Conductive Elastomer Extruded Strips

Extruded Strips

Chomerics' extruded conductive elastomer gaskets are solid and hollow strips which are available in a variety of cross section configurations. Sizes range from a 0.060 inch (1.5 mm) diameter hollow "O" to a 2.00 inch (50.8 mm) wide ribbon strip.

High precision cut-to-length extrusions with tolerances similar to molded part tolerances are available using the cutting technology of Parker's JBL Division.

In addition to the standard extrusions listed here, Chomerics has produced many specialized custom gasket shapes tailored to meet particular require-ments. Custom gaskets, accommodate special attachment needs, large deflection range for loosely toleranced parts, or ultra-low closure force.

Splicing Gaskets

For fabricated gaskets with an I.D. of 2 inches (51 mm) or more, many extruded strips can be cut and spliced to form a continuous seal. Gaskets formed this way offer cost savings over molded gaskets without sacrificing performance. The joint is vulcanized under heat and pressure. For solid extrusions, the splice is often as strong and resilient as the gasket material's tensile specification (except fluorosilicone). Grooves must provide corner radii equal to or greater than $2^1/_2$ times the strip width.

Note: Certain extrusion profiles cannot be spliced without twisting inside-out. If questionable, consult Chomerics.

General Tolerances

The following table provides general tolerances for extruded conductive elastomer gaskets. It is important to note that *all flat die-cut, molded, and extruded gaskets are subject to free-state variation in the unrestrained condition*. The use of inspection fixtures to verify conformance of finished parts is common and recommended where appropriate.

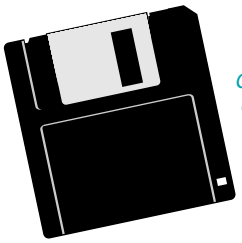
Table 1

EXTRUDED STRIP GASKETS *inch (mm)*	TOLERANCE
Cut Length	
Without Tooling	
≤30 (762.0)	±.062 (1.575)
>30 (762.0)	±0.2% Nom. Dim.
With Tooling	
< .100 (2.54)	±.008 (.203)
.100 to .999 (2.54-25.4)	±.010 (.254)
1 to 5.999 (25.4-152.4)	±.015 (.381)
6 to 12 (152.4-304.8)	±.032 (.813)
>12 (304.8)	±.062 (1.575)
Cross Section	
< .200 (5.08)	±.005 (.127)
.200-.349 (5.10-8.86)	±.008 (.203)
.350-.500 (8.90-12.70)	±.010 (.254)
> .500 (12.70)	Contact a Chomerics Applications or Sales Engineer

Ordering Procedure

For standard configurations, select the Chomerics part number from Tables 7-15, on the following pages. The last four or five digits designate the material type. Orders must also specify quantity in length (feet or meters). Please note that minimum order quantities may apply. Subject only to packaging constraints, the gaskets are shipped in continuous lengths on reels.

For custom configurations, cut-to-length parts, or spliced strips, drawings must be provided. Part numbers for these will be assigned by Chomerics.



Chomerics offers a comprehensive guide to its extrusion products on disk (PC format). Drawings, part numbers and dimensions are provided for all standard and custom cross sections.

Contact Chomerics' Marketing Communications Department for your disk copy of our Extrusion Products Guide.

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Europe Tel: (44) 1628 404000 Fax: (44) 1628 404090
Parker Seals

Material Selection and Manufacturing Limitations

The extruded strips listed in this section are generally available in the CHO-SEAL and CHO-SIL materials enumerated directly below. The physical characteristics of certain materials, however, make them unextrudable in very small sizes. General manufacturing limitations are shown in Table 2 below. Specific material exceptions (non-availability) are denoted by numerical superscripts following certain part numbers in Tables 7-15, on the following pages. The superscripts are defined below:

Code	Material
1	1273, S6304, S6305, S6600, S6602, 6370
2	1350, L6303
3	1356, 1485

Pressure-Sensitive Adhesive (PSA)

Chomerics' extruded conductive elastomer EMI gaskets are available with tenacious, non-conductive pressure-sensitive adhesive (PSA) tape for permanent attachment. Typical properties for this adhesive are shown in Table 3, on the next page. Peel strength data appears in Table 4. These acrylic pressure-sensitive adhesives do not appreciably affect the through-flange resistance of the EMI gasket (see Table 5, on the next page). Rapid thermal cycle testing does not affect peel strength (see Table 6).

Pressure-Sensitive Adhesive Widths, inch (mm)

.090 (2.29)
.100 (2.54)
.125 (3.17)
.160 (4.06)
.220 (5.08)
.250 (6.35)
.625 (15.87)

In general, pressure-sensitive adhesive requires a minimum of 0.125 inch (3.17 mm) mating surface. For this reason, Chomerics does not ordinarily supply pressure-sensitive adhesive on Solid or Hollow O-Strips.

Surface Preparation of Metallic Substrates

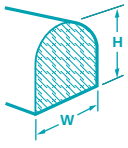
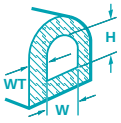
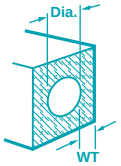
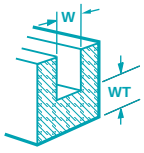
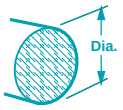
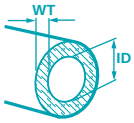
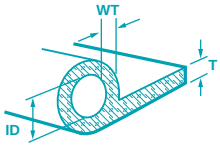
Optimal performance of the pressure-sensitive adhesive requires that the substrates to which these gaskets must adhere are cleaned prior to application. Chomerics has developed specific, easy-to-follow procedures for preparing the following substrates:

- Phosphate-Coated Steel
- Conversion-Coated Aluminum
- Stainless Steel and Mild Steel

It is essential to follow these cleaning instructions to ensure maximum adhesion of the PSA to metal substrates. *Failure to comply with the appropriate cleaning process could result in poor adhesion. Proper safety precautions should be followed to protect the operator.*

Table 2

EXTRUSION MANUFACTURING GUIDELINES & LIMITATIONS
Minimum dimensions allowed for manufacturing consistency

