



## **NATIONAL MRI SHIELDING SPECIFICATIONS-COPPER SOLDERED ENCLOSURE**

### **SECTION 13095 RADIO FREQUENCY SHIELDING FOR MRI SOLDERED COPPER ENCLOSURE**

#### **PART 1 - GENERAL**

##### **1.1 DESCRIPTION**

The purpose of RF and magnetic shield construction is to create an enclosure in which radio frequency (RF) and/or electromagnetic interference (EMI) is contained and/or prevented from entering. This environment is necessary to ensure proper performance of Magnetic Resonance Imaging (MRI) equipment.

##### **1.2 WORK INCLUDED**

This section includes furnishing all labor, materials, equipment, tools, and related items to engineer, pre-fabricate, deliver, install and test an RF & Magnetic shield for an MRI scan room.

##### **1.3 WORK NOT INCLUDED**

The following work is excluded, but shall be coordinated with the Shield Vendor:

- A. Construction or preparation of the parent structure to receive the shield assembly.
- B. Weatherproofing and climate control of the parent structure prior to the installation of the shield assembly.
- C. Calculations and specifications for thickness, location, and composition of magnetic shielding.
- D. Connections of other work to the RF shield.
- E. Delivery and installation of the MRI equipment.
- F. Any final finishes including but not limited to HVAC ducting, electrical wiring, drywall, paint, VCT, etc.

##### **1.4 RELATED SECTIONS**

- A. Section 087100 - Door Hardware
- B. Section 088000 - Glazing
- C. Section 092116 - Gypsum Board Systems
- D. Section 096500 - Resilient Flooring
- E. Section 099000 - Painting
- F. Section 224100 - Plumbing Piping
- G. Section 235050 - Air Conditioning Ductwork
- F. Section 260533 – Conduit and Tubing

##### **1.5 REFERENCES**

- A. Comply with applicable requirements of the following standards and those others referenced in this Section.
  - 1) American Welding Society
    - a. AWS D1.1, Structural Welding Code - Steel
  - 2) Military Standard



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- a. MIL-STD-220A, Method of Insertion Loss for Radio Frequency Filters.
- b. MIL-STD-285, Method of Attenuation Measurements for Electromagnetic
- 3) Shielding Enclosures for Electronic Test Purposes.
- 4) Underwriters Laboratories Inc.
  - a. UL-1283, Standard for Safety - Electromagnetic Interference Filters.
- 5) American Standard for Testing and Materials
  - a. ASTM F1869, Standard Test Method for Measuring Moisture Vapor Emission
- 6) Rate of Concrete Subfloor Using Anhydrous Calcium Chloride.

### **1.6 PERFORMANCE REQUIREMENTS**

- A. ATTENUATION: The shield must meet the following performance criteria according to specifications supplied by the MRI equipment manufacturer:
  - 1) Attenuation of magnetic field.
  - 2) Attenuation of electric field.
  - 3) Attenuation of plane wave.
  - 4) Attenuation of sound.
- B. GROUND: The shield structure must be electrically grounded at a single point, with a minimum resistance to alternate ground of 1,000 ohms.

### **1.7 SUBMITTALS**

- A. PROCEDURE: Submit under provisions of Section 013300.
- B. PRODUCT DATA: Include manufacturer's complete information on system, including system specifications and maintenance procedures.
- C. SHOP DRAWINGS: Show full layout of system, including all dimensions and required points of coordination with work of other sections. Demonstrate full compliance with contract documents. Shield Vendor's shop drawings will be approved in writing by the General Contractor, or other appropriate responsible party prior to fabrication of the RF shield.

