

# Rugged Cabinets for Harsh Environments

## Part 4: Thermal Management, Case Studies, and Strategic Considerations

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Harsh environments don't just challenge a cabinet's structure – they also test its ability to keep electronics cool and operational. As electronic systems grow more powerful and compact, thermal management has become a critical pillar of rugged cabinet design. This final part addresses cooling solutions for sealed enclosures, then presents several case studies illustrating how the previously discussed principles (standards, materials, EMI, thermal) come together in real-world applications. We conclude with strategic considerations for engineers and program managers when specifying cabinets for harsh environments.

### Contents

|  |    |
|--|----|
| Part 4: Thermal Management, Case Studies, and Strategic Considerations ..... | 1  |
| Thermal Management and Cooling Solutions .....                               | 2  |
| Active vs. Passive Cooling.....  | 2  |
| Closed-Loop Cooling .....  | 2  |
| Conduction and Liquid Cooling .....  | 3  |
| Thermal Simulation & Resilience.....   | 3  |
| Application Case Studies: Lessons from the Field .....                       | 4  |
| Missile Defense Systems .....  | 4  |
| Naval Combat Systems.....  | 5  |
| Surveillance & Telemetry Stations .....                                      | 6  |
| Nuclear Energy & Industrial Control .....                                    | 6  |
| Heavy Industrial & Mobile Equipment .....                                    | 7  |
| Strategic Takeaways and Conclusion .....                                     | 7  |
| Engage Early with Experts .....  | 7  |
| Balance COTS and Custom .....  | 8  |
| Think Future and Lifecycle.....  | 8  |
| Certification and Testing .....  | 8  |
| Human Factors.....   | 8  |
| In Conclusion.....   | 9  |
| References .....   | 10 |



Figure 1: Combined Cycle Power Plant. Steam Turbine Modern Clean Power generator building. Large electricity industry.

# Thermal Management and Cooling Solutions

Excessive heat is the enemy of electronic reliability – it can cause erratic behavior or premature failures. In harsh deployments, the thermal challenge is twofold: the electronics generate more heat (due to high-density boards and fast processors), and the ambient conditions are often unfavorable (e.g. high external temperatures, direct sun, or no HVAC infrastructure). Therefore, selecting a cabinet is no longer just about making a sturdy box; it's about providing an integrated cooling solution that will keep internal temperatures in safe limits under all operating conditions.

Key considerations and approaches include:

## Active vs. Passive Cooling

The simplest enclosure cooling is passive – relying on the cabinet's own metal surfaces to dissipate heat (sometimes aided by internal conduction paths or heatsinks). Passive cooling is maintenance-free and can work for low-power electronics or when there is lots of thermal headroom. However, most modern high-density systems require active cooling: moving air via fans or blowers through the cabinet or across the electronics. The majority of 19-inch rugged racks use forced-air cooling – for example, high-reliability fans drawing cool air in through filtered intakes and expelling hot air out the top or rear. Filters are crucial in dusty/sandy environments to prevent clogging electronics with debris. These filters must be easily replaceable during maintenance. When using fans, designers also consider noise (for cabinets in manned areas) and ensure EMI integrity (using shielded fan housings or EMI gaskets around fan modules). Active cooling adds complexity (power for fans, moving parts that can fail), so redundancy is often included – e.g., multiple fans so that if one fails, others can carry on.

## Closed-Loop Cooling (Air Conditioners)

In some scenarios, fans blowing ambient air aren't sufficient – especially if the outside air is hot, humid, or full of contaminants, or if the electronics are extremely heat-sensitive. For those cases, closed-loop cooling is implemented via sealed air-conditioning or heat exchanger units. A common solution is a side-mounted vapor-compression air conditioner on the cabinet, similar to a small HVAC unit, which actively cools and dehumidifies the internal air without exchanging air with the outside (thus preserving NEMA/IP weatherproof sealing). Another approach is an air-to-air heat exchanger (which might use thermoelectric coolers or heat pipes) that pumps heat from the interior to the exterior through a heat exchange core, again without outside air ingress. These rugged AC/heat exchanger units are designed

to operate under shock and vibration and often include electric heaters as well for extreme cold starts. If a deployment anticipates high heat loads in hot climates (e.g. a desert communication node shelter), program managers should consider cabinets that offer integrated environmental control units (ECUs) or proven attachment points for AC modules. Having a built-in or plug-on HVAC solution can be vital for maintaining safe temperatures when ambient conditions exceed electronics' limits.

