



BISCO® Silicones



**STOCKWELL
ELASTOMERICS**
MANUFACTURING SOLUTIONS
THROUGH ENGINEERED MATERIALS

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Silicone Material Selection Guide

business card slits



MARKETS

Aircraft

Rail

Automotive

Telecommunications &
Electrical Enclosures

Portable Communications

Exterior Lighting

Medical Devices

Wire, Cable & Fiberoptics

Manufacturing Equipment

APPLICATIONS

Environmental Seals

Outdoor Electrical Gaskets

EMI/RFI Shielding Gaskets

Chip Package & Battery
Cushions

Automotive Heat Shields

HID Lighting Seals

ROGERS' BISCO® SILICONES – PERFORMANCE TO THE EXTREME

Whether your design calls for high performance sealing, cushioning or protection - the BISCO Silicones broad portfolio of material options will provide the best design solution for your application.

Our materials are resistant to temperature extremes, UV and ozone, and are extremely resilient to mechanical fatigue. BISCO Silicone materials exhibit excellent compression set and creep resistance, and carry the most stringent UL flame ratings available.



The world runs better with Rogers.®





WHY CHOOSE BISCO SILICONES?

BISCO Silicones are a full line of cellular, solid and specialty materials produced in roll-stock to be fabricated into gaskets, heat shields, fire stops, seals, cushions and insulation for a wide variety of applications.

BISCO Silicone Materials offer...

- Superior flame resistance
- Low flame, smoke and toxicity upon combustion
- Excellent performance at extreme temperatures
- Superior resistance to compression set and creep

CELLULAR SILICONES

Available in a wide range of firmnesses, BISCO Cellular Silicones are ideal for sealing, cushioning, vibration isolation and insulation.

- Open and closed-cell offerings available
- Withstand temperatures from -55°C up to 200°C (-67°F to 392°F).
- Unsurpassed compression-set resistance for excellent long-term sealing
- Pass stringent smoke and toxicity regulations
- Meets the most stringent UL-94 flame ratings available, V-0 and HF-1

SOLID SILICONES

BISCO Solid Silicone materials are designed for high temperature/high pressure gasketing applications. They are available in a range of thicknesses and durometers, offering flexibility in materials selection. Grades are also available with fiberglass reinforcement for added dimensional stability and increased tear strength.

General Purpose Solids:

- Range of durometers from 40-70 Shore A
- Grades available with fiberglass reinforcement for added dimensional stability and increased tear strength

Performance Solids:

- Range of durometers from 10-40 Shore A
- Tight tolerances and softness, ideal for demanding sealing applications

SPECIALTY SILICONES

BISCO Specialty Silicone products are designed to meet specific industry needs. All of our specialty materials can withstand extreme temperatures and meet stringent industry flame tests.

Materials Include:

- Acoustic barriers
- Patented fire blocking material
- Silicone coated fiberglass cloth
- Silicone foam combined with fabrics

TIPS FOR MATERIAL SELECTION

		Application Need									
	Market	Flame, Smoke, Toxicity	UL Rated Material	Vibration Reduction	Acoustic Performance	Softness	Firmness	EMI Shielding	Moisture Resistant	Heat Shielding	Insulating
	Aerospace										
	Communication Infrastructure										
	Rail										
	Automotive										
	Energy										
	Lighting										
Legend		BISCO Cellular Silicones		BISCO Solid Silicones			BISCO Specialty Silicones				

For specific information regarding applications in additional market areas, please contact the Rogers' Solutions Center at 800.935.2940 or 607.786.8112, or visit us online at www.rogerscorp.com

SPECIALTY SERVICES

Rogers Corporation, High Performance Foams Division, can offer the following value added capabilities to BISCO Silicone material:

ADHESIVE LAMINATION

Pressure Sensitive Adhesive options

- Acrylic one or two sides of material
- Silicone one side only

MATERIAL SLITTING

Ability to slit minimum width of 0.250" (6.35mm)

Width of slit must be greater or equal to thickness

Material can be slit with or without adhesive applied

Maximum roll diameter is 14" (355.6mm)



