Silicone | Silicone | Silicone | Silicone | Silicone | Silicone |
| Filler | | | | | Ni/Graphite | Ni/graphite | Ag/Al | Ag/Glass |
| Color | Visual Inspection | Blue | Grey | Orange | Grey | Black | Tan | Tan |
| Hardness, Shore A | ASTM D2240 | 70 | 45 | 60 | 75 | 65 | 65 | 65 |
| Density, g/cm3 | ASTM D792 | 1.2 | 1.2 | 1.2 | 2.3 | 1.9 | 2 | 1.9 |
| Tensile strength, psi, min. | ASTM D412 | 400 | 700 | 800 | 280 | 150 | 200 | 200 |
| Elongation to break | ASTM D412 | 100-300% | 100-300% | 100-300% | 150% | 100-300% | 100-301% | 100-302% |
| Tear Strength, ppi, min. | ASTM D624, die C | 30 | 60 | 60 | 50 | 30 | 30 | 30 |
| Compression set, %, max. | ASTM D395 | 35% | 10% | 10% | 30% | 30% | 32% | 30% |
| Working Temperature | | | | | | | | |
| Maximum, oC | "MIL-DTL-83528C (4.5.15)" | 160 | 160 | 160 | 160 | 160 | 160 | 160 |
| Minimum, oC | ASTM D1329 | -55 | -55 | -55 | -55 | -55 | -55 | -55 |
| Flame Retardance | UL94 | NA | V0 | V0 | V0 | HB | V0 | V0 |

GEMINI COEXTRUSIONS

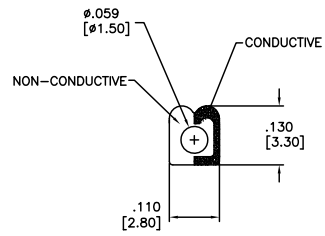
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8890-MGS103072-93

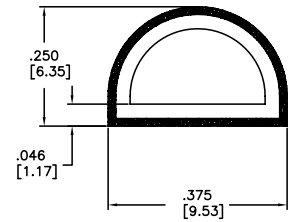


8890 0001 XX A



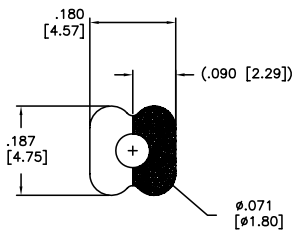
8890 0002 XX A

D

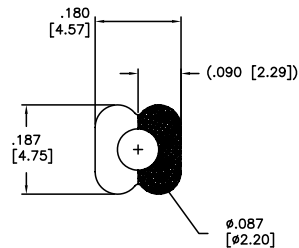


8894 0001 XX A

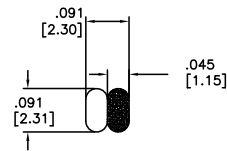
DD



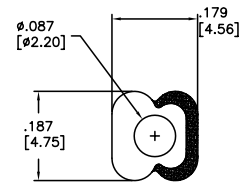
8898 0001 XX A



8898 0002 XX A



8899 0001 XX A



8898 0003 XX A

FABRICATED COMPONENTS GUIDE

OVERVIEW

Laird provides a full line of fabricated conductive elastomers. These products are offered in a wide range of materials to meet your particular application. In addition to the standard components shown, Laird can supply molded and vulcanized EcE gaskets to meet custom configurations required to package electronic components in either cast or sheet metal enclosures.

MOLDED O-RINGS

O-rings, when installed in a groove design that allows 10%–20% compression and 80%–95% gland fill, will provide both an EMI and moisture seal. Custom tools can be fabricated for prototypes and production quantities when diameters are larger than 2.000 in. (50,8 mm). Round strips can also be vulcanized to create O-rings to include parts with diameters larger than 3.000 in. (76,2 mm). Consult Laird sales department for sizes not shown in this catalog.

FLAT WASHERS

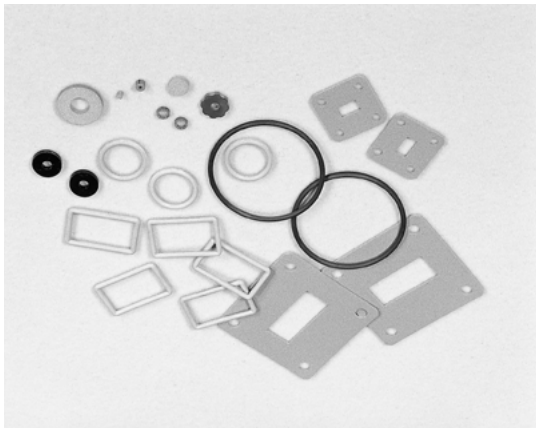
Table 3 shows some of the standard sizes of washers that can be die-cut from sheet material. Besides the circular shape, intricate shapes can be designed and die-cut to meet custom requirements.

MOLDED D-RINGS

Tables 4, 5 and 6 show standard sizes of molded rings. These components, as in the O-rings above, can be supplied spliced and vulcanized to dimensions in excess of two inches I.D.

FLAT WAVEGUIDE GASKETS

The die-cut gaskets shown in Tables 7 and 8 are designed to provide effective EMI shielding and pressure sealing for choke cover and contact flanges. Gaskets shown in this table can be supplied from the sheet materials shown in Table A.



SHEET MATERIAL

Table A lists thicknesses and sizes for our molded sheet material, while Table 2, pages 14–17, shows the compounds available for all of our conductive silicone elastomers.

HOW TO SPECIFY

1. Determine the standard Laird part number from Tables 1–8 on page 14 based upon configuration.

FABRICATED COMPONENTS GUIDE

Molded EMI O-Rings

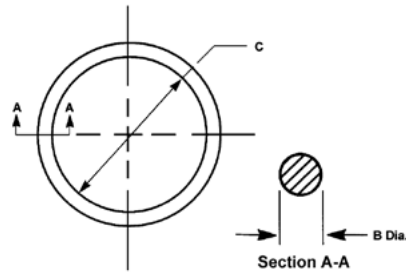


TABLE 1. MIL-DTL-83528 SERIES

| MIL-DTL-83528 PART NUMBER | LAIRD PART NUMBER | DIMENSIONS INCH(MM) | | MIL-DTL-83528 PART NUMBER | LAIRD PART NUMBER | DIMENSIONS INCH(MM) | |
|------------------------------|----------------------|---------------------|-------------|------------------------------|----------------------|---------------------|-------------|
| | | C | B | | | C | B |
| M83528/002X007 | 8563-0322-XX | 0.050 (1,3) | 0.063 (1,6) | M83528/002X018 | 8563-0075-XX | 0.739 (18,8) | 0.070 (1,8) |
| | 8563-0068-XX | 0.145 (3,7) | 0.070 (1,8) | | 8563-0218-XX | 0.755 (19,2) | 0.097 (2,5) |
| | 8563-0143-XX | 0.150 (3,8) | 0.062 (1,6) | M83528/002X019 | 8563-0076-XX | 0.801 (20,3) | 0.070 (1,8) |
| | 8563-0334-XX | 0.176 (4,5) | 0.070 (1,8) | M83528/002X020 | 8563-0077-XX | 0.864 (21,9) | 0.070 (1,8) |
| | 8563-0326-XX | 0.260 (6,6) | 0.030 (0,8) | | 8563-0344-XX | 0.921 (23,4) | 0.139 (3,5) |
| | 8563-0343-XX | 0.270 (6,9) | 0.070 (1,8) | M83528/002X021 | 8563-0078-XX | 0.926 (23,5) | 0.070 (1,8) |
| M83528/005X006 | 8563-0106-XX | 0.295 (7,5) | 0.048 (1,2) | M83528/002X022 | 8563-0079-XX | 0.989 (25,1) | 0.070 (1,8) |
| M83528/002X011 | 8563-0069-XX | 0.301 (7,6) | 0.070 (1,8) | | 8563-0213-XX | 0.989 (25,1) | 0.070 (1,8) |
| M83528/002X012 | 8563-0070-XX | 0.364 (9,2) | 0.070 (1,8) | | 8563-0279-XX | 1.000 (25,4) | 0.250 (6,4) |
| | 8563-0243-XX | 0.415 (10,5) | 0.057 (1,4) | | 8563-0062-XX | 1.100 (27,9) | 0.070 (1,8) |
| M83528/002X013 | 8563-0071-XX | 0.426 (10,8) | 0.070 (1,8) | M83528/002X024 | 8563-0080-XX | 1.114 (28,3) | 0.070 (1,8) |
| M83528/005X008 | 8563-0108-XX | 0.446 (11,3) | 0.051 (1,3) | M83528/005X013 | 8563-0113-XX | 1.182 (30,0) | 0.068 (1,7) |
| M83528/002X014 | 8563-0072-XX | 0.489 (12,4) | 0.070 (1,8) | M83528/002X026 | 8563-0089-XX | 1.239 (31,5) | 0.070 (1,8) |
| | 8563-0196-XX | 0.492 (12,5) | 0.070 (1,8) | | 8563-0161-XX | 1.239 (31,5) | 0.070 (1,8) |
| | 8563-0327-XX | 0.500 (12,7) | 0.100 (2,5) | M83528/002X126 | 8563-0094-XX | 1.362 (34,6) | 0.103 (2,6) |
| M83528/002X015 | 8563-0073-XX | 0.551 (14,0) | 0.070 (1,8) | M83528/002X028 | 8563-0090-XX | 1.364 (34,6) | 0.070 (1,8) |
| M83528/005X016 | 8563-0116-XX | 0.610 (15,5) | 0.070 (1,8) | | 8563-0165-XX | 1.366 (34,7) | 0.070 (1,8) |
| M83528/002X114 | 8563-0091-XX | 0.612 (15,5) | 0.103 (2,6) | | 8563-0324-XX | 1.463 (37,2) | 0.080 (2,0) |
| | 8563-0285-XX | 0.632 (16,1) | 0.062 (1,6) | M83528/002X128 | 8563-0095-XX | 1.487 (37,8) | 0.103 (2,6) |
| M83528/002X017 | 8563-0074-XX | 0.676 (17,2) | 0.070 (1,8) | | 8563-0164-XX | 1.487 (37,8) | 0.103 (2,6) |
| | 8563-0211-XX | 0.676 (17,2) | 0.070 (1,8) | | 8563-0166-XX | 1.489 (37,8) | 0.070 (1,8) |