### **1.8 QUALITY ASSURANCE**

- A. STANDARDS: Perform work of this section in accordance with provisions of the following:
  - 1) MIL-STD-285.
  - 2) MIL-STD-220A.
- B. QUALIFICATIONS: Shield Vendor shall have been engaged in continuous business for at least five (5) years in manufacturing and installation of RF and magnetic shielding.
- C. WARRANTIES



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- 1) **SPECIFIC:** Shield Vendor will supply a signed written warranty stating that the RF shield enclosure is guaranteed as follows:  
As long as it is maintained according to industry standards and written maintenance procedures, the structure is guaranteed against defective materials and workmanship and to retain the specified shielding characteristics for a period of five (5) years from date of completion of acceptance test. The electrical RF filters, waveguides, and door system are guaranteed against defective materials and workmanship and to retain the specified shielding characteristics for a period of one (1) year from date of completion of acceptance test.
- 2) **GENERAL:** The warranties specified in this article shall not deprive the Owner of other rights the Owner may have under other provisions of the contract documents and shall be in addition to, and run concurrent with, other warranties made by the Shield Vendor under requirements of the contract documents.

### **PART 2 - PRODUCTS**

#### **2.1 MANUFACTURERS**

- A. This section is based on products manufactured by:  
National MRI Shielding, Inc.  
201 Brothers Blvd Ste 5  
Red Oak, TX 75154  
(214) 614-8103  
[www.mri-shielding.com](http://www.mri-shielding.com)
- B. Alternative products (substitutions): Contractor must furnish appropriate and complete product data, environmental characteristics, and sample warranty with bid for the Architect to consider the substitutions as "equal" to the manufacturer, product specified and quality assurance requirements. Further additional information may be requested by the Architect for determination that the proposed product substitution is fully equal to the specified products. There is no guarantee that proposed substitutions will be approved, and the Contractor is hereby directed not to order any materials until said approval(s) are received in writing.
  - 1) Requesting substitutions is at the Contractor's own risk, with regard to uncompensated delays of the Project. Time is required for sufficient review and for additional requests of information. Delays of work which result from substitution reviews and resubmissions are not grounds for additional time or cost change orders, and will not be considered by the Owner.

#### **2.2 MATERIALS AND COMPONENTS**



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A. **MAGNETIC SHIELDING:** For shield installations where attenuation of the MRI magnetic field is required, magnetic shielding (typically M36 silicon steel) will be installed according to precise specifications as to thickness, location, and type of material. These specifications are to be supplied by others (typically the MRI equipment vendor) to the Shield Vendor prior to shield fabrication.

B. **COPPER SHEET:** RF Shielding Floor; weight of 3 ounce, RF Shielding Wall and ceiling; weight of 3 ounce minimum, new and in a clean condition.

- 1) Solder and flux only, required for proper joining of the copper sheets at all joints and seams.
- 2) Non-ferrous fasteners as required to attach copper sheets to support members.

### **C. FLOOR**

#### **1) UNDERLAYMENT:**

##### **a. VAPOR RETARDANT:**

- i. Install epoxy based moisture barrier over slab.
- ii. Install one layer of StormGuard® Film-Surfaced Leak Barrier.

b. **SUPPORT MATERIAL:** Self-leveling mortar underlayment of minimum 4200 PSI.

c. **MAGNET SUPPORTS / ANCHORS:** Shall be installed according to Equipment Vendor's specifications.

d. **WIRING TRENCHES / RACEWAYS:** Shall be lined with formed 12 ounce copper and made electrically contiguous with the floor copper sheet.

D. **CEILING:** Shall consist of  $\frac{3}{4}$ " plywood by others with laminated 3 ounce minimum copper sheets. All joints and seams shall be soldered.

- 1) **CEILING SUPPORTS:** a wood 2 x 4 frame structure to be erected by others prior to the start of the RF shield installation.
- 2) **ATTACHMENT POINTS:** Attachment points for interior finish shall be installed by the Shield Vendor for support of other work and materials to be installed by others. Load, location and quantity of attachment points shall be specified prior to shield fabrication.

E. **WALLS:** Shall consist of minimum  $\frac{1}{2}$ " gypsum by others with 3 ounce minimum copper sheet with all joints and seams soldered.