	 Solid D		 Hollow D			 Hollow Rect.		 Channel		 Solid O	 Hollow O		 Hollow P			 Rectangular
	H	W	WT	H	W	Dia.	WT	WT	W	Dia.	WT	ID	WT	T	ID	T*
1273	0.035	0.035	0.020	0.040	0.040	0.020	0.025	0.020	0.020	0.028	0.015	0.020	0.020	0.030	0.045	0.031
1350	0.035	0.035	0.025	0.040	0.040	0.020	0.032	0.032	0.020	0.035	0.020	0.020	0.020	0.030	0.045	0.031
1356	0.040	0.040	0.025	0.040	0.040	0.020	0.032	0.032	0.020	0.040	0.020	0.020	0.020	0.030	0.045	0.031
1485	0.040	0.040	0.025	0.040	0.040	0.020	0.032	0.032	0.020	0.040	0.020	0.020	0.020	0.030	0.045	0.031
L6303	0.035	0.035	0.025	0.040	0.040	0.020	0.032	0.032	0.020	0.035	0.020	0.020	0.020	0.030	0.045	0.031
S6304	0.035	0.035	0.020	0.040	0.040	0.020	0.025	0.020	0.020	0.028	0.015	0.020	0.020	0.030	0.045	0.031
S6305	0.035	0.035	0.020	0.040	0.040	0.020	0.025	0.020	0.020	0.028	0.015	0.020	0.020	0.030	0.045	0.031
S6600	0.035	0.035	0.020	0.040	0.040	0.020	0.025	0.020	0.020	0.028	0.015	0.020	0.020	0.030	0.045	0.031
S6602	0.035	0.035	0.020	0.040	0.040	0.020	0.025	0.020	0.020	0.028	0.015	0.020	0.020	0.030	0.045	0.031
6370	0.035	0.035	0.020	0.040	0.040	0.020	0.025	0.020	0.020	0.028	0.015	0.020	0.020	0.030	0.045	0.031

Consult Chomerics' Applications Engineering Department concerning material compatibility for smaller dimensions and custom extrusions.

* Maximum width of 1.000 inch at minimum thickness of 0.031 inch.
Dimensions shown in inches. 1 inch = 25.4 mm.

Materials Required:
3M Scotch Brite Pads or equivalent, Rubber Gloves, Safety Glasses, Lint-Free Cotton Wipes, MEK, Acetone or Isopropyl Alcohol (IPA).

Surface Preparation of Conversion-Coated Aluminum and Phosphate-Coated Steel

A. Using a clean, lint-free applicator, moistened with MEK, acetone solvent or IPA, wash the aluminum surface until all traces of contamination have been removed.

B. Clean the surface until the cotton applicator shows no discoloration.

C. If discoloration still exists, continue washing, changing the cotton applicator each time, until clean.

Note: With phosphate coatings, it is very hard to remove all discoloration from the surface so it is up to the operator to determine the cleanliness of the surface prior to bonding. Typically, cleaning the surface 3 times is required.

D. Allow the substrate to dry completely at room temperature. After the cleaning sequence is complete, do not touch the substrate with bare hands.

E. If the cleaned surfaces do not have the PSA applied within an 8-hour period, rewash using the above process.

Surface Preparation of Stainless Steel and Mild Steel

A. Using a Scotch Brite 3M pad or equivalent, lightly abrade the steel surface.

B. Blow the dust residue off the steel surface with oil-free filtered air.

C. Follow Steps A through E from previous section to complete surface preparation.

Gasket Installation Procedure

1. Cut gasket material to specific lengths per drawing. If gasket is one piece (e.g., four corner spliced gasket), pre-fit the assembly to ensure fit and location.
2. Remove a portion of the release liner and position the gasket. Press firmly against gasket to tack in place. Continue pressing along entire length of gasket until it is positioned and aligned to the mating surface.
3. Using a rubber roller, apply moderate pressure to the entire gasket to ensure complete contact between the PSA and substrate surface.

Note: It is important during this rolling procedure that the operator not apply excessive pressure to the gasket. Extreme pressure will cause the gasket to elongate and creep as it relaxes, which may cause an intermittent bond to the substrate surface.

Optimum Application Temperature

Temperatures below 50°F (10°C) can cause poor gasket adhesion to the substrate. Ideal gasket installation temperature is 72°F (22°C), ambient room temperature. All materials should be stored at this temperature when not in use. Hardware and gasket materials stored below 50°F should be brought to room temperature before installing gasket.

PSA Ordering Procedure

Pressure-sensitive adhesive may be ordered for any standard extrusion, other than Solid and Hollow O-Strips, which has a 0.125 inch (3.17 mm) mating surface. The standard Part Numbers listed in Tables 9-15, on the next page must be modified by Chomerics to designate pressure-sensitive adhesive. Contact us for this information.

Table 3

PRESSURE-SENSITIVE ADHESIVE TYPICAL PROPERTIES	
Adhesive Description	Pressure-sensitive acrylic with release liner
Service Temperature Range	–20 to +150°F (–29 to +66°C); PSA will function for short periods of time @ 200°F (93°C); ultimate high temperature limit 250°F (121°C)
Shelf Life Conditions	One year at 158°F (70°C)/50% RH
Application Temperature Range	40 to 150°F (4 to 66°C)

Table 4

TYPICAL PEEL STRENGTH *lb/inch (N/mm)*		
Property	**On Aluminum**	**On Steel**
Initial Peel Strength	6.0 (1.05)	6.0 (1.05)
Heat Aged Peel Strength*	5.4 (.945)	5.4 (.945)
Humidity Peel Strength**	6.0 (1.05)	6.0 (1.05)

Peel Strength Test Data Per ASTM D1000 (90° peel).
* Heat aging 168 hrs/158°F (70°C).
** Humidity 168 hrs/95% RH/158°F (70°C).