FABRICATED COMPONENTS GUIDE

TABLE 1. MIL-DTL-83528 SERIES (CONT'D)

| MIL-DTL-83528 PART NUMBER | LAIRD PART NUMBER | DIMENSIONS INCH(MM) | | MIL-DTL-83528 PART NUMBER | LAIRD PART NUMBER | DIMENSIONS INCH(MM) | |
|------------------------------|----------------------|---------------------|-------------|------------------------------|----------------------|---------------------|-------------|
| | | C | B | | | C | B |
| M83528/005X022 | 8563-0122-XX | 1.612 (40,9) | 0.103 (2,6) | | 8563-0281-XX | 3.989 (101,3) | 0.070 (1,8) |
| M83528/002X132 | 8563-0096-XX | 1.737 (44,1) | 0.103 (2,6) | | 8563-0274-XX | 4.450 (113,0) | 0.070 (1,8) |
| | 8563-0167-XX | 1.739 (44,2) | 0.070 (1,8) | | 8563-0139-XX | 4.690 (119,1) | 0.062 (1,6) |
| M83528/005X023 | 8563-0123-XX | 1.790 (45,5) | 0.103 (2,6) | M83527/002X155 | 8563-0315-XX | 5.858 (148,8) | 0.070 (1,8) |
| M83528/002X134 | 8563-0097-XX | 1.862 (47,3) | 0.103 (2,6) | | 8563-0185-XX | 6.000 (152,4) | 0.103 (2,6) |
| | 8563-0168-XX | 1.989 (50,5) | 0.070 (1,8) | | 8563-0234-XX | 6.312 (160,3) | 0.070 (1,8) |
| | 8563-0280-XX | 2.000 (50,8) | 0.250 (6,4) | | 8563-0342-XX | 7.322 (186,0) | 0.103 (2,6) |
| | 8563-0159-XX | 2.050 (52,1) | 0.103 (2,6) | | 8563-0226-XX | 7.491 (190,3) | 0.070 (1,8) |
| M83528/002X142 | 8563-0098-XX | 2.367 (60,1) | 0.103 (2,6) | | 8563-0323-XX | 8.750 (222,3) | 0.250 (6,4) |
| | 8563-0232-XX | 2.614 (66,4) | 0.070 (1,8) | | 8563-0263-XX | 9.370 (238,0) | 0.103 (2,6) |
| | 8563-0180-XX | 3.158 (80,2) | 0.062 (1,6) | | 8563-0187-XX | 9.984 (253,6) | 0.139 (3,5) |
| | 8563-0241-XX | 3.209 (81,5) | 0.070 (1,8) | | 8563-0339-XX | 10.303 (261,7) | 0.103 (2,6) |
| | 8563-0216-XX | 3.806 (96,7) | 0.125 (3,2) | | 8563-0140-XX | 12.812 (325,4) | 0.125 (3,2) |

O-rings with a diameter less than 3" (76,2 mm) will be molded.

O-rings with a diameter of 3" (76,2 mm) or more may be molded or spliced.

TABLE 2. MIL-DTL-83528/013 JAM NUT SEALS

| SHELL SIZE | LAIRD PART NUMBER | | DIMENSIONS INCH(MM) | |
|---------------|---------------------------------|---------------|---------------------|-------------|
| | MIL-DTL-38999/ MIL-DTL-26482 | MIL-DTL-81511 | C | B |
| 6 | 8563-0073-XX | | 0.551 (14,0) | 0.070 (1,8) |
| 8 | 8563-0074-XX | | 0.676 (17,2) | 0.070 (1,8) |
| 8 | | 8563-0075-XX | 0.739 (18,8) | 0.070 (1,8) |
| 9, 10 | 8563-0076-XX | | 0.801 (20,3) | 0.070 (1,8) |
| 9, 10 | | 8563-0077-XX | 0.864 (21,9) | 0.070 (1,8) |
| 11, 12 | 8563-0079-XX | | 0.989 (25,1) | 0.070 (1,8) |
| 13, 14 | 8563-0080-XX | 8563-0080-XX | 1.114 (28,3) | 0.070 (1,8) |
| 15, 16 | 8563-0089-XX | 8563-0089-XX | 1.239 (31,5) | 0.070 (1,8) |
| 17, 18 | 8563-0090-XX | 8563-0090-XX | 1.364 (34,6) | 0.070 (1,8) |
| 19, 20 | 8563-0095-XX | | 1.487 (37,8) | 0.103 (2,6) |
| 23, 24 | 8563-0096-XX | | 1.737 (44,1) | 0.103 (2,6) |

FABRICATED COMPONENTS GUIDE

Flat Washer Gaskets

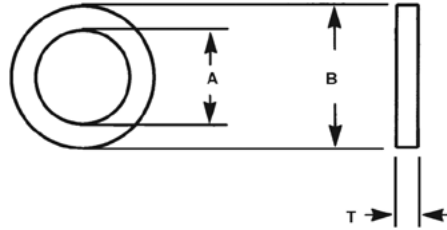
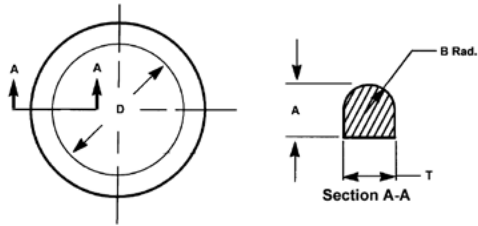


TABLE 3. MIL-DTL-83528 SERIES

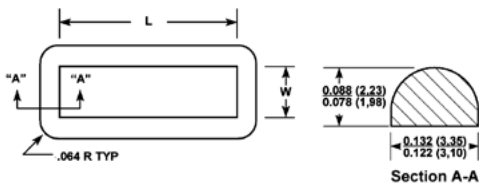
| MIL-DTL-83528 PART NUMBER | LAIRD PART NUMBER | DIMENSIONS INCH(MM) | | |
|------------------------------|-------------------|---------------------|--------------|--------------|
| | | A | B | T |
| | 8560-0231-XX | 0.120 (3,0) | 0.260 (6,6) | 0.030 (0,8) |
| | 8560-0234-XX | 0.171 (4,3) | 0.390 (9,9) | 0.060 (1,5) |
| | 8560-0233-XX | 0.218 (5,5) | 0.468 (11,9) | 0.030 (0,8) |
| M83528/012X001 | 8560-0097-XX | 0.250 (6,4) | 0.625 (15,9) | 0.032 (0,8) |
| M83528/012X002 | 8560-0158-XX | 0.250 (6,4) | 0.562 (14,3) | 0.060 (1,5) |
| | 8560-0435-XX | 0.250 (6,4) | 0.750 (19,1) | 0.032 (0,8) |
| | 8560-0299-XX | 0.319 (8,1) | 0.422 (10,7) | 0.075 (1,9) |
| M83528/012X004 | 8560-0143-XX | 0.375 (9,5) | 0.750 (19,1) | 0.062 (1,6) |
| M83528/012X003 | 8560-0098-XX | 0.375 (9,5) | 0.750 (19,1) | 0.031 (0,8) |
| | 8560-0331-XX | 0.375 (9,5) | 0.750 (19,1) | 0.032 (0,8) |
| | 8560-0444-XX | 0.380 (9,7) | 0.960 (24,4) | 0.065 (1,7) |
| | 8560-0200-XX | 0.433 (11,0) | 0.508 (12,9) | 0.045 (1,1) |
| M83528/012X005 | 8560-0099-XX | 0.500 (12,7) | 0.656 (16,7) | 0.031 (0,8) |
| M83528/012X007 | 8560-0100-XX | 0.500 (12,7) | 0.875 (22,2) | 0.031 (0,8) |
| M83528/012X006 | 8560-0144-XX | 0.500 (12,7) | 0.656 (16,7) | 0.062 (1,6) |
| M83528/012X008 | 8560-0145-XX | 0.500 (12,7) | 0.875 (22,2) | ≤0.062 (1,6) |
| | 8560-0330-XX | 0.500 (12,7) | 0.656 (16,7) | 0.032 (0,8) |
| | 8560-0311-XX | 0.641 (16,3) | 0.703 (17,9) | 0.032 (0,8) |
| | 8560-0505-XX | 0.800 (20,3) | 1.000 (25,4) | 0.156 (4,0) |
| | 8560-0453-XX | 0.890 (22,6) | 1.250 (31,8) | 0.062 (1,6) |

FABRICATED COMPONENTS GUIDE

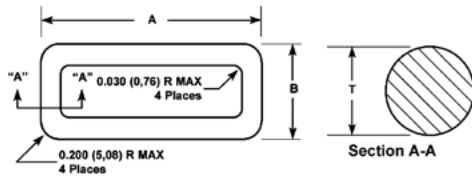
Molded Waveguide Gaskets


TABLE 4. CIRCULAR “D” SECTION

| MIL-DTL-83528 PART NUMBER | LAIRD PART NUMBER | NOMINAL DIMENSIONS INCH(MM) | | | |
|------------------------------|-------------------|-----------------------------|-------------|--------------|-------------|
| | | A | B | D | T |
| M83528/013X002 | 8563-0126-XX | 0.056 (1,4) | 0.041 (1,0) | 0.410 (10,4) | 0.082 (2,1) |
| M83528/013X004 | 8563-0127-XX | 0.048 (1,2) | Full Radius | 0.587 (14,9) | 0.078 (2,0) |
| M83528/013X006 | 8563-0128-XX | 0.125 (3,2) | Full Radius | 0.885 (22,5) | 0.155 (3,9) |
| M83528/013X008 | 8563-0129-XX | 0.065 (1,7) | 0.049 (1,2) | 1.122 (28,5) | 0.099 (2,5) |
| M83528/013X011 | 8563-0131-XX | 0.088 (2,2) | Full Radius | 1.340 (34,0) | 0.095 (2,4) |
| M83528/013X012 | 8563-0130-XX | 0.077 (2,0) | Full Radius | 1.310 (33,3) | 0.115 (2,9) |
| M83528/013X017 | 8563-0133-XX | 0.078 (2,0) | Full Radius | 1.550 (39,4) | 0.105 (2,7) |