- 1) **WALL SUPPORTS:** a wood 2 x 4 frame structure to be erected by others prior to the start of the RF shield installation.
- 2) **PENETRATION PANEL:** The penetration panel opening location will be field verified. An opening will be cut thru the copper and gypsum walls. The opening will be



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framed with copper wrapped wood 2 x 4 to accept the MRI vendor's supplied penetration panel at the time of magnet delivery.

- 3) **GROUNDING BUSS BAR:** 1/2" diameter solid brass threaded rod with a solid brass attachment bar shall be mounted through the RF shielding adjacent to the power line filters. This structure shall serve as a single point grounding point for the RF shield. Intended for subsequent attachment of a dedicated wire to the electrical ground point of the building under Section 262100, it shall be external as well as internal to the RF shield, electrically contiguous with the shield, and shall be the sole attachment point for the "green wire" system (by others) within the shield.
- 4) **MAGNET DELIVERY ACCESS PANEL:** A removable section will be provided in the shield to allow entry or exit of the MRI magnet. The location shall be specified prior to shield fabrication.

F. **DOOR ASSEMBLY: RF SHIELDED DOOR:** The door and frame assembly shall provide RF integrity while presenting the overall appearance of a conventional medical facility door. Door and frame assembly will be fit and hung at the factory. RF attenuation shall be accomplished by means of a continuous RF door seal around the entire perimeter of the door.

- 1) **DOOR FRAME:** Shall consist of stainless steel plated wood.
- 2) **DOOR LEAF:** To consist of a solid core, laminated with 3 ounce copper. 4'-0" x 7'-0" shall be considered the standard size.
- 3) **DOOR HINGES:** The door assembly shall be factory mounted with one continuous piano style hinge running the entire length of the door.
- 4) **THRESHOLD:** Shall consist of a stainless steel tapered ramp directly fastened to the jambs. This will serve as an integral mating part of the seal assembly affixed to bottom of the door. Threshold is to be made electrically contiguous with the door frame.
- 5) **DOOR LATCHING DEVICE:** Shall consist of a T series extra heavy duty grade 1 cylindrical lever lock.
- 6) **RF DOOR SEALS:** Conventional copper/beryllium "finger stock" material shall not be used. The RF door seal shall consist of high performance RF gasket material providing 100db shielding attenuation.
- 7) **DOOR FINISH:** Wilsonart Laminate or standard unfinished paint-grade white birch shall be applied to both sides. Anodized aluminum trim shall be applied to both sides.

G. **RF WINDOWS:** To consist of two (2) internal layers of 304 stainless steel screen material, mounted in a hardwood frame in such a way as to become electrically contiguous with the shield, and painted flat black to minimize reflection. The two layers of screen material must be laid at opposing angles totaling 30° in order to minimize the optical effect known as "moiré". The window frames shall conform to the attachment system described above.



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- 1) INTERIOR: (Control Room Window) shall be glazed with 1/4" tempered glass on both sides. 3'-0" x 4'-0" Shall be considered standard size.
- 2) EXTERIOR: (View Window) View windows are typically located to match exterior windows on the parent structure. View windows shall be glazed with 1/4" tempered glass on one side only
- 3) SKYLIGHT: Skylight RF windows are typically located to match exterior skylights of the parent structure. Skylight RF windows shall not require glass, and consist of window framing and screen only. Because the RF shielded skylight assembly does not have glass applied, the space above the assembly will be open to the conditioned space below the assembly, therefore the walls of the skylight assembly should be sealed by others to prevent dust and debris from falling on the RF screen.
- 4) Large RF windows may require mullions.

