

# CHOFORM® Form-in-Place Gasketing Material

MATERIAL PROPERTIES				
	TEST METHOD	CHOFORM 5513	CHOFORM 5519	CHOFORM 5528
Filler		Ag/Cu	Ag/Cu	Ag/Cu
Resin System		Silicone	Silicone*	Silicone
Number of Components		2	1	1
Cure System		Thermal	Moisture	Moisture
Cure Cycle		140° C/ 30 minutes	See table below.	See table below.
Volume Resistivity (ohm-cm) initial disc measurement aged, flanged condition 48 hrs. @ 85° C	Chomerics MAT-1002	0.003	0.006	0.009
Hardness (Shore A)	Chomerics MAT-1002 ASTM D 2240	53	31	26
Tensile Strength (psi / kPa)	ASTM D 412	322 / 2,220	90 / 621	85 / 586
Specific Gravity	ASTM D 792	3.43	3.05	3.02
Compression Set (%)	ASTM D 395 Method B, 22 hrs. 85° C	28	35	30
Shelf Life /Storage Conditions	Chomerics MAT - 1200	6 months/below -10°C	6 months/ambient	6 months/ambient
Flow Rate (grams/minute)*	UL 94	1.55 - 1.70	13	8.0 - 10.0
Viscosity (Centipoise)	CHO-TP08 (200 MHz - 10 GHz)	1.5 x 10 <sup>6</sup>	1.6 x 10 <sup>5</sup>	2.3 x 10 <sup>5</sup>
Flammability Rating**	CHOFORM WI038	V-0	--	--
Use Temperature (degrees °C) (max.)	Chomerics TM-100	85	85	85
Shielding Effectiveness (dB)		> 80	> 80	> 70
Adhesion (typical max.) (Newtons/cm)		> 12	> 4	> 4
Corrosion Resistance (milligrams weight loss Al coupons)		N/A	N/A	N/A

\* Flow rate: Standard 15 gauge x 1/2 inch (12mm) long disposable stainless steel needle, air pressure of 6.2 bar (90 psi), at 25° C (77° F)

\*\* UL 94 V-0 possible on all materials on metal substrates

## MOISTURE CURE CYCLES

### Tack Free Time

Approx. 18 minutes @ 22° C & 50% RH

Approx. 8 minutes 35° C & 50% RH

### Handling Time

4 hrs. @ 22° C & 50% RH

2 hrs. @ 35° C & 50% RH

2 hrs. @ 22° C & 95% RH

## TYPICAL BEAD SIZES\*\*\*

Smallest cross-section

Largest single bead cross-section

\*\*\* practical bead size is related to material dispense rate

CHOFORM 5513	CHOFORM 5519	CHOFORM 5528
0.018 x 0.022 inches	0.018 x 0.022 inches	0.018 x 0.022 inches
0.46 x 0.56 mm	0.46 x 0.56 mm	0.46 x 0.56 mm
0.062 x 0.073 inches	0.042 x 0.049 inches	0.042 x 0.049 inches
1.57 x 1.85 mm	1.07 x 1.24 mm	1.07 x 1.24 mm

# CHOFORM<sup>®</sup> Form-in-Place Gasketing Material

## MATERIAL PROPERTIES

	TEST METHOD	CHOFORM 5526	CHOFORM 5541	CHOFORM 5538
Filler		Ag	Ni/C	Ni/C
Resin System		Silicone	Silicone	Silicone
Number of Components		1	1	1
Cure System		Moisture	Thermal	Moisture
Cure Cycle		See table below.	150° C/ 30 minutes	4 hours at 50% RH, 20° C
Volume Resistivity (ohm-cm) initial disc measurement	Chomerics MAT-1002	0.004	0.02	0.15
aged, flanged condition 48 hrs. @85°C	Chomerics MAT-1002	0.005	0.03	0.25
Hardness (Shore A)	ASTM D 2240	37	79	65
Tensile Strength (psi / kPa)	ASTM D 412	90 / 621	450 / 3,103	325 / 2,241
Specific Gravity	ASTM D 792	3.51	2.4	2.2
Compression Set (%)	ASTM D 395	32	40	50
Shelf Life /Storage Conditions	Method B, 22 hrs. 85°C	6 months/ambient	6 months/below -10°C	3 months min. at 25°C
Flow Rate (grams/minute)*	Chomerics MAT - 1200	1.70 - 2.30	0.85 - 1.25	4.0
Viscosity (Centipoise)		1.2 x 10 <sup>6</sup>	1.7 x 10 <sup>6</sup>	1.5 x 10 <sup>6</sup>
Flammability Rating**	UL 94	--	V-0	V-0
Use Temperature (degrees°C) (max.)		85	125	85
Shielding Effectiveness (dB)	CHO-TP08 (200 MHz - 10 GHz)	> 100	> 70	> 60
Adhesion (typical max.) (Newtons/cm)	CHOFORM WI038	> 4	> 12	> 4
Corrosion Resistance (milligrams weight loss Al coupons)	Chomerics TM-100	N/A	12	10

\* Flow rate: Standard 15 gauge x 1/2 inch long disposable stainless steel needle, air pressure of 6.2 bar (90 psi), at 25°C (77°F)

\*\* UL 94 V-0 possible on all materials on metal substrates

## MOISTURE CURE CYCLES

### Tack Free Time

Approx. 18 minutes @ 22°C & 50% RH

Approx. 8 minutes 35°C & 50% RH

### Handling Time

4 hrs. @ 22°C & 50% RH

2 hrs. @ 35°C & 50% RH

2 hrs. @ 22°C & 95% RH

## TYPICAL BEAD SIZES\*\*\*

Smallest cross-section

Largest single bead cross-section

\*\*\* practical bead size is related to material dispense rate

CHOFORM 5526	CHOFORM 5541	CHOFORM 5538
0.018 x 0.022 inches	0.026 x .032 inches	0.020 x 0.025 inches
0.46 x 0.56 mm	0.66 x 0.81 mm	0.51 x 0.64 mm
0.042 x 0.049 inches	0.062 x .082 inches	0.038 x 0.045 inches
1.07 x 1.24 mm	1.57 x 2.08 mm	1.02 x 1.27 mm

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