TABLE 5. RECTANGULAR “D” SECTION

| MIL-DTL-83528 PART NUMBER | LAIRD PART NUMBER | WIDTH DIMENSIONS INCH(MM) | | LENGTH DIMENSIONS INCH(MM) | |
|------------------------------|-------------------|------------------------------|--------------|-------------------------------|---------------|
| | | MIN | MAX | MIN | MAX |
| M83528/006X001 | 8563-0253-XX | 0.285 (7,2) | 0.295 (7,5) | 0.983 (25,0) | 0.993 (25,2) |
| M83528/006X002 | 8563-0254-XX | 0.485 (12,3) | 0.495 (12,6) | 0.983 (25,0) | 0.993 (25,2) |
| M83528/006X003 | 8563-0255-XX | 0.619 (15,7) | 0.629 (16,0) | 1.243 (31,6) | 1.243 (31,6) |
| M83528/006X005 | 8563-0257-XX | 1.325 (33,7) | 1.355 (34,4) | 5.265 (133,7) | 5.295 (134,5) |


TABLE 6. RECTANGULAR “O” SECTION

| MIL-DTL-83528 PART NUMBER | LAIRD PART NUMBER | DIMENSIONS INCH(MM) | | |
|------------------------------|-------------------|---------------------------------|-------------------------------|------------------------------|
| | | A | B | T |
| M83528/013X013 | 8563-0248-XX | 1.368 (34,7) ± 0.012 (0,3) | 0.868 (22,0) ± 0.010 (0,3) | 0.103 (2,6) ± 0.003 (0,1) |
| M83528/013X018 | 8563-0249-XX | 1.616 (41,0) ± 0.015 (0,4) | 0.991 (25,2) ± 0.010 (0,3) | 0.103 (2,6) ± 0.003 (0,1) |
| M83528/013X023 | 8563-0250-XX | 11.866 (301,4) ± 0.015 (0,4) | 1.116 (28,3) ± 0.012 (0,3) | 0.103 (2,6) ± 0.003 (0,1) |
| M83528/013X030 | 8563-0251-XX | 2.449 (62,2) ± 0.020 (0,5) | 1.449 (36,8) ± 0.013 (0,3) | 0.139 (3,5) ± 0.004 (0,1) |
| M83528/013X037 | | 3.451 (87,7) ± 0.024 (0,6) | 1.951 (49,6) ± 0.004 (0,1) | 0.139 (3,5) ± 0.004 (0,1) |

FABRICATED COMPONENTS GUIDE

Rectangular Waveguide Gaskets

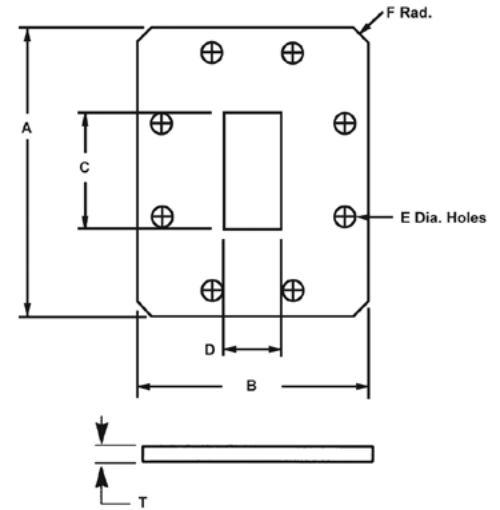
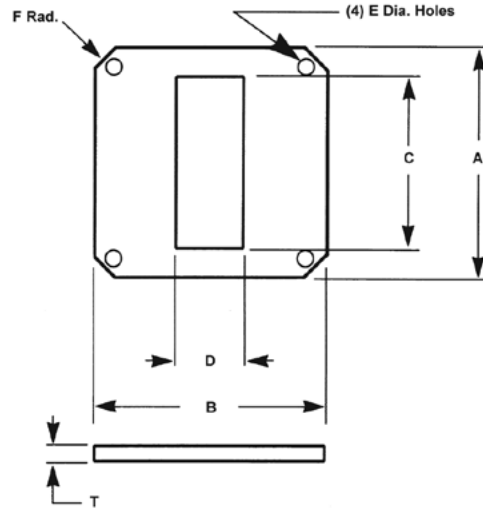


TABLE 7.

| MIL-DTL-83528 PART NUMBER | LAIRD PART NUMBER | DIMENSIONS INCH(MM) | | | | | | |
|------------------------------|----------------------|---------------------|-------------------|------------------|------------------|----------------------------|------------------|-------------------|
| | | A | B | C | D | E | T | F RADIUS |
| M83528/013X001 | 8560-0104-XX Fig. 1 | ± 0.750 (19,1) | ± 0.750 (19,1) | ± 0.145 (3,7) | ± 0.285 (7,2) | ± 0.116 (2,9) | ± 0.027 (0,7) | ± 0.469 (11,9) |
| M83528/013X003 | 8560-0105-XX Fig. 1 | 0.875 (22,2) | 0.875 (22,2) | 0.175 (4,4) | 0.425 (10,8) | 0.116 (2,9) | 0.027 (0,7) | 0.563 (14,3) |
| M83528/013X005 | 8560-0106-XX Fig. 1 | 1.313 (33,4) | 1.313 (33,4) | 0.630 (16,0) | 0.320 (8,1) | 0.140 (3,6) | 0.027 (0,7) | 0.875 (22,2) |
| M83528/013X007 | 8560-0103-XX Fig. 1 | 1.496 (38,0) | 1.496 (38,0) | 0.760 (19,3) | 0.385 (9,8) | 0.155 (3,9) | 0.027 (0,7) | 0.450 (11,4) |
| M83528/013X009 | 8560-0107-XX Fig. 1 | 1.625 (41,3) | 1.625 (41,3) | 0.905 (23,0) | 0.405 (10,3) | 0.169 (4,3) | 0.027 (0,7) | 0.469 (11,9) |
| M83528/013X015 | 8560-0108-XX Fig. 1 | 1.875 (47,6) | 1.875 (47,6) | 1.130 (28,7) | 0.505 (12,8) | 0.180 (4,6) | 0.027 (0,7) | 1.150 (29,2) |
| M83528/013X016 | 8560-0113-XX Fig. 2 | 1.750 (44,5) | 2.500 (63,5) | 0.505 (12,8) | 1.130 (28,7) | 0.171 (4,3) | 0.027 (0,7) | 0.250 (6,4) |
| M83528/013X020 | 8560-0114-XX Fig. 2 | 1.937 (49,2) | 2.687 (68,3) | 0.633 (16,1) | 1.380 (35,1) | 0.206 (5,2) | 0.027 (0,7) | 0.250 (6,4) |
| M83528/013X027 | 8560-0116-XX Fig. 2 | 3.500 (88,9) | 2.500 (63,5) | 1.880 (47,8) | 0.880 (22,4) | 0.226 (5,7) | 0.027 (0,7) | 0.313 (8,0) |
| M83528/013X028 | Fig. 2 | 1.764 (44,8) | 2.781 (70,6) | 0.882 (22,4) | 1.882 (47,8) | 0.156 (4,0) 0.141 | 0.027 (0,7) | 0.125 (3,2) |
| M83528/013X031 | Fig. 2 | 2.750 (69,9) | 3.875 (98,4) | 1.155 (29,3) | 2.300 (58,4) | 0.270 (6,9) | 0.027 (0,7) | 0.312 (7,9) |
| M83528/013X040 | 8560-0110-XX Fig. 2 | 4.188 (106,4) | 6.344 (161,1) | 2.160 (54,9) | 4.310 (109,5) | 0.266 (6,8) 0.281 (7,1) | 0.027 (0,7) | 0.250 (6,4) |

FABRICATED COMPONENTS GUIDE

The waveguide gaskets listed in the Waveguide Gasket Selection Guide will fit standard UG, CPR and CMR flanges. The letters (A, B, C, D, E) shown in the “Gasket Config.” column correspond to the MIL-DTL-83528/013 part configurations as follows:

Type A — Square & Rectangular Die-Cut Gaskets
 Type B — Circular Die-Cut Gaskets
 Type C — Molded Rectangular “O” Cross Section
 Type D — Molded Circular “O” Cross Section
 Type E — Molded Circular “D” Cross Section