Table 5

TYPICAL THROUGH FLANGE ELECTRICAL RESISTANCE			
Chomerics P/N 10-05-3369-S6304 (Ni/C filled silicone)		**@ 10% deflection**	**@ 25% deflection**
Hollow "D" Shape Extrusion	w/PSA	.23 ohm	.14 ohm
	w/out PSA	.16 ohm	.14 ohm

Table 6

RAPID THERMAL CYCLING* *lb/inch (N/mm)*		
Conductive Elastomer	**Flange**	**Peel Strength (90°)**
CHO-SEAL 1485 (Silver-Plated-Aluminum-Filled Silicone)	Steel	7.0 (1.23)
	Aluminum	7.0 (1.23)
CHO-SEAL S6304 (Nickel-Plated-Graphite-Filled Silicone)	Steel	6.5 (1.14)
	Aluminum	5.5 (0.96)

*Per ASTM D1000; 5 cycles at –48° to 212°F (–40° to 100°C) with dwell time of 15 minutes at each extreme.

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Standard Extrusion Sizes

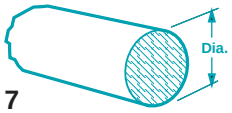

Table 7

O-STRIPS			
		"Rule of Thumb" Groove Dimensions†	
Chomerics P/N*	Nominal Dimension [Dia.]	Depth	Width
19-04-12895-XXXX[2, 3]	0.028 (0.71)	0.018 (0.46)	0.055 (1.40)
19-04-W993-XXXX[2, 3]	0.030 (0.76)	0.020 (0.51)	0.056 (1.42)
19-04-12896-XXXX[2, 3]	0.032 (0.81)	0.022 (0.56)	0.056 (1.42)
19-04-12897-XXXX[2, 3]	0.033 (0.84)	0.023 (0.58)	0.056 (1.42)
10-04-6386-XXXX	0.040 (1.02)	0.029 (0.74)	0.061 (1.55)
10-04-9139-XXXX	0.048 (1.22)	0.037 (0.94)	0.065 (1.65)
10-04-C317-XXXX	0.050 (1.27)	0.038 (0.97)	0.068 (1.73)
10-04-3560-XXXX	0.053 (1.35)	0.041 (1.04)	0.070 (1.78)
19-04-X294-XXXX	0.060 (1.52)	0.047 (1.19)	0.076 (1.93)
10-04-2561-XXXX	0.062 (1.57)	0.049 (1.24)	0.077 (1.96)
10-04-1687-XXXX	0.070 (1.78)	0.056 (1.42)	0.084 (2.13)
19-04-12987-XXXX	0.074 (1.88)	0.060 (1.52)	0.087 (2.21)
19-04-11228-XXXX	0.075 (1.91)	0.061 (1.55)	0.087 (2.21)
19-04-12899-XXXX	0.077 (1.96)	0.063 (1.60)	0.089 (2.26)
19-04-12900-XXXX	0.079 (2.01)	0.064 (1.63)	0.091 (2.31)
10-04-2657-XXXX	0.080 (2.03)	0.065 (1.65)	0.092 (2.34)
19-04-12901-XXXX	0.085 (2.16)	0.069 (1.75)	0.097 (2.46)
19-04-M394-XXXX	0.090 (2.29)	0.073 (1.85)	0.102 (2.59)
10-04-2865-XXXX	0.093 (2.36)	0.076 (1.93)	0.104 (2.64)
10-04-3509-XXXX	0.100 (2.54)	0.082 (2.08)	0.110 (2.79)
10-04-1720-XXXX	0.103 (2.62)	0.084 (2.13)	0.114 (2.90)
19-04-12902-XXXX	0.106 (2.69)	0.087 (2.21)	0.114 (2.90)

continued next column

Table 7 *continued*

O-STRIPS			
		"Rule of Thumb" Groove Dimensions†	
Chomerics P/N*	Nominal Dimension [Dia.]	Depth	Width
10-04-2866-XXXX	0.112 (2.84)	0.092 (2.34)	0.121 (3.07)
10-04-3077-XXXX	0.119 (3.02)	0.098 (2.49)	0.128 (3.25)
10-04-2463-XXXX	0.125 (3.18)	0.102 (2.59)	0.135 (3.43)
10-04-2862-XXXX	0.130 (3.30)	0.107 (2.72)	0.138 (3.51)
19-04-12903-XXXX	0.134 (3.40)	0.110 (2.79)	0.143 (3.63)
10-04-1721-XXXX	0.139 (3.53)	0.114 (2.90)	0.147 (3.73)
19-04-12904-XXXX	0.147 (3.73)	0.120 (3.05)	0.156 (3.96)
10-04-3982-XXXX	0.150 (3.81)	0.123 (3.12)	0.158 (4.01)
19-04-12906-XXXX	0.158 (4.01)	0.129 (3.28)	0.166 (4.22)
19-04-12905-XXXX	0.159 (4.04)	0.130 (3.30)	0.167 (4.24)
10-04-3231-XXXX	0.160 (4.06)	0.131 (3.33)	0.168 (4.27)
19-04-12907-XXXX	0.170 (4.32)	0.139 (3.53)	0.178 (4.52)
19-04-F371-XXXX	0.188 (4.78)	0.154 (3.91)	0.195 (4.95)
19-04-12908-XXXX	0.195 (4.95)	0.160 (4.06)	0.201 (5.11)
10-04-2864-XXXX	0.216 (5.49)	0.177 (4.50)	0.227 (5.77)
19-04-12909-XXXX	0.219 (5.56)	0.179 (4.55)	0.231 (5.87)
19-04-11453-XXXX	0.220 (5.59)	0.180 (4.57)	0.232 (5.89)
19-04-12910-XXXX	0.236 (5.99)	0.193 (4.90)	0.247 (6.27)
19-04-12911-XXXX	0.247 (6.27)	0.202 (5.13)	0.258 (6.55)
10-04-3076-XXXX	0.250 (6.35)	0.205 (5.21)	0.260 (6.60)

* Replace XXXX with four or five digit material number (1356, 1273, S6305, etc.). Smallest sizes may not be extrudable in certain materials. For explanation of superscript codes following XXXX, which indicate non-availability, refer to page 15.