## Conduction and Liquid Cooling

At the cutting edge of thermal management, some rugged systems use conduction cooling at the chassis or board level, and even liquid cooling for extreme power densities. In conduction-cooled designs, heat is carried from components to the enclosure walls or cold plates by solid conduits; in liquid-cooled designs, a fluid (often a water/glycol mix or dielectric fluid) circulates through a heat exchanger to remove heat. These methods are increasingly seen in high-power radar, electronic warfare, and computing cabinets (for example, to cool hot FPGA/ASIC modules or GaN RF amplifiers). In fact, military thermal experts note that conduction cooling, forced air, and liquid cooling are the three avenues currently used in combination to cool advanced electronics. With the rise of very hot processors and dense RF systems, many foresee that liquid cooling will become necessary in applications where air alone used to suffice. Already, some rugged cabinet suppliers offer compact liquid-to-air heat exchanger units (mountable within a rack) capable of removing on the order of 5-10 kW of heat. Even larger standalone liquid chiller systems exist for deployable electronics, with capacities of 8-24 kW for the most power-hungry radar and supercomputer installations<sup>1</sup>-act.com. The key for cabinet designers is to accommodate the needed cooling method: providing extra depth or space for airflow channels, structural support for a pump or radiator, and the flexibility to integrate different cooling modules as needed. Optima, for example, often designs “families” of cabinets where one variant has only fan cooling (for a transit-case deployment) while another variant of the same base frame includes a liquid cooling loop for a shipboard high-power radar – all leveraging the same core frame and panel designs.

## Thermal Simulation & Resilience

Modern CAD tools allow enclosure designers to simulate airflow and temperature distribution within a fully populated cabinet. When evaluating a cabinet (especially for high-density payloads), it's wise to ask if thermal analysis has been performed or if the vendor provides guidelines on equipment placement. Good designs might include internal baffles or air ducts to guide cooling air to where it's most needed, high-capacity fan trays, and temperature sensors or smart fan controllers to respond to changing conditions. It's also important that cooling solutions are specified for environmental extremes – for instance, arctic-grade fan lubricants so they don't seize up in extreme cold, or the inclusion of internal heaters to pre-warm electronics in sub-zero conditions. Thermal management is about maintaining an optimal range: not too hot and not too cold. The best rugged cabinets have features to handle both ends of the spectrum.



## Cooling Strategies

In short, managing heat in harsh environments is a multi-faceted challenge, and a well-designed cabinet turns that challenge into a solved

problem. It's not just the boards and power supplies that you are buying - it's the complete thermal solution (fans, filters, coolers, insulation, sensors) needed to keep those boards running optimally for the long haul. Decision-makers should evaluate an enclosure's cooling strategy with the same scrutiny as its structural strength or EMI shielding - all are equally mission-critical in the field.

**Figure 1** Actively cooled rugged fire proof cabinet

# Application Case Studies: Lessons from the Field

To ground these considerations in reality, let's examine several application domains where harsh-environment cabinets play a pivotal role. Each case study highlights different requirements and how modern cabinet designs meet them:

## Missile Defense Systems (Patriot, Aegis SPY-6 radar)

These systems involve high-power radar and control electronics that must operate reliably in combat scenarios. The U.S. Navy's AN/SPY-6 Air and Missile Defense Radar, for example, drove stringent requirements for its electronics cabinets. Optima Stantron was selected to supply the SPY-6 equipment racks, and the program demanded hardware modularity, scalability, and the ability to withstand diverse environmental and combat stresses. In practice, this meant the cabinets had to meet MIL-S-901D shock, MIL-STD-167 vibration, MIL-STD-810 for climate extremes, and MIL-STD-461 for EMI - all while being modular enough to accommodate technology insertions over the radar's lifecycle. The delivered solution embodied these principles: a robust aluminum-frame cabinet with shock isolators and EMI gasketing that can be reconfigured as needed. As Elma's president noted, the cabinets "guarantee the protection, reliability and scalability that defense programs demand" while providing a growth path for future upgrades [5gtechnologyworld.com](http://5gtechnologyworld.com). Similarly, the U.S. Army's Patriot missile defense system uses mobile shelter cabinets for its radar and command stations. These are mounted on trailers and subjected to constant vibration and jolts during transport, plus dust and temperature extremes in the field. Patriot enclosures require high shock/vibration resilience (often tested to MIL-STD-810 truck

transport profiles) and excellent EMI shielding to ensure that nearby radar pulses or jamming attempts don't upset the electronics. In one case, a standard rugged cabinet was modified with additional shock isolators at its base to survive the pounding of cross-country transit. By pairing a COTS rugged cabinet with custom shock mounts (and adding features like retractable maintenance shelves and robust cable management for the heavy electronics), the supplier delivered a field-ready solution that met the mission's needs.