TABLE 8. WAVEGUIDE GASKET SELECTION GUIDE

| FREQUENCY RANGE GHZ. | BAND | EIA WAVEGUIDE SIZE | DESIGNATION MIL-W | FLANGE DESCRIPTION | | | FLANGE TYPE | GASKET CONFIG | MIL-DTL-83528/013 PAGE NO. |
|----------------------|------|--------------------|---|--|----------|----------|----------------|---------------|----------------------------|
| | | | | UG | CPR | CMR | | | |
| 26.5 - 40.0 | Ka | WR28 | RG-96U (Silver) | UG-599/U UG-600A/U | | | Cover Choke | A E | 001 (1) |
| 18.0 - 26.5 | K | WR42 | RG-53/U (Brass) RG-121/U (Aluminum) | UG-595/U UG-597/U UG-596A/U UG-598A/U | | | Cover Choke | A E | 003 (1) 004 |
| 12.4 - 18.0 | Ku | WR62 | RG-91/U (Brass) RG-107/U (Silver) | UG-419/U UG-541A/U | | | Cover Choke | A E | 005 (1) 006 |
| 10.0 - 15.0 | | WR75 | | UG | | | Cover Choke | A E | 007 008 |
| 8.2 - 12.4 | X | WR90 | RG-52/U (Brass) RG-67/U (Aluminum) | UG-39/U UG-135/U | | | Cover | A | 009 |
| | | | | UG-1736/U UG-1737/U | CPR-90F | | Flat Contact | A | 010 (2) |
| | | | | UG-136A/U UG-40A/U | | | Choke | E | 011 |
| | | | | UG-136B/U UG-40B/U | | | Choke | E | 012 |
| | | | | UG-1360/U UG-1361/U | CPR-90G | | Contact | C | 013 |
| | | | | UG-1494/U | | | Choke | E | 014 |
| 7.0 - 11.0 | | WR102 | | | | | | | |
| 7.05 - 10.0 | X1 | WR112 | RG-51/U (Brass) RG-68/U (Aluminum) | UG-51/U UG-138/U | | | Cover | A | 015 |
| | | | | UG-1734/U UG-1735/U | CPR-112F | | Flat Contact | A | 016 |
| | | | | UG-52B/U UG-137B/U | | | Choke | E | 017 |
| | | | | UG-1358/U UG-1359/U | CPR-112G | | Contact | C | 018 |
| | | | | UG-344/U UG-138/U | | | Cover | B | 019 |
| 5.85 - 8.2 | Xb | WR137 | RG-50/U (Brass) RG-108/U (Aluminum) | UG-1732/U UG-1733/U | CPR-137F | | Flat Contact | A | 020 (1) |
| | | | | | | CMR-137 | Flat Contact | A | 021(1) |
| | | | | UG-343B/U UG-440B/U | | | Choke | D | 022 |
| | | | | UG-1356/U UG-1357/U | | CPR-137G | Contact | C | 023 |
| | | | | UG-1730/U UG-1731/U | | CPR-159F | Flat Contact | A | 024 (1) |
| 4.9 - 7.05 | | WR159 | | | | CMR-159 | Flat Contact | A | 025 (1) |
| 3.95 - 5.85 | C | WR187 | RG-49/U (Brass) RG-95/U (Aluminum) | UG-149A/U UG-407/U | | | Cover | B | 026 |
| | | | | UG-1728/U UG-1729/U | | CPR-187F | Flat Contact | A | 027 (1) |
| | | | | | | CMR-187 | Flat Contact | A | 028 (1) |
| | | | | UG-148C/U UG-406B/U | | | Choke | D | 029 |
| | | | | UG-1352/U UG-1353/U | | CPR-187G | Contact | C | 030 |
| 3.30 - 4.90 | | WR229 | | UG-1726/U UG-1727/U | | CPR-229F | Flat Contact | A | 031 (1) |
| | | | | | | CMR-229 | Flat Contact | A | 032 (1) |
| 2.6 - 3.95 | S | WR284 | RG-48/U (Brass) RG-75/U (Aluminum) | UG-53/U UG-584/U | | | Cover | B | 033 |
| | | | | UG-1724/U UG-1725/U | | CPR-248F | Flat Contact | A | 034 (1) |
| | | | | | | CMR-284 | Flat Contact | A | 035 (1) |
| | | | | UG-54B/U UG-585A/U | | | Choke | E | 036 |
| | | | | UG-1348/U UG-1349/U | | CPR-284G | Contact | C | 037 |
| | | | | UG-533/U UG-554/U | | | Flat Contact | A | 038 (1) |
| 2.2 - 3.3 | | WR340 | RG-112/U (Brass) RG-112/U (Aluminum) | | | CPR-340F | Flat Contact | A | 039 (1) |
| 1.7- 2.6 | W | WR430 | RG-104/U (Brass) RG-105/U (Aluminum) | UG-435A/U UG-437A/U | | | Flat Contact | A | 040 (1) |
| | | | | | | CPR-430F | Flat Contact | A | 041 (1) |
| 1.12 - 1.7 | L | WR650 | RG-69/U (Brass) RG-103/U (Aluminum) | UG-417A/U UG-418A/U | | | Flat Contact | A | 042 (1) |

AUTOMATED FORM-IN-PLACE EMI GASKET TECHNOLOGIES

INTRODUCTION

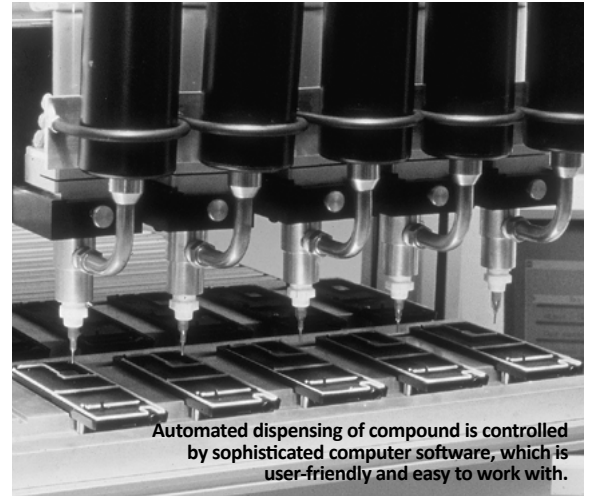
Laird form-in-place is an automated system for dispensing conductive elastomer EMI shielding and grounding gaskets onto metal or plastic substrates. Form-in-place is particularly well suited for cellularphones, PDAs, PC cards, telecom base stations, radios, and many other compartmentalized cast or plastic enclosures and packaged electronic assemblies.

Utilizing programmable 3-axis CNC dispensing equipment, the compound is dispensed accurately onto the substrate and creates a secure bond during the curing process. The repeatable computer-controlled dispensing pattern insures consistency between parts and rapid part program changes. In addition, it supports all levels of volume – from prototyping to high-volume electronic component production – via the use of one or multiple dispensing heads. The system is programmed to apply custom gasket configurations onto parts, to form multiple levelson the part, and on slopes up to approximately 70°.

Laird RXP compounds are Room Temperature Vulcanizing (RTV) elastomers and HXP compounds are High Temperature Vulcanizing (HTV) elastomers, both filled with proprietary conductive particles. Dispensed gasket beads of RXP compounds may be handled in 3 hours, and are cured in 24 hours, under conditions of standard temperature and 50% Relative Humidity. Dispensed gasket beads of HXP compounds can be handled after the materials are cured in an oven. The compounds have a working compression range from 10% to 50% of the gasket height, with a recommended design compression of 30% against a mechanical compression stop. Our product is designed to support low closure forces and is compatible with plastic, metal, and plated or chromate finished substrates.

The required force to compress a given bead is a function of the compound and the gasket size; i.e. smaller gaskets require less force than larger gaskets. Please refer to our technical data for details. Gaskets are dispensed on substrates within a placement tolerance of ± 0.001 inches and gasket cross-sectional tolerances from ± 0.003 to 0.007 inches. Refer to Table 1 on page 39 for typical gasket dimensions and tolerances. As a normal course of equipment operations, starting points and termination ends of the gaskets will have profiles that are approximately 25% larger than the running gaskets.

TYPICAL APPLICATION FOR FORM-IN-PLACE GASKETS:

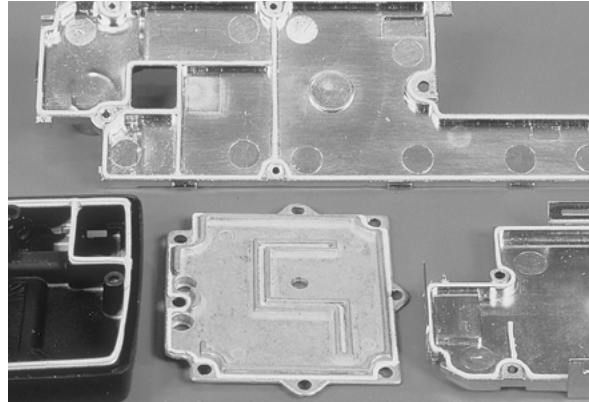
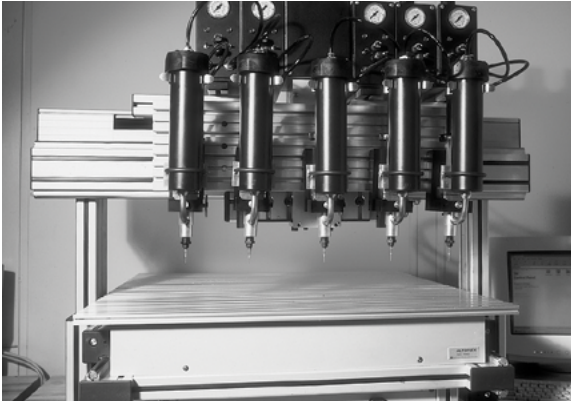


Automated dispensing of compound is controlled by sophisticated computer software, which is user-friendly and easy to work with.

FORM-IN-PLACE GASKETING FEATURES AND BENEFITS

- Form-in-place gasketing offers a total cost savings in the form of reduced raw materials, labor or assembly time
- Room temperature cure gasketing materials eliminate the need for costly heat curing systems, allowing the use of inexpensive plastic or metal substrates
- Single-component compounds eliminate the need for mixing ingredients, thereby shortening production cycles and eliminating related waste
- Easy to program operating system allows for quick part-to-part change-over, minimal tooling investment for new designs, and prototype development in 24 to 48 hours
- High shielding effectiveness: 85–100 dB up to 10 GHz
- The dispensing system supports prototyping and high volume production schedules in a space saving 4' x 3' [12 sq. ft.] (1,2 m x 0,9 m [1,1 sq. m]) footprint
- Form-in-place gaskets provide more critical packaging space for board level components and smaller package dimensions
- Excellent adhesion on a wide variety of metal and plastic substrates including:
 - aluminum and other casting alloys
 - stainless steel
 - nickel copper plating (on plastics)
 - copper, silver, and nickel filled paint (on plastics)
- Low compression force makes SN compounds an excellent selection where the mating surfaces lack mechanical stiffness

AUTOMATED FORM-IN-PLACE EMI GASKET TECHNOLOGIES



Laird form-in-place gasketing is ideal for hand held electronics applications.

PROGRAMMING SOFTWARE

Programming of the dispensing equipment can be facilitated utilizing part samples or part drawings. We also support the following CAD formats: AutoCAD®, DXF®, IGES®, Pro/ENGINEER®.

The software is user-friendly and includes several useful tools to simplify the path programming. These include scaling, symmetries, rotation, segment ends definition, and robotic dispensing instructions.

All production parameters are controlled by the software to include dispensing speed, start point, number of parts on the pallet, time needed to process one part, and automatic shut-down for cartridge reloading.

EXCEPTIONAL QUALITY

All material undergoes batch testing before application to guarantee superior mechanical and electrical properties. All dispensed products are manufactured to the exacting requirements of our ISO 9001 certified facility.

PACKAGING

To prevent damage to the substrate and gasket, and to facilitate handling, parts should be shipped in trays. Parts should be held securely to the tray to prevent movement during shipping, and packaged to avoid contact with each other. If required, Laird can design special packaging and trays to suit your specific part requirements. Store in the freezer prior to use.