† ***Note:*** The groove dimensions recommended assume groove tolerance of ±0.002" (0.05 mm) for standard O- and D-strips. Closure forces are assumed to provide maximum and uniform gasket deflection. If these conditions are not attainable, contact Chomerics' Applications Engineering Department before ordering.

continued next page

(mm dimensions in parentheses)

Table 7 *continued*

O-STRIPS			
Chomerics P/N*	Nominal Dimension [Dia.]	"Rule of Thumb" Groove Dimensions† Depth	Width
10-04-9769-XXXX	0.280 (7.11)	0.230 (5.84)	0.288 (7.32)
19-04-12912-XXXX	0.291 (7.39)	0.238 (6.05)	0.300 (7.62)
19-04-12913-XXXX	0.292 (7.42)	0.239 (6.07)	0.301 (7.65)
19-04-19214-XXXX	0.317 (8.05)	0.260 (6.60)	0.324 (8.23)
19-04-12915-XXXX	0.324 (8.23)	0.265 (6.73)	0.332 (8.43)
19-04-12916-XXXX	0.329 (8.36)	0.270 (6.86)	0.335 (8.51)
19-04-12917-XXXX	0.348 (8.84)	0.285 (7.24)	0.354 (8.99)
19-04-12918-XXXX	0.367 (9.32)	0.301 (7.65)	0.376 (9.55)
19-04-12919-XXXX	0.379 (9.63)	0.310 (7.87)	0.388 (9.86)
19-04-12920-XXXX	0.393 (9.98)	0.322 (8.18)	0.401 (10.19)
19-04-12921-XXXX	0.410 (10.41)	0.336 (8.53)	0.417 (10.59)
19-04-12922-XXXX	0.420 (10.67)	0.344 (8.74)	0.427 (10.85)
19-04-W337-XXXX	0.429 (10.90)	0.351 (8.92)	0.436 (11.07)
19-04-12923-XXXX	0.479 (12.17)	0.392 (9.96)	0.484 (12.29)
19-04-12924-XXXX	0.570 (14.48)	0.467 (11.86)	0.590 (14.99)
19-04-12925-XXXX	0.635 (16.13)	0.520 (13.21)	0.653 (16.59)
19-04-12926-XXXX	0.661 (16.79)	0.542 (13.77)	0.677 (17.20)
19-04-12927-XXXX	0.831 (21.11)	0.681 (17.30)	0.860 (21.84)
19-04-12928-XXXX	0.876 (22.25)	0.718 (18.24)	0.903 (22.94)
19-04-12929-XXXX	0.894 (22.71)	0.733 (18.62)	0.920 (23.37)
19-04-12930-XXXX	0.922 (23.42)	0.756 (19.20)	0.947 (24.05)

* Replace XXXX with four or five digit material number (1356, 1273, S6305, etc.). Smallest sizes may not be extrudable in certain materials. For explanation of superscript codes following XXXX, which indicate non-availability, refer to page 2.

† ***Note:*** The groove dimensions recommended assume groove tolerance of ±0.002" (0.05 mm) for standard O- and D-strips. Closure forces are assumed to provide maximum and uniform gasket deflection. If these conditions are not attainable, contact Chomerics' Applications Engineering Department before ordering.

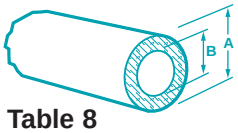

Table 8

HOLLOW O-STRIPS		
Chomerics P/N*	Nominal Dimensions A	B
10-04-W137-XXXX	0.060 (1.52)	0.020 (0.51)
19-04-11204-XXXX	0.081 (2.06)	0.020 (0.51)
19-04-12570-XXXX[2, 3]	0.083 (2.11)	0.050 (1.27)
10-04-W267-XXXX	0.090 (2.29)	0.050 (1.27)
10-04-W293-XXXX[2, 3]	0.090 (2.29)	0.060 (1.52)
19-04-11205-XXXX	0.102 (2.60)	0.039 (0.99)
10-04-M211-XXXX	0.103 (2.62)	0.040 (1.02)
19-04-10212-XXXX	0.110 (2.79)	0.045 (1.14)
19-04-12534-XXXX[2, 3]	0.118 (3.00)	0.079 (2.01)
19-04-11216-XXXX	0.122 (3.10)	0.061 (1.55)
10-04-2999-XXXX	0.125 (3.18)	0.045 (1.14)
10-04-8817-XXXX	0.125 (3.18)	0.062 (1.57)
19-04-11283-XXXX	0.125 (3.18)	0.080 (2.03)
10-04-W775-XXXX	0.125 (3.18)	0.085 (2.16)
10-04-5514-XXXX	0.130 (3.30)	0.045 (1.14)
19-04-X787-XXXX[2, 3]	0.135 (3.43)	0.097 (2.46)
19-04-11289-XXXX	0.145 (3.68)	0.070 (1.78)
10-04-4180-XXXX	0.156 (3.96)	0.050 (1.27)
10-04-9732-XXXX	0.156 (3.96)	0.080 (2.03)
19-04-11213-XXXX[2, 3]	0.172 (4.37)	0.140 (3.56)
19-04-11293-XXXX[2, 3]	0.175 (4.45)	0.144 (3.66)
10-04-8133-XXXX	0.177 (4.50)	0.079 (2.01)
19-04-11214-XXXX	0.180 (4.57)	0.140 (3.56)
10-04-4254-XXXX	0.190 (4.83)	0.080 (2.03)
19-04-12015-XXXX	0.207 (5.26)	0.077 (1.95)
19-04-E483-XXXX	0.210 (5.33)	0.093 (2.36)
10-04-2737-XXXX	0.250 (6.35)	0.125 (3.18)
10-04-3221-XXXX	0.290 (7.36)	0.175 (4.45)
19-04-W049-XXXX	0.290 (7.36)	0.156 (3.96)
10-04-3004-XXXX	0.312 (7.92)	0.192 (4.88)
19-04-14292-XXXX	0.373 (9.47)	0.200 (5.08)
10-04-3122-XXXX	0.375 (9.53)	0.250 (6.35)
19-04-14291-XXXX	0.404 (10.26)	0.223 (5.66)
19-04-14290-XXXX	0.404 (10.26)	0.243 (6.17)
19-04-12338-XXXX	0.430 (10.92)	0.330 (8.38)
10-04-4034-XXXX	0.437 (11.10)	0.347 (8.81)
19-04-14138-XXXX	0.440 (11.18)	0.280 (7.11)
19-04-14139-XXXX	0.461 (11.71)	0.315 (8.00)
10-04-3649-XXXX	0.479 (11.94)	0.345 (8.76)
10-04-5572-XXXX	0.500 (12.70)	0.385 (9.78)

continued next page

(mm dimensions in parentheses)