		Typical Physical Properties						Flammability & Outgassing										Temperature Resistance		Electrical & Thermal							
Property	Density	Compression Force Deflection	Compression Set	Tensile Strength	Elongation	Water Absorption	Flame Resistance					Flame Spread Index (I _s)	Smoke Density (D _g)			Toxic Gas Emissions Rating	Total Mass Loss	Collected Volatile Condensible Materials (CVCM)	Water Vapor Regain	Recommended Constant Use	Low Temperature Embrittlement	Dielectric Constant	Dissipation Factor	Dielectric Strength	Dry Arc Resistance	Volume Resistivity	Thermal Conductivity
Unit	lb/ft³ (kg/m³)	psi (kPa)	%	psi (kPa)	%	%	–					–	–			–	%	–	–	°C (°F)	–	–	–	Volts/mil	Seconds	Ohm-cm	W/m °K
Method	–	ASTM D 1056	ASTM D 1056	ASTM D 412	ASTM D 412	Rogers Internal	UL 94 (File #: E83967)		FMVSS302	FAR 25.853		ASTM E 162	ASTM E 662			SMP-800- C	ASTM E 595	ASTM E 595	ASTM E 595	Rogers Internal	ASTM D 746	ASTM D 150	ASTM D 150	ASTM D 149	ASTM D 495	ASTM D 257	ASTM C 518
Detail	–	@ 25% Deflection	@ 100°C (212°F)	–	–	24 hrs @ Room Temp	V-O	HF-1	Burn Rate (mm/min)	12 sec	60 sec	Flaming Mode	Flaming Mode @ 1.5 min	Flaming Mode @ 4.0 min		@ 1.5/4.0 min	4x10 ⁻⁶ Torr	4x10 ⁻⁶ Torr	4x10 ⁻⁶ Torr	–	-55°C (-67°F)	1 MHz	1 MHz	–	–	–	–
	Ultra-Soft BF-2000	10 (160)	1.5 (10.3)	<5	25 (172)	85	5	Pass	Pass	Pass	Pass	Pass	25	12	45	Pass	3.81	1.14	0.07	200 (392)	Pass	1.28	0.01	52	125	10 ¹⁵	0.05
	Extra-Soft BF-1000	12 (192)	3 (20.7)	<5	35 (241)	90	5	Pass	Pass	Pass	Pass	Pass	35	12	31	Pass	3.46	1.12	0.04	200 (392)	Pass	1.29	0.01	66	124	10 ¹⁵	0.06
	Soft HT-870	15 (240)	4 (27.6)	<5	30 (207)	90	5	Pass	Pass	Pass	Pass	Pass	25	17	50	Pass	1.19	0.34	0.02	200 (392)	Pass	1.38	0.01	65	124	10 ¹⁵	0.07
	Medium HT-800	22 (352)	9 (62.0)	<5	45 (310)	80	5	Pass	Pass	Pass	Pass	Pass	25	5	35	Pass	0.98	0.25	0.03	200 (392)	Pass	1.56	0.01	67	124	10 ¹⁵	0.07
	Firm HT-820	23 (384)	16 (110.3)	<5	50 (345)	55	5	Pass	Pass	Pass	Pass	Pass	35	20	37	Pass	2.11	0.63	0.02	200 (392)	Pass	1.47	0.01	69	125	10 ¹⁵	0.09
	Extra-Firm HT-840	27 (449)	22 (151.7)	<5	60 (414)	60	5	Pass	Pass	Pass	Pass	Pass	NA	NA	NA	NA	2.08	0.57	0.01	200 (392)	Pass	1.62	0.01	69	125	10 ¹⁵	0.10

Gasketing & Sealing Rating	Underwriters Labs - JMLU2 Gasket and Seals / File #MH13898 UL50, UL 50E (continuous / periodic compression), UL508, UL1570, UL1571, UL1572 (135C) and UL157, Oil Immersion	HT-800, HT 820, HT 870
UV Resistance	SAE J1960	All Materials Meet or Exceed
Ozone Effect	ASTM D 1171	All Materials Meet or Exceed