AUTOMATED FORM-IN-PLACE EMI GASKET TECHNOLOGIES

TABLE 1.
TYPICAL BEAD DIMENSIONS

| HEIGHT INCH(MM) | WIDTH INCH(MM) | MINIMUM LANDING AREA |
|---------------------------|---------------------------|----------------------|
| 0.014 ± 0.003 (0,4 ± 0,1) | 0.015 ± 0.003 (0,4 ± 0,1) | 0.020 (0,5) |
| 0.015 ± 0.003 (0,4 ± 0,1) | 0.020 ± 0.003 (0,5 ± 0,1) | 0.025 (0,6) |
| 0.020 ± 0.003 (0,5 ± 0,1) | 0.024 ± 0.003 (0,6 ± 0,1) | 0.029 (0,7) |
| 0.027 ± 0.004 (0,7 ± 0,1) | 0.030 ± 0.004 (0,8 ± 0,1) | 0.036 (0,9) |
| 0.030 ± 0.004 (0,8 ± 0,1) | 0.034 ± 0.004 (0,9 ± 0,1) | 0.040 (1,0) |
| 0.040 ± 0.004 (1,0 ± 0,1) | 0.048 ± 0.005 (1,2 ± 0,1) | 0.055 (1,4) |
| 0.045 ± 0.005 (1,1 ± 0,1) | 0.059 ± 0.006 (1,5 ± 0,2) | 0.067 (1,7) |
| 0.055 ± 0.006 (1,4 ± 0,2) | 0.075 ± 0.007 (1,9 ± 0,2) | 0.084 (2,1) |

TABLE 2.
ACCELERATED CURE AT HIGHER TEMPERATURES

| CONDITIONS | 50%RELATIVE HUMIDITY, 0.024 IN. (0,6 MM) BEAD | | |
|-------------------------|--|----------|----------|
| Temperature °F (°C) | 73 (23) | 140 (60) | 185 (85) |
| Time for 98% Cure (Hr.) | 12 | 2 | 1 |

TABLE 3. MATERIAL SPECIFICATIONS

| | TEST METHOD | UNIT | SNC70-RXP | SNK55-RXP | SNL60-RXP | SNN60-RXP | SIL25-RXP | SNC70-HXP | SNK60-HXP | SNL70-HXP | SNN65-HXP | SIL35-HXP |
|------------------------------|----------------|---------|-------------------------------------|-------------------------------------|-------------------------------------|-------------------------------------|----------------|-----------------|---------------|------------------|---------------|----------------|
| Elastomer | | | Silicone | Silicone | Silicone | Silicone | Silicone | Silicone | Silicone | Silicone | Silicone | Silicone |
| Filler | | | Nickel/Graphite | Silver/Copper | Silver/Aluminium | Silver/Nickel | Non-conductive | Nickel/Graphite | Silver/Copper | Silver/Aluminium | Silver/Nickel | Non-Conductive |
| Color | | | Gray | Tan | Tan | Tan | White | Gray | Tan | Tan | Tan | Transparent |
| Electric Properties | | | | | | | | | | | | |
| Volume Resistivity | | ohm-cm | 0.03 | 0.002 | 0.003 | 0.005 | NA | 0.03 | 0.004 | 0.005 | 0.005 | NA |
| Shielding effectiveness | MIL-DTL-83528C | | | | | | | | | | | |
| 200MHz to 10GHz | Para. 4.5.12 | dB | >100 | >90 | >100 | >100 | NA | >90 | >90 | >90 | >100 | NA |
| Mechanical Properties | | | | | | | | | | | | |
| Hardness | ASTM D2240 | Shore A | 70 | 55 | 60 | 60 | 25 | 70 | 60 | 70 | 65 | 35 |
| Density (cured) | ASTM D792 | g/cm3 | 2.5 | 3 | 2.1 | 3.9 | 1.2 | 2.5 | 3.1 | 2 | 3.84 | 1.1 |
| Compression set | ASTM D395 | % | 15 | 10 | 10 | 15 | <20(a) | 15 | 10 | 10 | 10(b) | <20(b) |
| Adhesion strength (Al) | LT-FIP-CLE-03 | N/cm2 | 150 | 200 | 140 | 180 | 220 | >180 | 200 | 200 | 200 | 285 |
| Compression deflection | LT-FIP-CLE-07 | | | | | | | | | | | |
| at 20% compression | | lb/in | 1.5 | 1.2 | 1.9 | 1.7 | See note (b) | 3.2 | 1.5 | 2.3 | | See note (c) |
| at 40% compression | | lb/in | 6.9 | 5.2 | 8.3 | 6.4 | | 11.5 | 7.3 | 10.5 | | |
| Temperature Range | | °C | -50 to 125 | -50 to 100 | -50 to 125 | -50 to 125 | See note (b) | -50 to 150 | -50 to 125 | -50 to 125 | -50 to 125 | See note (c) |
| UL rating | UL-94 | | V0 | V0 | V0 | V0 | TBD | V0 | V0 | V0 | V0 | TBD |
| Curing requirements | | | | | | | | | | | | |
| Curing conditions | | | 15°C to 40°C, 50% relative humidity | 15°C to 40°C, 50% relative humidity | 15°C to 40°C, 50% relative humidity | 15°C to 40°C, 50% relative humidity | 23°C, 50% RH | 120°C | 120°C | 120°C | 120°C | 120°C |
| Handling time | | | 1 hour | 1 hour | 1 hour | 1 hour | 10-25 minutes | | | | | |
| Cure time | | | 24 hours | 24 hours | 24 hours | 24 hours | 12hrs/mm thick | 1 hour | 1.5 hours | 1 hours | 1.5 hours | 1 hour |

(a) Test method ASTM D575

(b) Contact Laird Application Engineering for test data.

METAL IMPREGNATED MATERIALS

ELECTROMET™ ORIENTED WIRE

ElectroMet oriented wire gaskets are EMI shielding and sealing composites. Monel® or aluminum wires embedded in the elastomer and oriented perpendicular to the mating surfaces provide the EMI sealing. Solid or sponge silicone provides the weather sealing; however, solid silicone weather seals are recommended for high-pressure applications. Silicone based oriented wire composites are capable of withstanding temperature ranges from -70°F to 500°F (-56°C to 260°C).

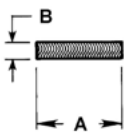
Oriented wire materials are available in sheet or strip form with a minimum thickness of 0.032 in. (0,8 mm). Material specifications and information for standard sheets and strips are provided in Tables 1 through 3.

TABLE 1.

| MATERIAL CODE | ELASTOMER | WIRE SPECIFICATION |
|---------------|--|---|
| 55 | Silicone Sponge Per AMS 3195 | Monel: Alloy Per QQ N281 Dia. 0.0045 (0,114) |
| 56 | Silicone Solid Per ZZR765 Class 2b Grade 40 | Monel: Alloy Per QQ N281 Dia. 0.0045 (0,114) |
| 58 | Silicone Sponge Per AMS 3195 | Aluminum: Alloy 5056 Per AMS 4182 Dia. 0.005 (0,127) |
| 59 | Silicone Solid Per ZZR765 Class 2b Grade 40 | Aluminum: Alloy 5056 Per AMS 4182 Dia. 0.005 (0,127) |

Note: Wire density per sq. in.: 700–900; per sq. cm 108–139

TABLE 2. ELECTROMET SHEET MATERIALS

| END VIEW | PART NUMBER | DIMENSIONS INCH(MM) | |
|---|--------------|---------------------|--------------|
| | | A. WIDTH | B. THICKNESS |
|  | 8408-0296-XX | 0.750 (19,1) | 0.125 (3,2) |
| | 8408-0200-XX | 3.000 (76,2) | 0.032 (0,8) |
| | 8408-0203-XX | 3.000 (76,2) | 0.045 (1,1) |
| | 8408-0206-XX | 3.000 (76,2) | 0.062 (1,6) |
| | 8408-0209-XX | 3.000 (76,2) | 0.093 (2,4) |
| | 8408-0212-XX | 3.000 (76,2) | 0.125 (3,2) |
| | 8408-0213-XX | 3.000 (76,2) | 0.187 (4,8) |
| | 8408-0215-XX | 4.500 (114,3) | 0.032 (0,8) |
| | 8408-0218-XX | 4.500 (114,3) | 0.045 (1,1) |
| | 8408-0221-XX | 4.500 (114,3) | 0.062 (1,6) |
| | 8408-0224-XX | 4.500 (114,3) | 0.093 (2,4) |
| | 8408-0227-XX | 4.500 (114,3) | 0.125 (3,2) |
| | 8408-0230-XX | 6.000 (152,4) | 0.032 (0,8) |
| | 8408-0233-XX | 6.000 (152,4) | 0.045 (1,1) |
| | 8408-0236-XX | 6.000 (152,4) | 0.062 (1,6) |
| | 8408-0239-XX | 6.000 (152,4) | 0.093 (2,4) |
| | 8408-0242-XX | 6.000 (152,4) | 0.125 (3,2) |
| | 8408-0245-XX | 9.000 (228,6) | 0.032 (0,8) |
| | 8408-0248-XX | 9.000 (228,6) | 0.045 (1,1) |
| | 8408-0251-XX | 9.000 (228,6) | 0.062 (1,6) |
| | 8408-0254-XX | 9.000 (228,6) | 0.093 (2,4) |
| | 8408-0257-XX | 9.000 (228,6) | 0.125 (3,2) |

HOW TO SPECIFY

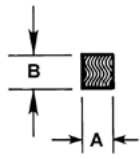
- For PSA, change the fifth digit to 9 for items with tape. Example: 8408-0200-59 becomes 8408-9200-59.
- Replace XX with material code from Table 1.
Example: To request a 3.0 in. (76,2 mm) wide x 0.032 in. (0,8 mm) thick strip with aluminum wire in solid silicone sponge, use 8408-0200-59.

For further information or for product samples, please contact Laird Technologies sales department.



Monel® wire is bonded into a silicone elastomer for uniform surface and multiple “spring” effect with each contact point.