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Parker Seals

Table 8 *continued*

HOLLOW O-STRIPS		
Chomerics P/N*	Nominal Dimensions	
	A	B
19-04-11651-XXXX	0.524 (13.31)	0.315 (8.00)
10-04-4155-XXXX	0.555 (14.10)	0.425 (10.80)
10-04-5515-XXXX	0.562 (14.27)	0.437 (11.10)
10-04-5516-XXXX	0.620 (15.75)	0.515 (13.08)
10-04-3652-XXXX	0.650 (16.51)	0.520 (13.21)

* Replace XXXX with four or five digit material number (1356, 1273, S6305, etc.). Smallest sizes may not be extrudable in certain materials. For explanation of superscript codes following XXXX, which indicate non-availability, refer to page 2.

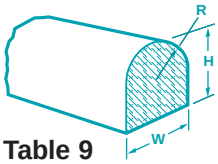

Table 9

D-STRIPS					
Chomerics P/N*	Nominal Dimensions			"Rule of Thumb" Groove Dimensions†	
	H	W	R(rad.)	Depth	Width
10-05-5589-XXXX[3]	0.064 (1.63)	0.055 (1.40)	0.031 (0.79)	0.052 (1.32)	0.077 (1.96)
10-05-Z337-XXXX[3]	0.075 (1.90)	0.060 (1.52)	0.030 (0.76)	0.062 (1.57)	0.089 (2.26)
10-05-1362-XXXX	0.068 (1.73)	0.062 (1.57)	0.031 (0.79)	0.056 (1.42)	0.084 (2.13)
19-05-E163-XXXX	0.074 (1.88)	0.062 (1.57)	0.031 (0.78)	0.061 (1.55)	0.088 (2.23)
19-05-12883-XXXX	0.085 (2.16)	0.062 (1.57)	0.031 (0.78)	0.072 (1.83)	0.088 (2.23)
10-05-4699-XXXX	0.100 (2.54)	0.062 (1.57)	0.031 (0.79)	0.085 (2.16)	0.081 (2.06)
19-05-12887-XXXX[3]	0.055 (1.40)	0.064 (1.62)	0.032 (0.81)	0.044 (1.12)	0.101 (2.57)
10-05-E205-XXXX	0.095 (2.41)	0.070 (1.78)	0.035 (0.89)	0.081 (2.06)	0.097 (2.46)
10-05-1363-XXXX	0.089 (2.26)	0.078 (1.98)	0.039 (0.99)	0.074 (1.88)	0.101 (2.57)

continued next column

* Replace XXXX with four or five digit material number (1356, 1273, S6305, etc.). Smallest sizes may not be extrudable in certain materials. For explanation of superscript codes following XXXX, which indicate non-availability, refer to page 2.

Table 9 *continued*

D-STRIPS					
Chomerics P/N*	Nominal Dimensions			"Rule of Thumb" Groove Dimensions†	
	H	W	R(rad.)	Depth	Width
19-05-C497-XXXX	0.070 (1.78)	0.080 (2.03)	0.040 (1.02)	0.058 (1.47)	0.116 (2.95)
19-05-E329-XXXX	0.090 (2.29)	0.080 (2.03)	0.040 (1.02)	0.076 (1.93)	0.111 (2.82)
19-05-12888-XXXX	0.081 (2.06)	0.088 (2.23)	0.044 (1.12)	0.068 (1.73)	0.123 (3.12)
19-05-A611-XXXX	0.134 (3.40)	0.091 (2.31)	0.045 (1.14)	0.117 (2.97)	0.118 (3.00)
10-05-3224-XXXX	0.078 (1.98)	0.094 (2.39)	0.047 (1.19)	0.065 (1.65)	0.115 (2.92)
19-05-Z586-XXXX	0.094 (2.39)	0.094 (2.39)	0.047 (1.19)	0.080 (2.03)	0.128 (3.25)
19-05-C128-XXXX	0.115 (2.92)	0.102 (2.60)	0.051 (1.30)	0.099 (2.51)	0.134 (3.40)
10-05-1499-XXXX	0.156 (3.96)	0.118 (3.00)	0.059 (1.50)	0.137 (3.48)	0.136 (3.45)
10-05-1364-XXXX	0.135 (3.43)	0.122 (3.10)	0.061 (1.55)	0.118 (3.00)	0.140 (3.56)
10-05-A283-XXXX	0.131 (3.33)	0.122 (3.10)	0.061 (1.55)	0.114 (2.90)	0.156 (3.96)
19-05-F364-XXXX	0.135 (3.43)	0.124 (3.15)	0.062 (1.57)	0.118 (3.00)	0.158 (4.01)
19-05-F084-XXXX	0.125 (3.18)	0.125 (3.18)	0.062 (1.57)	0.108 (2.74)	0.161 (4.09
10-05-2618-XXXX	0.110 (2.79)	0.150 (3.81)	0.075 (1.91)	0.095 (2.41)	0.165 (4.19)
19-05-F173-XXXX	0.156 (3.96)	0.156 (3.96)	0.078 (1.98)	0.137 (3.48)	0.194 (4.93)
10-05-1577-XXXX	0.175 (4.45)	0.178 (4.52)	0.089 (2.26)	0.154 (3.91)	0.195 (4.95)
19-05-A381-XXXX	0.200 (5.08)	0.187 (4.75)	0.093 (2.36)	0.177 (4.50)	0.228 (5.79)
19-05-12899-XXXX	0.205 (5.21)	0.187 (4.75)	0.093 (2.36)	0.179 (4.55)	0.234 (5.94)
19-05-W496-XXXX	0.188 (4.78)	0.188 (4.78)	0.094 (2.39)	0.166 (4.22)	0.229 (5.82)
19-05-12890-XXXX	0.324 (8.23)	0.487 (12.37)	0.243 (6.17)	0.289 (7.34)	0.577 (14.66)

† ***Note:*** The groove dimensions recommended assume groove tolerance of ±0.002" (0.05 mm) for standard O- and D-strips. Closure forces are assumed to provide maximum and uniform gasket deflection. If these conditions are not attainable, contact Chomerics' Applications Engineering Department before ordering.