SOLID SILICONES

PERFORMANCE GRADE SILICONES

		Typical Physical Properties					
Property		Hardness	Compression Set	Tensile Strength	Elongation	Tear Strength	Low Temperature Embrittlement
Unit		pts	%	psi (MPa)	%	ppi (kN/m)	–
Method		ASTM D 2240	ASTM D 395 (B)	ASTM D 412	ASTM D 412	ASTM D 624	ASTM D 2137
Detail		Shore A	70 hr @ 150°C (302°F)	–	–	–	-62°C (-80°F)
	10 Durometer HT-6210	10	25-30	250 (1.7)	500	25 (4.4)	Pass / No Cracks
	20 Durometer HT-6220	20	25-30	800 (5.5)	650	55 (9.6)	Pass / No Cracks
	35 Durometer HT-6135	35	<15	800 (5.5)	450	70 (12.3)	Pass / No Cracks
	40 Durometer HT-6240	40	25-30	800 (5.5)	250	75 (13.1)	Pass / No Cracks

GENERAL PURPOSE SOLIDS

		Typical Physical Properties					
Property		Hardness	Compression Set	Tensile Strength	Elongation	Tear Strength	Low Temperature Embrittlement
Unit		pts	%	psi (MPa)	%	ppi (kN/m)	–
Method		ASTM D 2240	ASTM D 395 (B)	ASTM D 412	ASTM D 412	ASTM D 624	ASTM D 2137
Detail		Shore A	70 hr @ 150°C (302°F)	–	–	–	-62°C (-80°F)
	40 Durometer HT-1240	40	20	825 (5.7)	350	50 (8.8)	Pass / No Cracks
	50 Durometer HT-1250	50	20	950 (6.6)	300	70 (12.2)	Pass / No Cracks
	60 Durometer HT-1260	60	20	1050 (7.2)	250	75 (13.1)	Pass / No Cracks
	70 Durometer HT-1270	70	25	1150 (7.9)	200	90 (15.8)	Pass / No Cracks

SPECIALTY SILICONES

THERMAL SOLUTIONS

BISCO FIRE BLOCK MATERIALS: FPC

Flame retardant silicone foams designed to protect sensitive components from damage during fires.

Typical Physical Properties				
Property	Method	Detail	Unit	Value
Density	ASTM F 1315	–	lb/ft³ (kg/m³)	32 (555)
Surface Flammability	ASTM E 162	Flame Spread Index (I _f)	–	5
Smoke Generation	ASTM E 662	Smoke Density (D _s) - Flaming D _s -1.5 minutes	–	12
		Smoke Density (D _s) - Flaming D _s -4 minutes	–	40
Dielectric Breakdown	ASTM E 149-90	–	Volts	1100
Dielectric Strength	ASTM D 149-90	–	Volts/mil	9
Arc Resistance	ASTM D 495-99	–	Seconds	140

BISCO REFLECTIVE FOAM: RF-120

Reflective silicone foam designed to aid in heat management applications by both insulating against heat and reflecting it away.

Typical Physical Properties				
Property	Method	Detail	Unit	Value
Density	ASTM F 1315	Same as BF-1000 (Foam Only)	lb/ft³ (kg/m³)	12 (208)
Aerial Density	Rogers Internal	–	lb/ft²	0.3
Compression Set	ASTM D 1056, Method B	22hrs, 50% Compressed @ 70°C (158°F)	% max	<1
		50% Compressed @ 100°C (212°F)		<5
Surface Flammability	ASTM E 162	Flame Spread Index (I _f)	–	1

BISCO REINFORCED FOAM: IF-200

Abrasion resistant foam that allows users to place the foam in slightly harsher environments while minimizing the potential for tearing the foam.

Typical Physical Properties				
Property	Method	Detail	Unit	Value
Density	ASTM F 1315	Same as BF-1000 (Foam Only)	lb/ft³ (kg/m³)	12 (208)
Aerial Density	Rogers Internal	–	lb/ft²	0.3
Compression Set	ASTM D 1056, Method B	22hrs, 50% Compressed @ 70°C (158°F)	% max	<1
		50% Compressed @ 100°C (212°F)		<5
Surface Flammability	ASTM E 162	Flame Spread Index (I _f)	–	<25

BISCO FR PERFORMANCE SOLID: HT-6360

Formulated to be a solid flame resistant material that meets the strictest flammability ratings.

