



Product Overview

Kemtron Form-in-Place (FIP) Elastomer compounds are directly dispensed onto component hardware or enclosure via a pressurised fluid dispensing system on a numerically controlled XYZ table to form a gasket for RFI/EMI shielding and/or environmental seal for dust and moisture. The dispensing machine deposits the gasket by following a pre-determined CNC path to provide accuracy and repeatability.

The process advantages are

- Component is integrated with EMI shielding and/ or environmental gasket.
- Materials are one-component room curable.
- Assembly time is reduced as gasket is included on component.
- Rapid prototyping.
- Low setup costs.
- Smaller gasket land required.
- Variety of materials available to optimise shielding and galvanic compatibility.
- No material waste.
- Excellent EMI shielding.
- Can be applied to metal and plastic components.

Product Overview (Continued)

Applications

Suited to applications where small, intricate gasket profiles are required, such as on multi-compartment labyrinth housings with minimum gasket land area where traditional larger types of gasket are not suitable. This process also negates the assembly costs associated with traditional gaskets as the Form-in-Place gasket becomes an integral part of the housing or enclosure. The process is suitable for depositing on both metal and metallised plastic components/housing.

Availability

Kemtron can dispense FIP gaskets directly onto the customer's free issue hardware or can procure the component hardware thereby reducing the customer's supply base. Kemtron can also supply FIP compounds in syringes or Semco cartridges for the customer's own use.

Form- in-Place gasket materials include:

For RFI/EMI Shielding

- Silver plated copper filled silicone.
- Silver plated aluminium filled silicone.
- Silver plated nickel filled silicone.
- Nickel coated graphite filled silicone.

For Environmental Sealing only

- Unfilled silicone.

Design Considerations

- To achieve optimum EMI shielding performance the component surface on which the gasket is to be deposited must be highly conductive as low contact resistance is required between the two. Chromate finishes on aluminium must be conductive.
- The gasket height can be specified between 0.4mm to 2.0mm, gasket width will typically be 1.5x the gasket height. General tolerance is +/-0.1mm.
- Recommended gasket compression is between 20% and 30%. Over-compression can damage the gasket and as compression stops cannot be incorporated into the gasket they should be designed into the component hardware.
- Gasket path for the deposition can be determined from a sample part, drawings or CAD files.

Production Capability

To meet the varying demands of customer requirements Kemtron has developed its own CNC Form-in-Place dispenser. FIP gasketing work has become a regular feature of our production work and we are able to provide a reliable, accurate and quick response to even high volume orders.



Notice

Information supplied in these data sheets is based on independent and laboratory tests which Kemtron believes to be reliable. Kemtron has no control over the design of customer's product which incorporates Kemtron's products, therefore it is the responsibility of the user to determine the suitability for his particular application and we recommend that the user make his own test to determine suitability.

The product described in this data sheet shall be of standard quality, however the products are sold without warranty of fitness for a particular purpose, either expressed or implied, except to the extent expressly stated on Kemtron's invoice, quotation or order acknowledgement. Kemtron does not warrant that products described in this data sheet will be free of conflict with existing or future patents of third parties. All risks of lack of fitness, patent infringement and the like are assumed by the user.

Technical Specification

Materials

Silver plated Copper Particles in Silicone Elastomer

FIPSSC

Density	3.3 g/cm ³
Hardness	40 Shore A
Volume resistivity	<0.01Ω.cm
Adhesion	>50 N/cm ²
Attenuation – 100MHz to 10GHz (MIL-STD 285)	100-120dB (typically)
Compression recommended – (allowable range)	25% (10 – 50%)
Gasket resistance	<0.5Ω.cm ⁻¹
Elongation	100%
Compression set – 70 hours at 23°C	<20%
Service temperature range	-55°C to 125°C
Force/deflection – 0.7mm high gasket section	1.4 N/cm ⁻¹ @ 10%
	3.3 N/cm ⁻¹ @ 25%
	14.8 N/cm ⁻¹ @ 50%

Silver plated Aluminium Particles in Silicone Elastomer

FIPSSA

Density	2.0 g/cm ³
Hardness	50 Shore A
Volume resistivity	<0.01Ω.cm
Adhesion	>50 N/cm ²
Attenuation 100MHz to 10GHz (MIL-STD 285)	85-110dB (typically)
Compression recommended (allowable range)	25% (10 – 50%)
Gasket resistance	<0.5Ω.cm ⁻¹
Elongation	100%
Compression set – 70 hours at 23°C	<20%
Service temperature range	-55°C to 125°C
Force/deflection – 0.7mm high gasket section	1.5 N/cm ⁻¹ @ 10%
	3.5 N/cm ⁻¹ @ 25%
	16 N/cm ⁻¹ @ 50%

Nickel plated Graphite Particles in Silicone Elastomer

FIPSSNG

Density	2.5 g/cm ³
Hardness	50 Shore
Volume resistivity	<0.01Ω.cm
Adhesion	>50 N/cm ²
Attenuation – 100MHz to 10GHz (MIL-STD 285)	85-110dB (typically)
Compression recommended (allowable range)	25% (10 – 50%)
Gasket resistance	<0.5Ω.cm ⁻¹
Elongation	100%
Compression set – 70 hours at 23°C	<20%
Service temperature range	-55°C to 150°C
Force/deflection – 0.7mm high gasket section	2.8 N/cm ⁻¹ @ 10%
	7.4 N/cm ⁻¹ @ 25%
	26.4 N/cm ⁻¹ @ 50%

Silver plated Nickel Particles in Silicone Elastomer

FIPSSN

Density	3.6 g/cm ³
Hardness	45 Shore A
Volume resistivity	<0.01Ω.cm
Adhesion	>50 N/cm ²
Attenuation 100MHz to 10GHz (MIL-STD 285)	90-110dB (typically)
Compression recommended (allowable range)	25% (10 – 50%)
Gasket resistance	<0.5Ω.cm ⁻¹
Elongation	100%
Compression set – 70 hours at 23°C	<20%
Service temperature range	-55°C to 150°C
Force/deflection 0.7mm high gasket section	1.7 N/cm ⁻¹ @ 10%
	4.1 N/cm ⁻¹ @ 25%
	20.7 N/cm ⁻¹ @ 50%

Typical Form-in-Place Deposits