TABLE 3. ELECTROMET STRIP MATERIALS

| END VIEW | PART NUMBER | DIMENSIONS INCH(MM) | |
|---|--------------|---------------------|--------------|
| | | A. WIDTH | B. THICKNESS |
|  | 8408-0100-XX | 0.125 (3,2) | 0.062 (1,6) |
| | 8408-0138-XX | 0.125 (3,2) | 0.062 (1,6) |
| | 8408-0102-XX | 0.125 (3,2) | 0.125 (3,2) |
| | 8408-0120-XX | 0.125 (3,2) | 0.125 (3,2) |
| | 8408-0130-XX | 0.125 (3,2) | 0.250 (6,4) |
| | 8408-0151-XX | 0.187 (4,8) | 0.020 (0,5) |
| | 8408-0105-XX | 0.187 (4,8) | 0.062 (1,6) |
| | 8408-0141-XX | 0.187 (4,8) | 0.125 (3,2) |
| | 8408-0127-XX | 0.187 (4,8) | 0.187 (4,8) |
| | 8408-0110-XX | 0.250 (6,4) | 0.062 (1,6) |
| | 8408-0290-XX | 0.250 (6,4) | 0.093 (2,4) |
| | 8408-0123-XX | 0.250 (6,4) | 0.125 (3,2) |
| | 8408-0133-XX | 0.250 (6,4) | 0.250 (6,4) |
| | 8408-0111-XX | 0.312 (7,9) | 0.062 (1,6) |
| | 8408-0124-XX | 0.312 (7,9) | 0.125 (3,2) |
| | 8408-0140-XX | 0.312 (7,9) | 0.250 (6,4) |
| | 8408-0137-XX | 0.375 (9,5) | 0.032 (0,8) |
| | 8408-0115-XX | 0.375 (9,5) | 0.062 (1,6) |
| | 8408-0139-XX | 0.394 (10,0) | 0.032 (0,8) |
| | 8408-0143-XX | 0.500 (12,7) | 0.032 (0,8) |
| | 8408-0116-XX | 0.500 (12,7) | 0.062 (1,6) |
| | 8408-0293-XX | 0.500 (12,7) | 0.093 (2,4) |
| | 8408-0126-XX | 0.500 (12,7) | 0.125 (3,2) |
| | 8408-0289-XX | 0.500 (12,7) | 0.187 (4,8) |
| | 8408-0118-XX | 0.625 (15,9) | 0.062 (1,6) |
| | 8408-0144-XX | 0.625 (15,9) | 0.062 (1,6) |
| | 8408-0134-XX | 0.625 (15,9) | 0.093 (2,4) |
| | 8408-0128-XX | 0.625 (15,9) | 0.125 (3,2) |
| | 8408-0117-XX | 0.750 (19,1) | 0.062 (1,6) |
| | 8408-0135-XX | 0.750 (19,1) | 0.250 (6,4) |
| | 8408-0147-XX | 1.000 (25,4) | 0.062 (1,6) |
| | 8408-0294-XX | 1.000 (25,4) | 0.093 (2,4) |
| | 8408-0148-XX | 1.000 (25,4) | 0.125 (3,2) |

COMPRESSION-DEFLECTION FOR SOLID SILICONE

| MATERIAL THICKNESS | COMPRESSION FORCE PSI (MPa) AT DEFLECTION OF: | | | |
|--------------------|---|-----------|-----------|-----------|
| | 5% | *10% | 15% | 20% |
| 0.045 (1,1) | 40 (0,3) | 100 (0,7) | 155 (1,1) | 280 (1,9) |
| 0.062 (1,6) | 85 (0,6) | 165 (1,1) | 240 (1,7) | 345 (2,4) |
| 0.125 (3,2) | 115 (0,8) | 180 (1,2) | 245 (1,7) | 290 (2,0) |

*Recommended

Note: Compression force for silicone sponge is approximately 15 psi to 75 psi. Silicone sponge density is 0.02 lb/in³.

SPECIALTY PRODUCTS

ELECTROCOAT™

ElectroCoat is a thin, flexible surface coating consisting of a silver-filled silicone elastomer. The versatile coating can be easily applied to die-cut or molded foams for both gasket and non-gasket applications. It can also be applied to molded or extruded elastomers, other polymers, and a wide range of other materials.

- Excellent shielding effectiveness — greater than 90 dB measured by transfer impedance
- Solid, continuous, conductive coating over the entire gasket surface, including the inner die-cut surfaces of foam gaskets
- Coated foam gaskets have very low compression force
- Exceptionally wide compression range from 10% to 70% deflection to accommodate uneven gaps in enclosure housings
- Flexible coating withstands gasket compression with no decrease in shielding effectiveness after 1000 cycles of 40% compression
- Extruded profiles shown on pages 18–22 are available with neoprene core.

ORDERING INFORMATION

1. Determine if PSA is needed. If so, replace the 5th digit in the part number with "9".
2. Select desired core material from Table 1 and insert in place of YY.
3. Select two digit ElectroCoat from Table 2 and insert in place of ZZ.
4. A unique custom identification number will be assigned by sales.

| 8550 | -X | XXX | -YY | -ZZ |
|------------------------|----------|--|----------------|--------------------------------|
| Standard Series Number | 9 w/ PSA | Unique identification number assigned by Laird | Core Material* | ElectroCoat (Coating Material) |

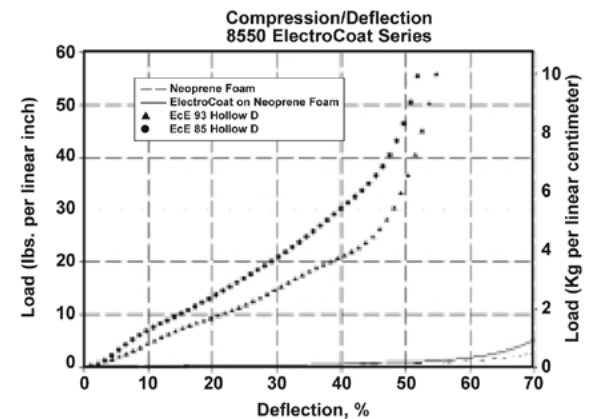
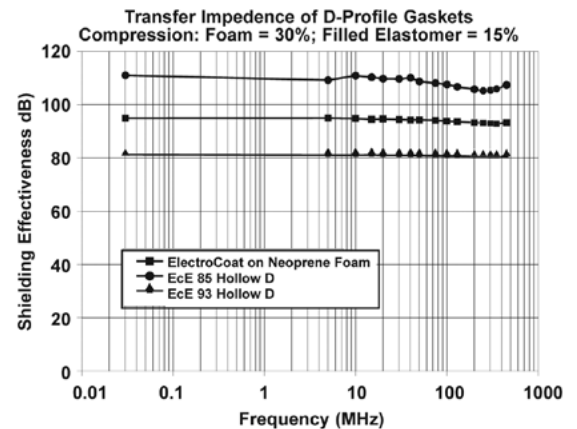
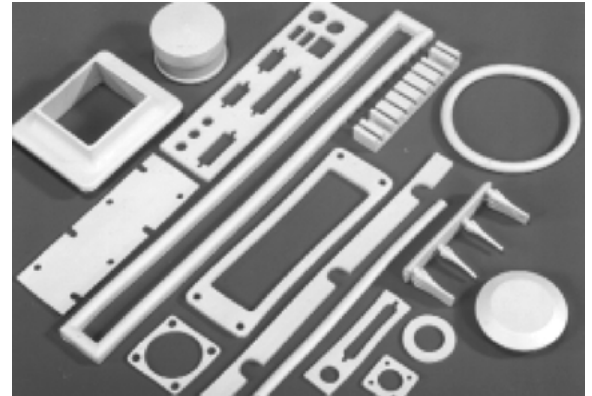
TABLE 1

| YY # | CORE MATERIAL* |
|------|----------------|
| 50 | Silicone Foam |
| 51 | Solid Silicone |
| 52 | Neoprene Foam |

TABLE 2

| ZZ COATING # | MATERIAL |
|--------------|-----------------|
| 10 | Silver/Silicone |

*Other core materials may be available.
Consult Laird sales department.



BOARD TO CHASSIS CONDUCTIVE STAND-OFF

Laird offers a multi-functional grounding device that provides electrical contact between the bottom of printed circuit boards and enclosure housings. The snap in feature allows for easy assembly and secure retention. Once inserted, the part makes contact with the base of the printed circuit board on a grounding pad or trace, assuring superior grounding.

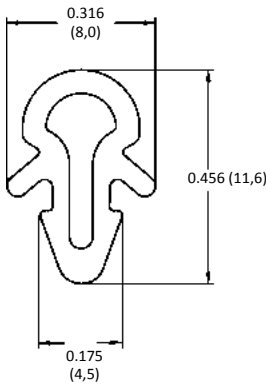
- Solves EMI and/or ESD problems via superior grounding (maximum 0.8 Ohm DC resistance)
- Provides damping of vibration and spacing between grounded surfaces
- Available in two standard lengths (custom lengths also available)
- Design of part facilitates simple robotic automation
- Minimum compression force required within operating range (see chart below)

ORDERING INFORMATION

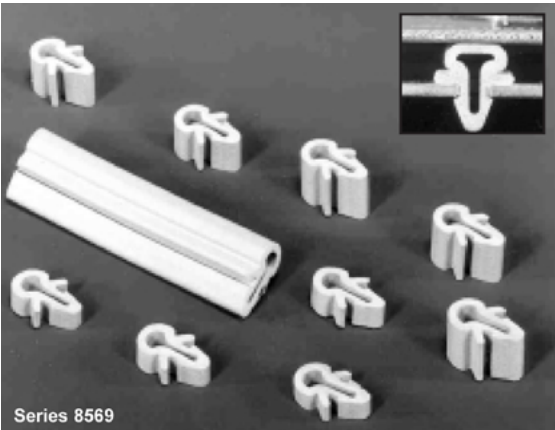
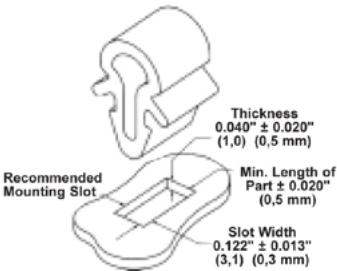
Select part from table below. Insert desired compound number in place of XX. Custom lengths are also available.

| PART NOUMBER | LENGTH |
|-----------------|-----------------|
| 8569-0127-XX | 0.250 (6,4) |
| 8569-0131-XX | 0.125 (3,2) |
| ECE COMPOUND 85 | ECE COMPOUND 22 |
| Silver/Glass | Nickel/Graphite |

PROFILE DIMENSION



MOUNTING INFORMATION



CORROSION OF EMI GASKETS

GALVANIC CORROSION

Corrosion can manifest itself in many forms. Some common forms are galvanic, pitting, and crevice corrosion. However, galvanic corrosion is the major concern in shielding applications. Galvanic corrosion is driven by the interaction of the gasket and the electronic enclosure, since in a shielded joint there are often two dissimilar materials in intimate contact.

BASIC GALVANIC CONDITIONS

There are three conditions that must exist for galvanic corrosion to occur:

1. Two electrochemically dissimilar materials present
2. An electrically conductive path between the two materials
3. An ionic conduction path (typically a corrosive environment) between the materials

If any of these three conditions is missing, galvanic corrosion will not occur. If we examine each of these conditions in detail, we will not only understand galvanic corrosion, but also know how to prevent it.