Typical Physical Properties				
Property	Method	Detail	Unit	Value
Durometer	ASTM D 2240	Shore A	pts	65
Tensile Strength	ASTM D 412	–	psi (MPa)	300 (2.1)
Elongation	ASTM D 412	–	%	175
Surface Flammability	ASTM E 162	Flame Spread Index (I _f)	–	6



SPECIALTY SILICONES

ACOUSTIC SOLUTIONS

BISCO VIBRATION ISOLATOR: L3 PREMIÈRE

BISCO L3 Première silicone foam technology is the *next generation* in dynamic flooring materials. The L3 Première is developed specifically to meet global requirements for flammability, smoke and toxicity while providing superior vibration isolation performance.

Typical Performance Values				
Property	Method	Detail	Unit	Value
Color	–		–	White
Nominal Thickness	–		mm	25
Density	ASTM D 1056		kg/m³ (pcf)	288 (18)
Compression Deflection	ASTM D 1056	Force Load Measured @ 25% Strain	kPa (psi)	120 (17.5)
Compression Set	ASTM D 1056	100°C for 22 hours @ 50% Compression	%	<5
		Flame, Smoke & Toxicity		
French Mass Transit (Rail)	NF F 16-101	25 mm	–	M1 F0

BISCO SOUND BLOCK: HT-200

BISCO Sound Block materials are silicone elastomers designed to reduce the transmission of sound within interior spaces while preventing the spread of fire and smoke.

Typical Performance Values				
Property	Method	Detail	Unit	Value
Flame Spread (I _g)	ASTM E 162	–	–	<5
Smoke Density (D _s)	ASTM E 662	Flaming D _s -4 minutes	–	<75
		Flaming D _s -1.5 minutes		<5
		Non-Flaming D _s		<5
Oxygen Index	ASTM D 2863	–	%	50
Toxic Gas Emissions	SMP-800C	–	–	Pass
Sound Transmission Loss Rating	ASTM E 90	Aerial Density	STC	
		1.5 lb/ft²		29
		1.0 lb/ft²		27
		0.75 lb/ft²		25
		0.50 lb/ft²		22
		0.25 lb/ft²		16

SPECIALTY SILICONES

BISCO EMI SHIELDING MATERIAL EC-2000

BISCO EC-2000 Electrically Conductive Solid Silicones are an ideal EMI/RFI shielding solution when high shielding effectiveness is a must. These soft, conductive materials offer exceptional compression force deflection to increase design flexibility for all types of enclosures.

Typical Performance Values					
Property	Method	Detail	Unit	Value	
				EC-2040	EC-2130
Specific Gravity	Internal	–	g/cc	2.18	1.97
Hardness	ASTM D 2240	Shore A		40	30
Tensile Strength	ASTM D 412	–	psi	90	50
Elongation	ASTM D 412	–	%	60	50
Volume Resistivity	Rogers Internal	–	Ohm-cm	<1	<1
Shielding Effectiveness	MIL G83528	100 MHz	dB	120	100
		500 MHz		120	100
		1 GHz		110	110
		10 GHz		85	85

FIBERGLASS REINFORCED SILICONE HT-1500

Designed for press pad and high strength gasketing applications where durability and tear resistance are critical.

Typical Performance Values				
Property	Method	Detail	Unit	HT-1500
Durometer	ASTM D 2240	Shore A	pts	75
Compression Set	ASTM D 395(B)	70 hr @ 150°C (302°F)	%	25
Breaking Strength	ASTM D 412	–	psi (MPa)	300 (5.3)
Low Temperature Embrittlement	ASTM D 2137	-62°C (-80°F)	–	Pass/No Cracks



