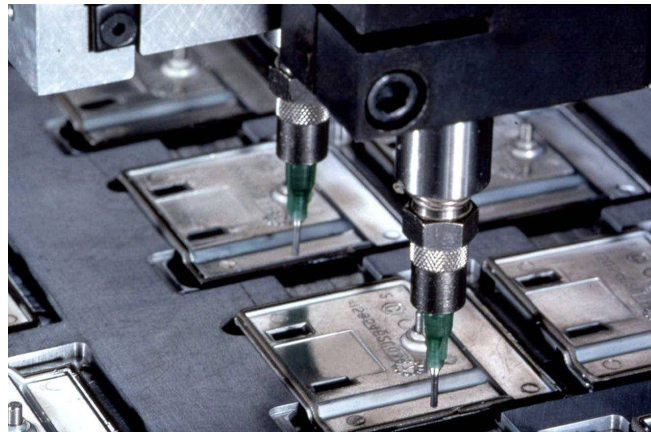


ParPHorm 1800

Form-in-Place Sealing Material

DESCRIPTION

ParPHorm 1800 is a non-conductive, moisture cure, form-in-place (FIP), silicon elastomer sealing material. The material provides environmental, fluid, and dust sealing of small enclosures via a compound designed to be robotically dispensed onto small housings. Curing of the dispensed material is via moisture cure for 48 hours. Minimum bead heights range from 0.018" (0.46 mm) to 0.022" (0.78 mm). Maximum bead size is .077" wide x .090" in height (2.73 mm x 3.19 mm). Application advantages of the material are excellent adhesion, low hardness, and excellent compression set properties. Applications for ParPHorm 1800 material include handheld electronic module housings, battery cases, industrial gauges, fuel cells, and other enclosures requiring small dispensed elastomer seals for environmental or fluid sealing. Chomerics offers worldwide capabilities for dispensing of this material onto customer supplied housings. Chomerics can also provide supply chain management of the process and source the housings along with ParPHorm dispensing and finishing operations such as painting and minor mechanical assembly.



HANDLING AND CURING OF MATERIAL

ParPHorm 1800 is a one component, moisture cure material. Recommended cure condition is 35° C , 50% RH for 48 hours. For these same temperature and humidity conditions the tack free time is approximately 8 minutes and handling time is 3 hours.

FEATURES

- One component moisture cure material
- Excellent adhesion to a wide variety of substrates
- Small cross-section dispensed beads
- Low material and installation costs

DESIGN AND PROTOTYPING

Application and design assistance is available to prospective customers. The specific focus of the assistance is on the examination/identification of design issues with regard to the substrate. These design issues include: enclosure material and surface finish, available gasket placement area, part flatness, transitions in the layout of the dispensed bead, obstructions in the design of the enclosure to the unimpeded travel of the dispense needle, and z direction dispense needs. Prototype dispensing is available on sample parts or sample coupons for customer evaluation.

January 2005

MATERIAL DISPENSING

ParPHorm 1800 is easily dispensed from a variety of commercially available gasket dispense systems. In addition to Chomerics' existing worldwide network of Cho-Form applicators, our Cho-Form applications group can provide support for material dispense needs worldwide for customers wishing to utilize their own or other dispense equipment.

Physical Properties	Test Methods	Typical Values
Hardness, Shore A	ASTM D2240	15 – 25
Tensile Strength, (min.) (psi)	ASTM DD412	150
Elongation, %	ASTM D412	500 – 800
Specific Gravity	ASTM D297	1.3 – 1.5
Compression Set, % (70 hrs., 25% deflection @ 100 °C)	ASTM D395 Method B	35
Other Data:		
Cure Process		Moisture
Cure Time & Conditions	Full Cure	48 hours @ 35°C 50% RH
--	Tack Free Time	8 minutes
--	Handling Time	3 hours
Color	--	Dark Gray
Binder	--	Silicone

PACKAGING AND PART NUMBERS

ParPHorm 1800 can be packaged in 30 cc syringes, as well as 6 and 12 fluid ounce plastic cartridges. Customer sampling of wet material is typically provided in either 30 cc syringes or 6 fluid ounce cartridges. Chomerics part numbers are as follows:

- 19-26-1800-0020, 35 grams in a 30 cc syringe
- 19-26-1800-0250, 350 grams in a 12 fluid ounce cartridge