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Pressure-Sensitive Adhesive *is available on any extrusion with a minimum 0.125 inch (3.17 mm) mating surface. Contact Chomerics to obtain modified Part Numbers. Refer to pages 2-3 for details.*

(mm dimensions in parentheses)

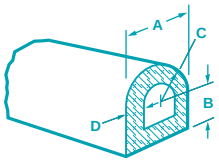

Table 10

HOLLOW D-STRIPS				
	Nominal Dimensions			
Chomerics P/N*	A	B	C (rad.)	D
10-05-6419-XXXX	0.156 (3.96)	0.078 (1.98)	0.078 (1.98)	0.045 (1.14)
10-05-4202-XXXX	0.187 (4.75)	0.093 (2.36)	0.093 (2.36)	0.050 (1.27)
19-05-X254-XXXX	0.187 (4.75)	0.134 (3.43)	0.093 (2.36)	0.040 (1.02)
19-04-11231-XXXX	0.207 (5.26)	0.084 (2.13)	0.103 (2.62)	0.050 (1.27)
10-05-4318-XXXX**	0.312 (7.92)	0.200 (5.08)	0.112 (2.84)	0.062 (1.57)
10-05-6991-XXXX	0.250 (6.35)	0.125 (3.18)	0.125 (3.18)	0.062 (1.57)
10-05-6394-XXXX	0.250 (6.35)	0.125 (3.18)	0.125 (3.18)	0.065 (1.65)
10-05-4308-XXXX	0.312 (7.92)	0.156 (3.96)	0.156 (3.96)	0.062 (1.57)
10-05-3369-XXXX††	0.312 (7.92)	0.156 (3.96)	0.156 (3.96)	0.062 (1.57)
19-05-10277-XXXX	0.296 (7.52)	0.015 (0.38)	0.172 (4.37)	0.030 (0.76)
19-05-L467-XXXX	0.296 (7.52)	0.015 (0.38)	0.172 (4.37)	0.050 (1.27)
19-05-12067-XXXX	0.487 (12.37)	0.080 (2.03)	0.244 (6.20)	0.035 (0.89)
19-05-12066-XXXX	0.487 (12.37)	0.080 (2.03)	0.244 (6.20)	0.045 (1.14)
19-05-12375-XXXX	0.487 (12.37)	0.080 (2.03)	0.244 (6.20)	0.062 (1.57)
10-05-4542-XXXX	0.487 (12.37)	0.080 (2.03)	0.244 (6.20)	0.080 (2.03)
10-05-C589-XXXX	0.488 (12.40)	0.068 (1.73)	0.244 (6.20)	0.055 (1.40)
10-05-C038-XXXX	0.488 (12.40)	0.080 (2.03)	0.244 (6.20)	0.080 (2.03)
19-05-E429-XXXX	0.502 (12.75)	0.250 (6.35)	0.250 (6.35)	0.061 (1.55)
10-05-4282-XXXX	0.700 (17.78)	0.250 (6.35)	0.350 (8.89)	0.100 (2.54)
19-05-L362-XXXX	0.750 (19.05)	0.375 (9.53)	0.375 (9.53)	0.075 (1.91)
19-05-W379-XXXX	0.975 (24.77)	0.132 (3.35)	0.488 (12.40)	0.093 (2.36)

* Replace XXXX with four or five digit material number (1356, 1273, S6305, etc.) Smallest sizes may not be extrudable in certain materials. Refer to page 2.

** Dimension "A" measured at bottom (width narrows to become tangent to "C" radius).

†† Includes internal radii for low closure properties.

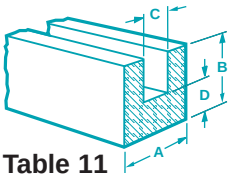

Table 11

CHANNEL STRIPS				
	Nominal Dimensions			
Chomerics P/N*	A	B	C	D
19-08-14054-XXXX	0.075 (1.91)	0.099 (2.51)	0.025 (0.64)	0.032 (0.81)
10-08-6475-XXX	0.100 (2.54)	0.100 (2.54)	0.034 (0.86)	0.033 (0.84)
19-08-12880-XXXX	0.126 (3.20)	0.078 (1.98)	0.044 (1.12)	0.048 (1.22)
19-08-12881-XXXX	0.126 (3.20)	0.099 (2.51)	0.047 (1.19)	0.059 (1.50)
10-08-8340-XXXX	0.126 (3.20)	0.097 (2.46)	0.026 (0.66)	0.037 (0.94)
10-08-3215-XXXX	0.126 (3.20)	0.110 (2.79)	0.025 (0.64)	0.050 (1.27)
10-08-4315-XXXX	0.126 (3.20)	0.225 (5.72)	0.020 (0.51)	0.075 (1.91)
19-08-12882-XXXX	0.154 (3.91)	0.154 (3.91)	0.082 (2.08)	0.088 (2.24)
10-08-3157-XXXX	0.156 (3.96)	0.156 (3.96)	0.062 (1.57)	0.04 7(1.19)
19-08-12844-XXXX	0.156 (3.96)	0.175 (4.45)	0.046 (1.17)	0.075 (1.90)
10-08-3253-XXXX	0.175 (4.45)	0.156 (3.96)	0.047 (1.19)	0.075 (1.91)
10-08-F815-XXXX	0.188 (4.78)	0.188 (4.78)	0.062 (1.57)	0.062 (1.57)
19-08-12884-XXXX	0.193 (4.90)	0.193 (4.90)	0.128 (3.25)	0.064 (1.62)
19-08-12158-XXXX	0.250 (6.35)	0.250 (6.35)	0.170 (4.32)	0.062 (1.57)
19-08-C929-XXXX	0.250 (6.35)	0.250 (6.25)	0.130 (3.30)	0.062 (1.57)
19-08-12885-XXXX	0.260 (6.60)	0.184 (4.67)	0.140 (3.56)	0.062 (1.57)
19-08-12886-XXXX	0.320 (8.13)	0.315 (8.00)	0.193 (4.90)	0.197 (5.00)
10-08-3872-XXXX**	0.327 (8.31)	0.235 (5.97)	0.062 (1.57)	0.115 (2.92)
19-08-E622-XXXX	0.375 (9.53)	0.500 (12.7)	0.187 (4.75)	0.125 (3.18)