ELECTROCHEMICALLY DISSIMILAR METALS

Of the three conditions necessary for galvanic corrosion, the most important is the electrochemical difference between metals. Commonly available materials have different electrochemical potentials; even pure metal at the microscopic level. This is why a block of steel sitting by itself corrodes. The order in which metals will corrode is always from the most anodic (active) to the most cathodic (noble). This means that when two dissimilar metals are put together, only the more anodic metal will corrode.

This method is used extensively in preventing corrosion by plating a more anodic metal over a more cathodic metal. The more anodic metal will then sacrifice itself (corrode first) and protect the metal underneath from corrosion. This is the reason for the good corrosion resistance of zinc plated steel. Even when scratched, the zinc coating that surrounds the scratch protects the exposed steel from corroding until the zinc near the scratch is consumed.

ELECTRICAL CONDUCTION

The second condition required for galvanic corrosion, electrical conduction, is the hardest to prevent. Metals are all good conductors of electricity, and most joints between metals are made with metal fasteners. The amount of electrical current that flows is dependent on the rate of corrosion, but in most cases is very small.

Dramatically reducing the conductivity of an electrical path between two metals has little effect on the corrosion rates except where very strong electrolytes are involved.

Generally, effective RF joints depend on having very high conductivity; therefore, reducing conductivity to decrease corrosion may greatly reduce shielding effectiveness. Some new research has produced materials that are good RF conductors, but poor D.C. conductors. These materials may be able to reduce corrosion and still maintain high shielding levels. Laird is in the forefront of this research.

AN ION CONDUCTION PATH

The ionic conduction medium that is most responsible for corrosion is water. There are other ionic conductors such as moist air, but the majority of corrosion problems will be caused by water or water-based solutions. The basic principle is that the metals are slightly soluble in water. You can sometimes taste a metallic taste in water, especially if the water is a little acidic. In a good ionic conductor like salt water, or water with a high acid content, the ions are relatively stable, and more metal will dissolve into the water. A good ionic conductor like salt water will also allow dissolved ions to move freely in the solution. The dissolved ions tend to migrate through the water toward the electrode of opposite polarity. The positively charged ions will migrate towards the cathode while the negatively charged ions will migrate towards the anode.

The only way to totally prevent dissolved ions from migrating is to interrupt their path, such as with a vacuum or by maintaining them at very low temperatures. The speed at which they migrate can also be reduced by many orders of magnitude by using poor ionic conductors as barriers. Placing metals in dry air, or coating the metals with a poor ionic conductor such as paint, greatly reduces corrosion rates. Some metals form their own barriers that prevent or restrict ion migration. For example, under normal atmospheric conditions aluminum corrodes in air, producing a thin coating of aluminum oxide. The aluminum oxide is an extremely poor ionic conductor and chokes off the flow of oxygen to the aluminum metal beneath the oxide coating. This demonstrates how by-products of corrosion can dramatically reduce corrosion rates.

As in the above example of zinc coating on steel, the anodic material does not need to completely cover the more cathodic material to offer protection. It only needs to be close by. The effective distance between the anodic metal and the cathodic metal depends on the environment. This distance is generally dependent on the conductivity of the electrolyte. In the case of typical electronic equipment this distance is usually the size of the microdroplets of water formed by condensation. In severe environments, this distance can be 0.250 in. (6,4 mm) or more.

CORROSION OF EMI GASKETS

GALVANIC CORROSION OF ELECTRICALLY CONDUCTIVE ELASTOMERS

The galvanic series provides a relative ranking for selecting compatible metallic couples. However, electrically conductive elastomers are a composite material that behaves differently from metals due to diffusion rates and elastomeric nature of the gaskets. In addition, the presence of corrosion inhibitors which continuously coat the exposed flanges also affects the corrosion rate. Therefore, the direct application of the metallic-based galvanic series to the conductive elastomers could be misleading. The corrosion behavior of the conductive elastomers is affected by the nature of the filler particles, the permeability of the elastomer matrix, and the presence of corrosion inhibitors.

Electrically conductive elastomers are effective shielding materials because they provide good attenuation to electromagnetic radiation, while at the same time providing an environmental seal. When conductive elastomers are assembled in an enclosure, they are in intimate contact with some type of metal flange and readily conduct current. These two conditions, intimate contact with a metallic substrate and electrical conductivity, create a galvanic couple. Significant corrosion of one of the components of this couple can occur under suitable conditions of: 1) conductive environment (i.e., salt water, acid, etc.) and 2) corrosion potential difference between the elastomer-metal couple (the difference between the Electromotive Force (EMF) values of the two materials). If the elastomer corrodes, an insulating corrosion product is formed that reduces the conductivity of the elastomer.

On the other hand, if the metal substrate corrodes, the metal loss could threaten the integrity of the flange and the corrosion products could adversely effect the performance of the elastomer. When designing the enclosure it is important to avoid conditions that can lead to significant corrosion. The following data are intended to be a guide to help in choosing the appropriate type of couple(s) so as to avoid or minimize these conditions.

Corrosion Test – To evaluate the impact of corrosion on the elastomer/metal galvanic couples test samples were exposed to 500 hours of salt spray in accordance with missile specification MIS-47057. The test fixtures were assembled as per Figure 1. The dimensions of the electrically conductive elastomer washers are shown in Figure 2 and the metal coupons are shown in Figure 3.

The volume resistivity of the elastomers and the weight of the metal coupons were measured before, and then again after the salt spray test. From this data, the change in volume resistivity for the elastomer and the weight loss for the metal coupons were calculated. With these two pieces of data it is possible to assess the compatibility of the various elastomer/metal couples. This information can then be used as a design guidance tool to determine which combinations of conductive elastomer gasket and metal flange are appropriate for a particular application. The following corrosion data indicate the performance of the galvanic couples in a very corrosive environment and thus represent a worst-case scenario.

Weight Loss of Metal Coupons (Part 1 of Galvanic Couple) — Five different metallic materials were evaluated. The five metallic materials included chromated aluminum, Galvalume® (a 55% Al-45% Zn hot-dip coated steel), tin plated steel, zinc plated steel and stainless steel (Table 1). These materials represent some of the common types of sheet metal used to manufacture enclosures.

FIGURE 1. TEST ASSEMBLY PER MIS-47057

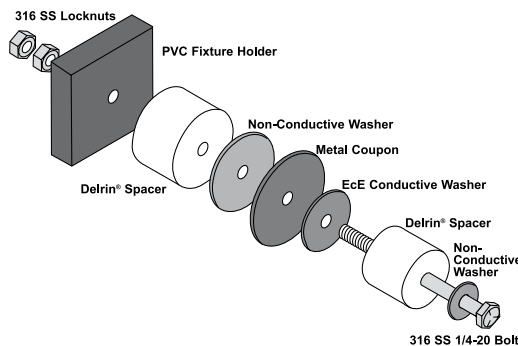


FIGURE 2. CONDUCTIVE WASHER

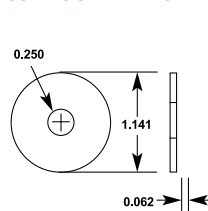
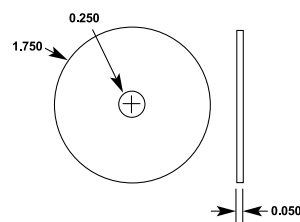


FIGURE 3. METAL COUPON



CORROSION OF EMI GASKETS

TABLE 1. METAL COUPONS TESTED

| METAL COUPON | BASE METAL | COATING |
|-------------------|------------|---------------------------------|
| Aluminum | 6061-T6 | Chromate |
| Galvalume® | 1006 | 55% Al-45% Zn hot-dip coated |
| Tin Plated Steel | 1010 | Electroplated Tin |
| Zinc Plated Steel | 1010 | Electroplated Zinc |
| Stainless Steel | 304 | None |

The percent weight loss was calculated for all of the metal coupons according to equation 1.

EQUATION 1

$$\% \text{ Weight Loss} = \frac{\text{Weight}_{\text{Before}} - \text{Weight}_{\text{After}}}{\text{Weight}_{\text{Before}}} \times 100\% \quad (1)$$

In equation 1, Weight Before is the weight of the metal coupon before the test and Weight After is the weight after the test once the corrosion products were removed. In Table 3 (page 55), a corrosion performance rating was developed from this data for the metal coupon part of the galvanic couple only. This table does not provide any information on how the elastomer part of the galvanic couple will hold-up.

The corrosion performance ratings, color coded for ease of recognition with a legend, are provided below the table. The divisions for the corrosion performance ratings were established by visual assessment to differentiate significant differences of metal loss on the coupons. The elastomer compound numbers are listed in columns across the top of the table, including the elastomer and filler material. The metal coupons are listed in rows along the side of the table. The intersection of a row and a column gives the weight loss rating for the metal coupon when used with that particular elastomer. For the galvanic couples in which the metal coupon experiences little weight loss (yellow rating), the metal coupon is probably the cathode (electrode where reduction occurs) and/or the couple has a small potential difference. In this case the metal substrate would not experience much corrosion, even in very corrosive environments.

At the other extreme, the galvanic couples in which the metal coupon experiences a large weight loss (dark green rating), the metal coupon would be the anode (electrode where oxidation occurs). In this case the metal substrate would experience extensive corrosion in the very corrosive environments. A large metal coupon weight loss (dark green rating) does not preclude the use of this galvanic couple, but in the design

it would be critical to look at the relative anode (metal) to cathode (elastomer) areas, the thickness of the flange and the corrosiveness of the environment. It is not recommended that the galvanic couples with an extreme metal coupon weight loss rating (gray) be used under any conditions.

Volume Resistivity of Conductive Elastomers

(Part 2 of Galvanic Couple) – Conductive elastomers are essentially a composite material made up of an elastomer matrix and small filler particles, usually metallic. Even the filler particles can have a composite nature since many are coated. This composite structure can result in a corrosion behavior that may not follow the well known galvanic series. The elastomer compounds that were evaluated are listed in Table 2.