### **H. PENETRATIONS**

- 1) HVAC WAVEGUIDES: Shall provide RF attenuation while allowing air- flow penetration through the shield, typically for HVAC supply, HVAC return, exhaust, and passive pressure equalization. Waveguides shall consist of 3/16" x 1" aluminum honeycomb vents with integral collars for mounting and attachment to the RF shield. Wave grilles will include attachment points for dielectric connection by others outside the RF shield and an attachment point for conventional connection on the inside. The sizes and quantity of wave grilles are to be specified by others prior to shield fabrication.
- 2) PIPE WAVEGUIDES: Shall provide RF attenuation for medical gases, cryogen vents, vacuum, fire sprinkler and other pipe penetrations through the shield. Pipe waveguides are to be compliant with MRI vendor's requirements, mounted by the Shield Vendor so as to be electrically contiguous with the shield, and materially, structurally, and mechanically compatible with connections by others. Connections of other work to waveguides are made by others and must be dielectric on the outside of shield unless otherwise noted.
- 3) ELECTRICAL FILTERS: Shield vendor shall provide electrical filters for RF attenuation of all power circuits and data circuits within shielding. Electrical filters shall be certified in accordance with UL-1283, and shall provide a rating satisfactory for the specific application. Filters provided will attenuate RF energy on the incoming conductor at 100db from 150 kHz to 10 GHz. Electrical filters will be mounted by the Shield Vendor in the area of the magnet penetration panel.



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- 4) OTHER PENETRATIONS: Shield vendor shall be notified of all other penetrations to the shield prior to fabrication. Under no circumstances is the RF shield to be penetrated without prior consent of the Shield Vendor.
- I. FINISHES: Installation of finishes is specified in the RELATED SECTIONS Article of section 1.4, and is to be performed by others.
- J. THIRD PARTY COMPONENTS: Any third party components requiring installation by the Shield Vendor, including MRI equipment vendor's penetration panel and/or floor supports, shall be made available in accordance with the Shield Vendor's installation schedule.

### **PART 3 - EXECUTION**

#### **3.1 DESIGN**

- A. ARCHITECTURAL DRAWINGS shall be supplied to the Shield Vendor as complete, accurate and approved for construction in order to ensure accurate preparation of Shield Vendor's shop drawings.
- B. MRI EQUIPMENT VENDOR'S DRAWINGS shall be supplied complete and approved to the Shield Vendor before fabrication. Shield vendor will combine information contained therein with the architectural data in order to provide a comprehensive set of shop drawings. In cases where a discrepancy exists between Architectural and MRI Equipment Vendor's drawings, Shield Vendor shall notify both parties, along with the General Contractor, and any other appropriate responsible party and proceed as directed.
- C. FIELD MEASUREMENTS: Shield vendor may elect, at its discretion, to gather field measurements as necessary to complete timely and accurate shop drawings. In cases where a discrepancy exists between written and actual dimensions, Shield Vendor shall notify the parties involved and proceed as directed.
- D. SHOP DRAWINGS: Shield Vendor shall use its best efforts to gather information and provide timely and accurate shop drawings prior to fabrication. Shop drawings will be approved in writing before fabrication takes place. Approval of shop drawings shall constitute 25% completion of the project.

#### **3.2 FABRICATION**

- A. Shield Vendor shall use its best means and methods to substantially pre-fabricate all necessary components for the shield, based upon the approved shop drawings.
- B. All raw materials and components used in the manufacturing process will be new, unused material and will conform to local and NEC codes.
- C. Shield Vendor shall use established means and methods for quality control assurance during the fabrication process.

#### **3.3 EXAMINATION**

- A. Verify that substrates are ready to receive work of this section and openings correspond to locations and dimensions indicated on approved shop drawings.