* Replace XXXX with four or five digit material number (1356, 1273, S6305, etc.). Smallest sizes may not be extrudable in certain materials. Refer to page 2.

** Slot not centered. Centerline of slot is 0.167 in. (4.24mm) from left edge.

Pressure-Sensitive Adhesive *is available on any extrusion with a minimum 0.125 inch (3.17 mm) mating surface. Contact Chomerics to obtain modified Part Numbers. Refer to pages 2-3 for details.*

(mm dimensions in parentheses)

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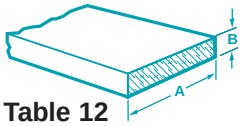

Table 12

RECTANGULAR STRIPS		
Chomerics P/N*	Nominal Dimensions A	B
19-07-12947-XXXX	0.041 (1.04)	0.031 (0.78)
19-07-10959-XXXX	0.870 (22.10)	0.032 (0.81)
19-17-M327-XXXX	1.000 (25.40)	0.032 (0.81)
19-07-12960-XXXX	1.000 (25.40)	0.033 (0.84)
19-07-Z499-XXXX	0.114 (2.89)	0.039 (0.99)
19-07-11206-XXXX	0.120 (3.05)	0.040 (1.02)
19-07-12675-XXXX	0.500 (12.70)	0.040 (1.02)
10-07-4272-XXXX	0.063 (1.60)	0.042 (1.07)
19-07-11081-XXXX	1.000 (25.40)	0.042 (1.06)
10-07-F743-XXXX	0.375 (9.53)	0.060 (1.52)
19-07-12959-XXXX	0.640 (16.25)	0.060 (1.52)
10-07-L525-XXXX	1.120 (28.45)	0.060 (1.52)
10-07-2981-XXXX	0.095 (2.41)	0.062 (1.57)
10-07-3225-XXXX	0.125 (3.18)	0.062 (1.57)
10-07-3047-XXXX	0.156 (3.96)	0.062 (1.57)
19-07-F463-XXXX	0.188 (4.77)	0.062 (1.57)
10-07-3226-XXXX	0.250 (6.35)	0.062 (1.57)
19-07-12200-XXXX	0.500 (12.70)	0.062 (1.57)
19-07-12958-XXXX	0.569 (14.45)	0.062 (1.57)
10-07-4483-XXXX	0.750 (19.05)	0.062 (1.57)
10-07-4523-XXXX	0.880 (22.35)	0.062 (1.57)
19-07-E431-XXXX	1.000 (25.40)	0.062 (1.57)
10-07-4538-XXXX	1.180 (29.97)	0.062 (1.57)
19-07-12961-XXXX	1.210 (30.73)	0.062 (1.57)
19-07-W391-XXXX	1.600 (40.64)	0.062 (1.57)
19-07-F067-XXXX	2.000 (50.80)	0.062 (1.57)
19-07-12954-XXXX	0.255 (6.47)	0.063 (1.60)
19-07-12956-XXXX	0.508 (12.90)	0.063 (1.60)
10-07-4014-XXXX	0.120 (3.05)	0.075 (1.91)
10-07-3522-XXXX	0.500 (12.70)	0.075 (1.91)
19-07-12952-XXXX	0.188 (4.77)	0.080 (2.03)
19-07-12948-XXXX	0.085 (2.16)	0.085 (2.16)
19-07-11080-XXXX	1.000 (25.40)	0.090 (2.28)
19-07-Z500-XXXX	0.114 (2.89)	0.091 (2.31)
19-07-F193-XXXX	0.093 (2.36)	0.093 (2.36)
19-07-12953-XXXX	0.188 (4.77)	0.093 (2.36)

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Table 12 *continued*

RECTANGULAR STRIPS		
Chomerics P/N*	Nominal Dimensions A	B
19-07-12491-XXXX	0.500 (12.70)	0.093 (2.36)
19-07-11079-XXXX	0.780 (19.81)	0.100 (2.54)
10-07-C786-XXXX	0.170 (4.32)	0.125 (3.18)
10-07-4217-XXXX	0.500 (12.70)	0.125 (3.18)
19-07-11495-XXXX	0.880 (22.35)	0.125 (3.18)
19-07-8345-XXXX	0.980 (24.89)	0.125 (3.18)
19-07-12951-XXXX	0.126 (3.20)	0.126 (3.20)
19-07-12957-XXXX	0.564 (14.32)	0.127 (3.23)
19-07-F627-XXXX	0.219 (5.56)	0.156 (3.96)
10-07-3080-XXXX	0.500 (12.70)	0.188 (4.78)
10-07-B447-XXXX	0.500 (12.70)	0.250 (6.35)
10-07-3797-XXXX	1.000 (25.40)	0.250 (6.35)
19-07-L956-XXXX	0.875 (22.23)	0.312 (7.92)
19-07-12955-XXXX	0.330 (8.38)	0.350 (7.75)

Note: Some configurations may have a degree of curvature, making them unsuitable in long lengths. Consult Chomerics Applications Engineering for details.

* Replace XXXX with four or five digit material number (1356, 1273, S6305, etc.). Smallest sizes may not be extrudable in certain materials. Refer to page 2.