TABLE 2. ELASTOMERS TESTED

| ELASTOMER | FILLER |
|----------------|--------------------|
| Silicone | Inert Al |
| Silicone | Ag Plated Cu |
| Silicone | Ag Plated Al |
| Silicone | Ag Plated Ni |
| Silicone | Ag Plated Glass |
| Fluorosilicone | Ag Plated Al |
| Fluorosilicone | Ni Plated Graphite |
| Silicone | Ni Plated Graphite |
| EPDM | Ag Plated Al |

When exposed to a corrosive environment one of the most important characteristics of a conductive elastomer is its ability to maintain its initial shielding effectiveness. As corrosion products form in the elastomer it usually results in a loss of shielding effectiveness. Generally, as shielding effectiveness decreases there is a tendency for the conductivity of the elastomer to decrease (or resistance to increase). To assess the effect of very corrosive environments on the elastomer part of the galvanic couples, the volume resistivities of the elastomers were measured before and after the corrosion test. In Graphs 1–5 on page 54, a side-by-side comparison is presented for each elastomer of its volume resistivity before and after exposure to the corrosive environment. The change in volume resistivity is the difference between these bars (before and after). It is important to note that the Y-axis is a log scale. Each chart corresponds to a different metallic substrate. The change was usually positive which means a loss in conductivity. These charts do not provide any information on how the metal coupon part of the galvanic couple will hold up.

For some of the elastomers, the increase in the volume resistivity is large. In these cases, the conductive elastomer was probably the anode. This condition results in a significant amount of corrosion of the elastomer filler particles, which makes it much less conductive.

CORROSION OF EMI GASKETS

At the other extreme there were a number of elastomers in which there was only a very small percent increase in volume resistivity. In these cases, the conductive elastomer was probably the cathode or the galvanic couple had a very small corrosion potential difference. Under these conditions there was very little loss of conductivity after exposure to a corrosive environment.

Design Considerations – When choosing a conductive elastomer for a particular design, especially in a potentially corrosive environment, it is important to look at shielding requirements and the type of galvanic couple that will be created. In deciding which couple best serves the design requirements two factors will have to be considered:

1. The impact of the galvanic couple on the enclosure material (Table 3).
2. The impact of the galvanic couple on the volume resistivity of the elastomer, Graphs 1–5 on page 54.

The impact of the galvanic couple on the corrosion of the enclosure material can be gauged by the metal coupon weight loss rating on Table 3 (page 55). As the color changes, the flange area on the enclosure will experience increasing amounts of corrosion.

Metal substrate factors to consider when choosing a elastomer/metal couple:

- Allowable enclosure material(s)
- Effect of weight loss/corrosion on the function of the enclosure
- Area of exposed enclosure material close to elastomer

The impact of corrosion on the shielding effectiveness of the elastomer can be gauged by the change in volume resistivity, see Graphs 1–5 on page 47. The greater the increase in volume resistivity after exposure to a corrosive environment the greater should be the drop-off in shielding effectiveness.

Elastomer factors to consider when choosing an elastomer/metal couple:

- Shielding requirements
- Change in volume resistivity of elastomer in corrosive environments
- Environmental sealing requirements
- Required compression properties

How to Use the Charts – When deciding on a conductive elastomer, it is important to examine the potential impact of galvanic corrosion. From a corrosion standpoint, the best design is an elastomer/metal flange galvanic couple that will result in the lowest corrosion rate. The charts (Table 3 and Graphs 1–5) in this section are intended to be used as a guide for choosing the least corrosive galvanic couple (other design considerations should also be taken into account when using these charts, such as restrictions on enclosure materials and environmental sealing requirements). To arrive at the best choice(s) for a particular application the impact of corrosion on both halves of the galvanic couple must be examined. One half is the weight loss on the metal substrate and the other half is the change in volume resistivity for the elastomer. The combined effect will dictate the corrosion performance of the galvanic couple/ finished component.

In Table 3, pick out the appropriate row(s) based on the choice of the enclosure material(s) and then note the elastomer compound(s) that has the lowest metal coupon weight loss. Then go to the appropriate Graphs 1–5, based on the metal substrate(s) of choice, and find the change in volume resistivity for the elastomer compound(s) that you have just identified from Table 3.

The elastomers that have the lowest change in volume resistivity will represent the elastomer/metal substrate combination(s) that will create the least corrosive couple. If a combination of metal substrate with a very low weight loss and elastomer with a very small change in volume resistivity is not identified, then a compromise will have to be made. In that case go through the same process but, now look at metal substrates with slightly higher weight losses and/or elastomers with slightly larger changes in volume resistivity. After a candidate is selected it is always best to test the elastomer(s) in the specific application.

EXAMPLE

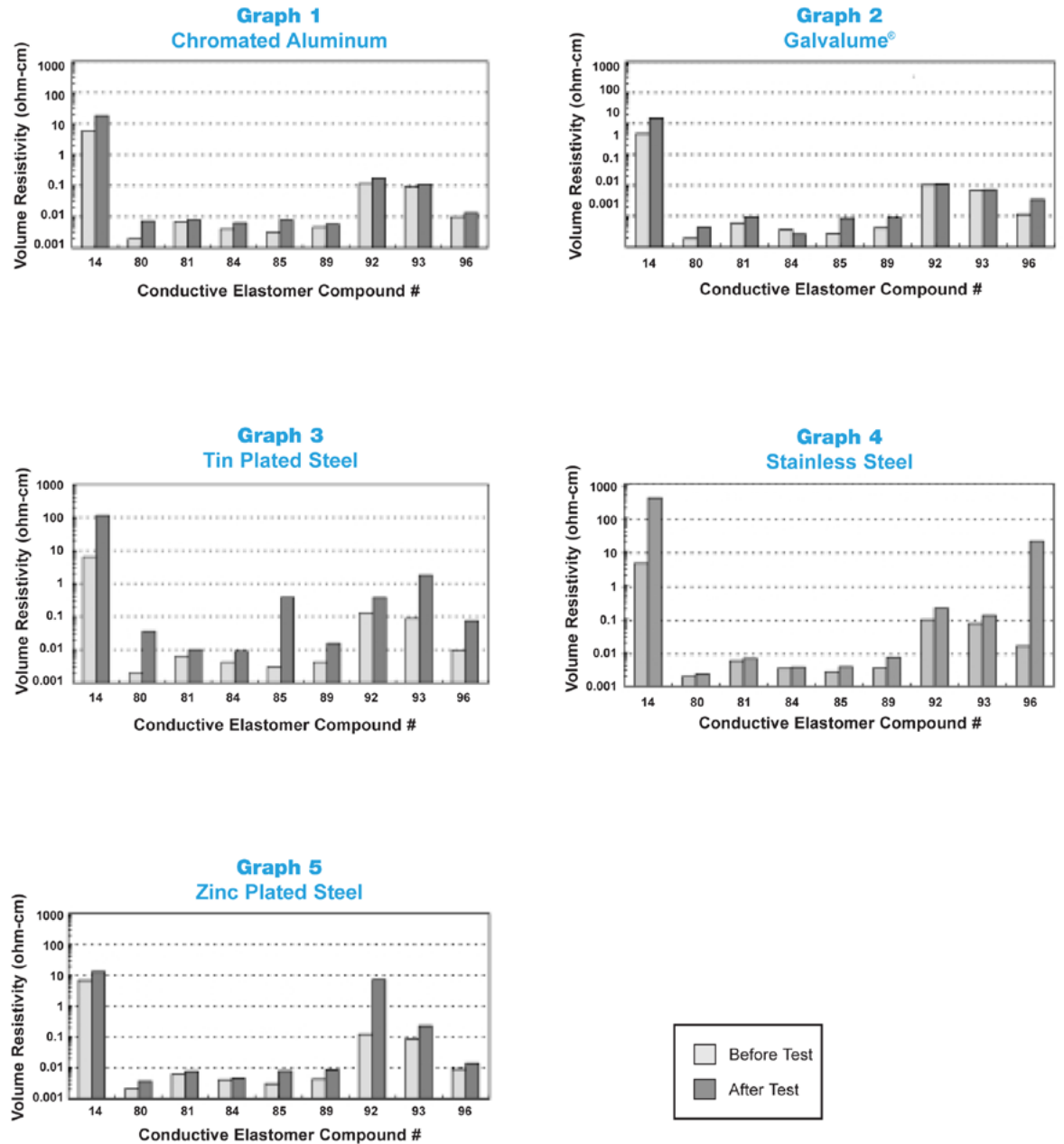
Assume the enclosure is aluminum.

1. From the aluminum row in Table 3, elastomer compounds #89 and 96 will cause the lowest weight loss on the aluminum metal substrate.
2. From Graph 1 (Chromated Aluminum) compound #89 has the lowest change in volume resistivity and 96 is a close second
3. As long as the elastomer matrix and initial attenuations are acceptable, choose either compound #89 or 96.

CORROSION OF EMI GASKETS

ELASTOMER VOLUME RESISTIVITY

(Salt spray is considered a very corrosive environment and represents a worst-case scenario)



EcE 14, EcE 80, EcE81 and EcE85 are legacy compounds.

ELASTOMER GALVANIC COMPATIBILITY CHART

TABLE 3. METAL COUPON WEIGHT LOSS RATING*
COMPOUND NUMBER: ELASTOMER AND FILLER MATERIAL

| METAL SUBSTRATE | 80 SIL AG/CU | 81 SIL AG/AL | 84 SIL AG/NI | 85 SIL AG/ GLASS | 89 FSIL AG/AL | 92 FSIL NI/ GRAPHITE | 93 SIL NI/ GRAPHITE | 96 EPDM AG/AL |
|-------------------|-----------------|-----------------|-----------------|------------------------|------------------|----------------------------|---------------------------|------------------|
| Chromated Al | • | • | • | • | • | • | • | • |
| Galvalume® | • | • | • | • | • | • | • | • |
| Tin Plated Steel | • | • | • | • | • | • | • | • |
| Zinc Plated Steel | • | • | • | • | • | • | • | • |
| Stainless Steel | • | • | • | • | • | • | • | • |

*This chart to be used in conjunction with Graphs 1–5 on page 40.
EcE 14, EcE 80, EcE81 and EcE85 are legacy compounds.



Little to no weight loss on metal coupon; less than 0.25%. Acceptable in all environments.



Substantial amount of weight loss on metal coupon; between 0.50% and 1.25%. Not acceptable in corrosive environments; for less corrosive applications consult with Laird applications engineer.



Moderate amount of weight loss on metal coupon; between 0.25% and 0.50%. May not be acceptable in very corrosive environments.



Extreme amount of weight loss on metal coupon; greater than 1.25%. Not recommended in any environments.

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