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1. Verify that floors are level to within 1/8 inch in 10 feet.
  2. Verify that required utilities are available.
  - B. Do not begin work of this section until unacceptable conditions have been corrected.
  - C. SITE CONDITIONS: General Contractor shall examine the areas and conditions under which the RF shielded enclosure is to be installed and notify the Shield Vendor of conditions detrimental to the proper and timely completion of work. Work shall not proceed until unsatisfactory conditions have been corrected.
  - D. DIMENSIONS: Upon arrival for installation, Shield Vendor shall verify that the job site is ready to receive work of this section and openings correspond to locations and dimensions indicated on approved shop drawings.
- 3.4 INSTALLATION
- A. JOB SITE READINESS: The following conditions are necessary to have the status of a "Ready Site". The General Contractor shall verify these conditions before the Shield Vendor arrives at the job site to begin installation:
    1. WORK AREA
      - a. There is a designated area adjacent to the MRI exam room for staging of the RF shield components and materials.
      - b. There is a clean, clear, pathway for wheeled transport of materials and equipment from the delivery truck to the staging area.
      - c. The MRI exam room and staging area is free of other work, workmen, clutter, and/or debris and the floor has been broom swept.
      - d. The MRI exam room and staging area is weatherproofed, dry (non-condensing), and temperature controlled between 60°F & 90°F.
      - e. The General Contractor will provide a secure area for storage of Shield Vendor's tools and equipment.
      - f. The General Contractor will provide proper work lighting in the area where the RF shield will be installed.
      - g. The General Contractor will provide two (2) 120 VAC, 20 AMP service connections at the installation location. These services must be grounded and comply with any and all applicable local and N.E.C. codes.
      - h. The General Contractor will provide containers for the disposal of refuse materials from the RF shield installation site. The General Contractor shall be responsible for the removal of the containers after completion.
  - B. PARENT STRUCTURE
    - 1) CONCRETE SLAB
      - a. DEPRESSION: If level, non-ramped, threshold-to-floor junction is required, the slab within the shield footprint will be provided to the





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- b. Shield Vendor as a depressed section measuring (a) 1" below the surrounding slab for an inward-opening or an outward-opening door. These measurements assume a finished floor thickness of 1/8". In addition to these measurements, the slab depression may need to increase to allow for any specified floor magnetic shielding.
- c. LEVELING: Slab is to be made level by others to within 1/8" in 10 feet with maximum difference of 1/4" between the highest and lowest point across the entire footprint of the shield.
- d. CURING: Slab shall be cured to less than or equal to 3 lbs moisture vapor transmission per 1000 sq. ft. per 24 hours prior to installation (per ASTM F1869).
- e. POSITIONING: The intended location of the MRI isocenter shall be established and marked on the slab by others prior to installation of the RF shield.

C. OVERHEAD SUPPORT. The RF shield ceiling is typically supported by the parent room construction. The RF shield ceiling system load is approximately 3 pounds per square foot (plywood and copper). This weight does not include any magnetic shielding or interior structures, such as lights, duct work, wiring, plumbing, suspended ceilings or other construction. It is the responsibility of the Customer (or other appropriate responsible party) to ensure that the parent room overhead construction will adequately support the RF shield ceiling system and any other additional weight.

D. ELECTRICAL ISOLATION. To ensure against grounding of the RF shield, all external RF shield surfaces must have no electrical contact with existing building construction. Therefore, all metallic surfaces such as conduit, duct work, metal framing studs & piping that may contact the RF shield must be (electrically) isolated or removed.

E. ASSEMBLY

- 1) Assemble all components of the RF and magnetic shielding system in strict conformance with Shield Vendor's methods, MRI equipment vendor's specifications and under direct supervision of a factory representative.
  - a. Install all materials to be straight, level, true, and plumb.
  - b. Verify integrity of RF shielding before covering shield material with other finish materials.
  - c. Coordinate locations of penetrations with installation of RF shielding and approved shop drawings.
  - d. Upon completion of the assembly, Shielding Vendor shall dispose of all debris, trash, containers, residue, remnants and scraps which result from the work of this section. Refuse container shall be supplied by General Contractor.



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### **F. COPPER SHEET SYSTEM:**

- 1) Install vapor retarder over floor construction.
- 2) Floor Underlayment: Install one layer of StormGuard® Film-Surfaced Leak Barrier.
- 3) Copper Sheet: Join all seams and joints with solder and flux only.
- 4) Magnet Access Removable Panels: Build where indicated on drawings.

G. WAVE GUIDES: Attach securely to RF shielded enclosure with frames or attachment collars as detailed.

H. Mechanical Sleeves: Attach securely to RF shielding with dielectrics, as required to allow penetration of shield without degradation of RF shield attenuation characteristics.