BISCO SILICONE TOLERANCES

Cellular Standard Thickness Tolerance										
in	1/32	1/16	3/32	1/8	3/16	1/4	3/8	1/2	3/4	1
	0.031	0.063	0.094	0.125	0.188	0.250	0.375	0.500	0.750	1.000
mm	0.79	1.60	2.39	3.18	4.78	6.35	9.53	12.70	19.05	25.40
BF-2000	–	–	–	+/- 0.025	+/- 0.030	+/- 0.040	+/- 0.060	+/- 0.060	–	–
BF-1000	–	+/- 0.016	+/- 0.020	+/- 0.025	+/- 0.030	+/- 0.040	+/- 0.060	+/- 0.050	+/- 0.090	+/- 0.090
HT-870	–	+/- 0.020	+/- 0.020	+/- 0.025	+/- 0.030	+/- 0.040	+/- 0.045	+/- 0.050	–	–
HT-800	+/- 0.015	+/- 0.020	+/- 0.020	+/- 0.025	+/- 0.025	+/- 0.030	+/- 0.045	+/- 0.050	–	–
HT-820	+/- 0.015	+/- 0.020	+/- 0.020	+/- 0.025	+/- 0.025	+/- 0.030	–	–	–	–
HT-840	–	+/- 0.020	+/- 0.020	+/- 0.025	+/- 0.025	+/- 0.040	–	–	–	–

		Solids Standard Thickness Tolerance				
in		0.010 - 0.014	0.015 - 0.025	0.026 - 0.040	0.041 - 0.094	0.095 - 0.145
mm		0.25 - 0.36	0.38 - 0.64	0.66 - 1.02	1.04 - 2.39	2.41 - 3.68
HT-6210		+/- 0.002	+0.003, -0.002	+/- 0.004	+/- 0.006	+/- 0.008
HT-6220						
HT-6135						
HT-6240						
HT-6360						

		Width Tolerance													
in		0 < T < 3		3 < T < 8		8 < T < 12		12 < T < 18		18 < T < 26		26 < T < 36		T ≥ 36	
mm		0 < T < 76		76 < T < 203		203 < T < 305		305 < T < 457		457 < T < 660		660 < T < 914		T ≥ 914	
		w/o PSA	w/ PSA	w/o PSA	w/ PSA	w/o PSA	w/ PSA	w/o PSA	w/ PSA	w/o PSA	w/ PSA	w/o PSA	w/ PSA	w/o PSA	w/ PSA
Cellular															
Solids		+/- 0.063	+/- 0.031	+/- 0.094	+/- 0.031	+/- 0.125	+/- 0.031	+/- 0.188	+/- 0.031	+/- 0.219	+/- 0.063	+/- 0.250	+/- 0.063	+ 1.0, -0	+ 1.0, -0
Specialty															

BISCO SILICONE SPECIFICATIONS

		Aerospace Global Specifications					
		FAR 25.853	ABS 5006	ABS 5026	BMS 1-68	AMS 3195	DMS-1980
CELLULAR SILICONES	BF-1000	●	–	–	●	–	●
	BF-1005 (A)	●	●	–	●	–	–
	HT-800	●	–	–	–	●	–

SPECIALTY SILICONES	FPC	●	–	●	–	–	–
	HT-6360	●	–	–	–	–	–
	HT-200	●	–	–	–	–	–

		Global Specifications			
		Mass Transit			Automotive
		BS 6853* (Tested to)	NF F 16-101* (Tested to)	NFPA 130* (Tested to)	MS-AY556* (Table 4)
CELLULAR SILICONES	BF-1000	●	●	●	●
	HT-800	●	●	●	●

* Indicated materials have been tested to specific sections of each safety standard. Ask your Customer Service Representative for detailed results.

		General Industry Specifications						
		AMS 3195	AMS 3196	A-A59588	AMS 3320	AMS 3302 - 3305	UL-94**	
							HF-1	V-0
CELLULAR SILICONES	BF-2000	–	–	–	–	–	●	●
	BF-1000	–	–	–	–	–	●	●
	HT-800	●	–	–	–	–	●	●
	HT-820	–	●	–	–	–	●	●
	HT-840***	–	–	–	–	–	●	●
	HT-870	–	–	–	–	–	●	●

SOLID SILICONES	HT-1240	–	–	●	–	–	–	–
	HT-1250	–	–	●	–	●	–	–
	HT-1260	–	–	●	–	●	–	–
	HT-1270	–	–	●	–	●	–	–
	HT-1500***	–	–	–	●	–	–	–

