

# ECCOSORB<sup>®</sup> MF500F

HIGH TEMPERATURE, MAGNETICALLY LOADED, MACHINABLE STOCK

## Description :

Eccosorb MF500F is a rigid, completely solid, magnetically loaded, high temperature absorber.

Physical and electrical properties are the same as those of the corresponding member of the Eccosorb MF series. See data sheet EB-200.

Eccosorb MF500F can be used for short periods at 260°C permitting use at high ambient and/or high power levels.

Exposure to high temperatures should be limited, slow changes in physical and electrical properties occur at temperatures above about 175°C.

## Application :

Eccosorb MF500F is widely used as absorbers, attenuators, and terminations in waveguides and coaxial lines.

It has also been successfully used as a high-Q inductor-core material in such devices as slug tuners. It is also useful in many other magnetic components.

## Availability :

Eccosorb MF500F is available in six standard loadings. In general, as the frequency of operation increases, the MF500 loading series decreases.

MF500F-110	MF500F-116
MF500F-112	MF500F-117
MF500F-114	MF500F-124

Standard stock sizes are available in the following:

Sheets 12" x 12" (30.5 cm x 30.5 cm) in thicknesses of 1/8, 1/4, 3/8, 1/2, 5/8, 3/4, 1.0, 1.5, 2.0, 2.5 & 3.0" (0.32, 0.64, 0.95, 1.27, 1.59, 1.91, 2.54, 3.81, 5.08, 6.35, 7.62 cm).

Rods 12" long (30.5 cm) in diameters of 1/8, 1/4, 3/8, 1/2, 5/8, 3/4, 1.0, 1.5, 2.0, 2.5 & 3.0" (0.32, 0.64, 0.95, 1.27, 1.59, 1.91, 2.54, 3.81, 5.08, 6.35, 7.62 cm).

Bars 12" long (30.5 cm) in squares of 1/4, 3/8, 1/2, 5/8, 3/4, 1.0, 1.5 & 2.0" (0.64, 0.95, 1.27, 1.59, 1.91, 2.54, 3.81, 5.08 cm).

Other sizes, shapes, thicknesses, and configurations are available on special order.

## Instructions for use :

Exposure to high temperatures should be limited.

For properties and design considerations, see the Eccosorb MF technical bulletin.

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## Machining Recommendations :

Most of the discussion below applies not only to the basic Eccosorb MF series of materials, but also to several high temperatures, castable and molding-powder equivalents. Eccosorb MF can be formed readily to close tolerances with standard metal-working machine tools, i.e.: lathes, milling machines, drills, saws, grinders, generally using conventional techniques but observing the precautions and limitations described below.

### Tooling :

For turning, milling, drilling and tapping, carbide tools should be used, for example Type 883, a general purpose carbide that works well under most conditions. Use solid carbide taps for long life. Standard size tap drills should be satisfactory. External threads are formed best, not with conventional thread-cutting dies but by lathe turning or grinding, with light feeds and shallow cuts.

Sawing can be done with best finish and tolerance using circular saws, 20.3 to 25.4 cm diameter, with grinding coolant and high RPM.

Thin carborandum wheels, 0,079 cm thick or carbide saws may be used where requirements are less stringent. Best results are attained by moving the saw and keeping work stationary, with saw rotating so it tends to climb into the work. Surface finishing of flat sheets, etc. is best performed with a Blanchard grinder. Eccosorb MF is held readily with magnetic chucks. Sheet size is limited by the size of the machine.

### Coolants :

Use of a coolant liquid is recommended, especially for all close tolerance operations. Commercial grinding fluid is preferred, or water-soluble oil, with rust-resisting properties to protect the machines. Spark producing operations in particular must not be run dry, since smoldering fires might result. Where coolant run-off is collected for recirculation, a two-cavity recovery system should be used to minimize pick-up of grinding dust, sawdust or chips by the coolant pump. Where a re-circulating system is not available, best results will be obtained with air-powered spray or mist equipment. Use of tapped metal inserts should be considered where electrical performance will not be degraded. Inserts may be cast in place, or bonded with castable material of suitable composition.

## Suggested Speeds and Feed Rates

The following speeds and feed rates are suggested to be modified as necessary to suit job conditions:

OPERATION	SPEED	FEED
Sawing, turning	(21.3 - 27.4 m)/min	0.13 - 0.20 mm
External threading	(21.3 - 27.4 m)/min	0.038 mm/pass
Tapping	450 rpm	Tapping Head
Milling	(21.3 - 27.4 m)/min.	0.038 - 0.076 mm/tooth



**Safety Considerations:** It is recommended to consult the EMERSON & CUMING MICROWAVE PRODUCTS product literature, including material safety data sheets, prior to use EMERSON & CUMING MICROWAVE PRODUCTS products. These may be obtained from your local sales office.

**WARRANTY:** Values shown are based on testing of laboratory test specimens and represent data that falls within the normal range of properties of the material. These values are not intended for use in establishing maximum, minimum or ranges of values for specification purposes. Any determination of the suitability of the material or any use contemplated by the user and the manner of such use is the sole responsibility of the user who must assure that the material as subsequently processed meets the needs of this particular product or use. We hope the information given here will be helpful. It is based on data and knowledge considered to be true and accurate and is offered for the user's consideration, investigation and verification but we do not warrant the results to be obtained. Please read all statements, recommendations or suggestions in conjunction with our conditions of sale INCLUDING THOSE LIMITING WARRANTIES AND REMEDIES which apply to all goods supplied by us. We assume no responsibility for the use of these statements, recommendations or suggestions nor do we intend them as a recommendation for any use which would infringe any patent or copyright.

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