I. FILTERS: Attach securely to RF shielding at all power line and communication wire penetrations, as required to prevent degradation of RF shield attenuation characteristics.

J. GROUND BUSS BAR: Install a ground stud on the RF shield adjacent to power Line filters inside the shield, as shown on shop drawings, for subsequent Attachment of a dedicated wire to the electrical ground point of the building under Section 262100.

K. FINISHES: Installation of room finishes is specified in sections referenced in RELATED SECTIONS Article 1.4, and is to be performed by others.

### **3.5 FIELD QUALITY CONTROL**

A. Shield Vendor shall exercise care in handling and protecting materials and finishes during fabrication, shipment, erection and finishing, as necessary to prevent damage to finished surfaces and shielding linings.

B. Shield Vendor shall field-verify specs and dimensions of all components during installation of RF shielding. If non-critical discrepancies exist, he will notate the approved shop drawings and make field corrections if possible. As built drawings will be provided after completion of the project.

C. Shield Vendor shall coordinate with other trades on site to ensure compliance with schedules, proper progression of work, and proper connections of other work to shield.

D. Upon completion of the RF shield enclosure installation, it shall become the responsibility of the Owner, General Contractor, or other responsible party to maintain the integrity of the RF enclosure. In addition to the testing procedures outlined below in section 3.5.E.1 – 2, this responsibility shall also include:

- 1) Ensure that the parent room and the RF shielded enclosure remain free of moisture.
- 2) Prevent unauthorized attachments, penetrations, or connections to the RF shielded enclosure.

### **E. TESTING**



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### **1) GROUND ISOLATION TESTING**

- a. During installation, the Shield Vendor shall test the enclosure daily for electrical isolation from ground by a minimum of 1,000 OHMS. Upon completion of the shield assembly, the Shield Vendor will confirm that the RF shield remains isolated from electrical ground.
- b. After installation of the shield, but before MRI equipment delivery, the General Contractor, or other appropriate responsible party will assume responsibility that the RF shield remains isolated from electrical ground. The General Contractor or other appropriate responsible party on site will confirm ground isolation at least four (4) times daily. If a ground condition should be created by others during this period, they will be notified to immediately take measures to correct the situation. If ground condition persists after corrective measures, the General Contractor shall promptly notify the Shield Vendor so that appropriate action may be taken to correct the situation.
- c. Prior to his departure, Shield Vendor shall provide a battery operated audible ground alarm system as a convenience to others. During Shield Vendor's absence, the monitoring and maintenance of the alarm shall be the responsibility of the General Contractor, or other appropriate responsible party on site.

### **2) ATTENUATION TESTING**

- a. Upon completion of the shield assembly, and prior to the application of finishes, the Shield Vendor shall seal the delivery access point and test the enclosure in accordance with MIL-STD 285, MIL-STD-220-A, and MRI equipment vendor requirements for magnetic field, and/or electric field, and/or plane wave attenuation. This test shall be witnessed by the General Contractor, or other appropriate responsible party. If shield fails to conform to specifications, Shield Vendor shall immediately make such modifications as necessary to the shield to correct any non-compliance, and shall then re-test. Upon completion of a successful test, the Shield Vendor will then remove the magnet access panel and store it on-site in a designated area until the time of magnet delivery.
- b. Upon delivery of the MRI equipment, the Shield Vendor shall return to the site to seal the delivery access point and test the enclosure in accordance with MIL-STD-285, MIL-STD-220-A, and MRI equipment vendor requirements for magnetic field, and/or electric field, and/or plane wave attenuation. This final testing shall be performed in the presence of the General Contractor, or other appropriate responsible parties, to verify compliance with specified attenuation versus frequency characteristics.



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F. COMPLETION: Upon completion of successful final testing, the Shield Vendor shall provide the following:

- 1) A formal report detailing the test results and certifying the shield for its intended use.
- 2) A written warranty document as specified.
- 3) As-built drawings.
- 4) Instructions for care and maintenance of shield.

**END OF SECTION**