SPECIALTY SILICONES	HT-6360	–	–	–	–	–	●	●
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** Underwriters Laboratories limits the ratings to specific colors and thicknesses. Consult www.ul.com for more details.
*** >0.031 thickness



PRODUCT AVAILABILITY

					Thickness																										
			Color	Width Inch	mm inch	0.25 0.010	0.51 0.020	0.79 0.031	1.60 0.063	2.39 0.094	2.50 0.100	3.18 0.125	4.78 0.188	5.00 0.200	6.35 0.250	9.53 0.375	10.00 0.390	12.70 0.500	15.88 0.625	16.00 0.630	19.05 0.750	25.40 1.000									
CELLULAR SILICONE	Ultra-Soft	BF-2000	Black	36								●	●		●	●		●													
	Extra-Soft	BF-1000	White Gray	36					●	●		●	●		●	●		●	●		●	●		●	●		●	●			
	Soft	HT-870	Black Red	36					●	●		●	●		●	●		●													
	Medium	HT-800	Gray Black Red	36				● not red	●	●		●	●		●	●		●													
	Firm	HT-820	Gray	36				●	●	●		●	●		●																
	Extra Firm	HT-840	Gray	36				▶	●	●		●	●		●																
PERFORMANCE GRADE SILICONE	10 Durometer	HT-6210	Gray	36		○	○	○	○	▶		○																			
	20 Durometer	HT-6220	Black	36		○	○	○	○	▶		○																			
	35 Durometer	HT-6135	Cream	36		○	○	●	●	▶		▶																			
	40 Durometer	HT-6240	Transparent	36		○	○	●	●	▶		●																			
GENERAL PURPOSE SOLIDS	40 Durometer	HT-1240	Red	36			▶	●	●	●		●																			
	50 Durometer	HT-1250	Red	36			▶	●	●	●		●																			
	60 Durometer	HT-1260	Red	36			▶	●	●	●		●																			
	70 Durometer	HT-1270	Red	36			▶	●	●	●		●																			
SPECIALTY SILICONE																															
	Fire Block	FPC	White	36					●	●		●	▶		●																
	Reflective Foam	RF-120	White	36							●	▶	▶	●	▶	▶		▶	▶	▶	▶	▶									
	Reinforced Foam	IF-200	White	36								▶	▶	●	▶	▶		▶	▶	▶	▶	▶									
	FR Performance Solid	HT-6360	Black	36			○	●	●	▶		●																			
	Vibration Isolator	L3 Première	White	*	Available from 4mm – 25mm																										
	EMI Shielding	EC-2040	Dk Gray	36			●	●																							
		EC-2130	Dk Gray	36						●		●																			
	Dimensionally Stable Material	HT-1500	Red	36/39.4				○	●	●		●																			
HT-1510		Gray	36/39.4				○	●	▶		▶																				
Sound Block	HT-200	Black	36	Sold by weight only, not thickness. See below for standard weights. Also available with adhesive (one side only) and/ or fiberglass on one or two sides.																											

*Width varies per thickness

Legend

●

Standard Product

○

Standard Product Not w/Adhesive

▶

Custom Materials

■

Not Available

HT-200 Availability	
Target Wt (lb/ft²)	Thickness (in)
0.25 +/- 0.030	0.025 +/- 0.003
0.50 +/- 0.050	0.050 +/- 0.005
0.75 +/- 0.075	0.075 +/- 0.008
1.00 +/- 0.100	0.100 +/- 0.010
1.50 +/- 0.150	0.150 +/- 0.015



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The Quality Management System at the Carol Stream facility is Registered to ISO 9001: 2008 and AS9100, Rev. B by the Underwriters Laboratories (File # A-5857).

www.rogerscorp.com



STOCKWELL ELASTOMERICS

MANUFACTURING SOLUTIONS
THROUGH ENGINEERED MATERIALS



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The information contained in this Material Selection Guide is intended to assist you in designing with Rogers' BISCO Silicones. It is not intended to and does not create any warranties, express or implied, including any warranty of merchantability or fitness for a particular purpose or that the results shown in this Material Selection Guide will be achieved by a user for a particular purpose. The user should determine the suitability of Rogers' BISCO Silicones for each application.