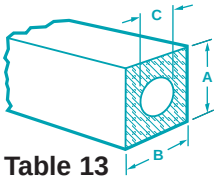

Table 13

HOLLOW RECTANGULAR STRIPS			
Chomerics P/N*	Nominal Dimensions A	B	C (dia.)
10-07-2998-XXXX	0.305 (7.75)	0.330 (8.38)	0.125 (3.18)
10-07-4481-XXXX	0.375 (9.53)	0.375 (9.53)	0.188 (4.78)
10-07-E263-XXXX	0.500 (12.70)	0.500 (12.70)	0.250 (6.35)

* Replace XXXX with four or five digit material number (1356, 1273, S6305, etc.). Smallest sizes may not be extrudable in certain materials. Refer to page 2.

continued next page

Pressure-Sensitive Adhesive *is available on any extrusion with a minimum 0.125 inch (3.17 mm) mating surface. Contact Chomerics to obtain modified Part Numbers. Refer to pages 2-3 for details.*

(mm dimensions in parentheses)

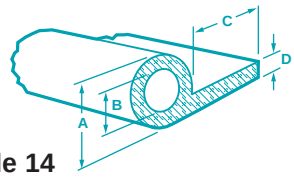

Table 14

HOLLOW P-STRIPS				
	Nominal Dimensions			
Chomerics P/N*	A (dia.)	B (dia.)	C	D
19-06-M151-XXXX	0.125 (3.18)	0.045 (1.14)	0.250 (6.35)	0.062 (1.57)
19-06-Z731-XXXX	0.140 (3.56)	0.100 (2.54)	0.135 (3.43)	0.030 (0.76)
19-06-C442-XXXX	0.164 (4.17)	0.084 (2.13)	0.040 (1.02)	0.095 (2.41)
10-06-M412-XXXX	0.168 (4.26)	0.047 (1.19)	0.200 (5.08)	0.062 (1.57)
19-06-12931-XXXX	0.170 (4.32)	0.060 (1.52)	0.205 (5.21)	0.062 (1.57)
10-06-B227-XXXX	0.190 (4.83)	0.130 (3.30)	0.312 (7.92)	0.062 (1.57)
19-06-13514-XXXX	0.200 (5.08)	0.080 (2.03)	0.083 (2.11)	0.062 (1.57)
10-06-A778-XXXX	0.200 (5.08)	0.080 (2.03)	0.215 (5.46)	0.062 (1.57)
10-06-8737-XXXX	0.200 (5.08)	0.080 (2.03)	0.250 (6.35)	0.062 (1.57)
10-06-8550-XXXX	0.200 (5.08)	0.080 (2.03)	0.275 (6.99)	0.062 (1.57)
19-06-11223-XXXX	0.200 (5.08)	0.080 (2.03)	0.300 (7.62)	0.062 (1.57)
19-06-12942-XXXX	0.200 (5.08)	0.080 (2.03)	0.400 (10.16)	0.062 (1.57)
10-06-6175-XXXX	0.200 (5.08)	0.080 (2.03)	0.550 (13.97)	0.062 (1.57)
10-06-3599-XXXX	0.200 (5.08)	0.080 (2.03)	0.650 (16.51)	0.062 (1.57)
10-06-4142-XXXX	0.250 (6.35)	0.125 (3.18)	0.250 (6.35)	0.062 (1.57)
10-06-3300-XXXX	0.250 (6.35)	0.125 (3.18)	0.375 (9.53)	0.062 (1.57)
10-06-6180-XXXX	0.250 (6.35)	0.125 (3.18)	0.625 (15.88)	0.062 (1.57)
10-06-4921-XXXX	0.250 (6.35)	0.150 (3.81)	0.375 (9.53)	0.062 (1.57)
10-06-C716-XXXX	0.254 (6.45)	0.153 (3.88)	0.254 (6.45)	0.062 (1.57)

continued next column

Table 14 *continued*

HOLLOW P-STRIPS				
	Nominal Dimensions			
Chomerics P/N*	A (dia.)	B (dia.)	C	D
10-06-5611-XXXX	0.312 (7.92)	0.187 (4.75)	0.563 (14.30)	0.062 (1.57)
10-06-2750-XXXX	0.360 (9.14)	0.255 (6.48)	0.420 (10.67)	0.070 (1.79)
19-06-12962-XXXX	0.410 (10.41)	0.210 (5.33)	0.187 (4.75)	0.070 (1.78)
19-08-L064-XXXX	0.600 (15.24)	0.400 (10.16)	0.350 (8.89)	0.110 (2.79)
19-06-11384-XXXX	0.750 (19.05)	0.625 (15.88)	0.725 (18.42)	0.062 (1.57)

* Replace XXXX with four or five digit material number (1356, 1273, S6305, etc.). Smallest sizes may not be extrudable in certain materials. Refer to page 2.

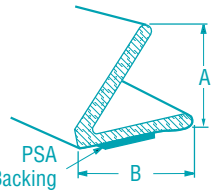

Table 15

V-STRIPS (ADHESIVE INCLUDED)		
Chomerics P/N*	A	B
19-09-10606-XXXX	0.394 (10.01)	0.375 (9.53)
10-09-W864-XXXX	0.410 (10.41)	0.500 (12.70)
19-09-14645-XXXX	0.600 (15.24)	0.500 (12.70)

Note: Please consult the factory for part numbers when ordering punched strips for fastener installation.

* Replace XXXX with four or five digit material number (1356, 1273, S6305, etc.). Smallest sizes may not be extrudable in certain materials. Refer to page 2.

Pressure-Sensitive Adhesive *is available on any extrusion with a minimum 0.125 inch (3.17 mm) mating surface. Contact Chomerics to obtain modified Part Numbers. Refer to pages 2-3 for details.*

(mm dimensions in parentheses)

CHOMERICS

US Headquarters **Tel:** 781-935-4850 **Fax:** 781-933-4318 • *www.chomerics.com*
Europe **Tel:** (44) 1628 404000 **Fax:** (44) 1628 404090

Parker Seals