## Naval Combat Systems

Onboard naval vessels, space is at a premium and the environment is unforgiving – there is constant vibration from engines and waves, salt-laden air that promotes corrosion, and the risk of shock from munitions hits. Cabinets used in shipboard combat information centers or weapon control systems must be extremely robust and often seismically braced (a warship in combat can behave like a building during an earthquake in terms of shock/vibration). For instance, one deployed fire-control system cabinet for the Navy's Sea Sparrow missile defense was built to be shock and vibration qualified & EMI/RFI secure, passing MIL-S-901D, MIL-STD-167, and even TEMPEST-level EMI tests. Notably, this design includes an inner VME electronics chassis that fully extends and rotates 90° for easy access to modules, illustrating how engineers balanced extreme ruggedness with maintainability. Features like stainless steel hardware are used to resist salt corrosion, and drip-proof tops or guttered doors protect against any overhead leaks. Many naval cabinets also tie into ship resources – for example, some have provisions for chilled water cooling hookups to interface with a ship's cooling plant, or use special low-smoke paint and gasket materials to meet naval safety specs. Figure 1 below shows an example of a naval-grade cabinet designed for shock, vibration, and EMI protection.



**Figure 1** Shipboard cabinet examples. Fully assembled

## Surveillance & Telemetry Stations (Air Traffic, Radar, etc.)

Outside of frontline weapon systems, many support installations rely on rugged enclosures as well. Consider an FAA remote radar or radio telemetry station: often these are unmanned boxes on a mountaintop or out in an open field. They may not need to survive a torpedo hit, but they do need all-weather protection (e.g. NEMA 4 or IP65 sealing against rain and dust), EMI control (to avoid interfering with sensitive receivers nearby), and redundant cooling (because if a fan fails, the system might lose radar coverage until someone can service it). Some FAA equipment cabinets are located in seismic zones (e.g. a radar control box on the U.S. West Coast), so they also require seismic anchoring or isolation similar to telecom standards. A typical solution for these outdoor electronics racks might involve a double-walled enclosure for thermal insulation and sun/solar heat shielding (since direct sunlight can bake a cabinet's interior), redundant fan filters or small AC units, and internal battery backups for short power outages. Even though these are "civilian" systems, they end up incorporating many mil-spec lessons: vibration isolators, sturdy anchor brackets, EMI filtering to avoid interference with aviation frequencies, and high-reliability cooling with automatic failovers. The emphasis is on unattended reliability – the cabinet must keep the gear running 24/7 in remote, harsh locales with minimal maintenance visits.

## Nuclear Energy & Industrial Control

In nuclear power plants and certain heavy industrial sites, electronic control systems are housed in cabinets that must remain functional during and after events like earthquakes, voltage surges, or electromagnetic disturbances. Nuclear facilities often have their own standards (e.g. IEEE 344 for seismic qualification of Class 1E equipment) which map to stringent testing similar to Zone 4 seismic and MIL-STD EMI tests. Cabinets in these settings are usually floor-mounted with seismic kits – bolted anchor brackets, snubbers, sway braces – and sometimes internal shock absorbers for critical sub-components. The operating environment can be warm, humid, or mildly corrosive (for instance near cooling towers or chemical processes), so corrosion-resistant construction (stainless steel or aluminum with protective coatings) is key. Another consideration is longevity: nuclear plants might operate for 40+ years, so the cabinets need to support technology upgrades over decades. A modular aluminum frame is very valuable here – it's easier to swap out sub-assemblies or reconfigure as control systems are modernized, without replacing the entire enclosure. As an example, one seismic-rated cabinet for a power plant was adapted from a standard COTS modular design by adding a seismic reinforcement kit (welded corner gussets, heavy floor bolts). This allowed a proven standard cabinet to meet nuclear seismic criteria in a cost-effective way. The nuclear sector underscores that safety and reliability are paramount; every component down to the cabinet is part of the safety case. Thus these cabinets must pass rigorous qualification – showing via shake-table and EMI tests that they can endure design-basis events without allowing their equipment to fail.

## Heavy Industrial & Mobile Equipment

Rugged cabinets are also used in industries like mining, oil & gas, transportation, and even emerging fields like hypersonics testing. For example, a mobile control cabinet on an oil exploration truck might face constant shock and vibration (from off-road driving), exposure to mud, and rapid temperature swings. In one scenario, engineers added top and bottom shock isolators to a standard 19-inch cabinet, effectively turning it into a “floating” platform that cushioned the electronics inside the vehicle. Likewise, battery backup units and power converters in military or industrial use are often enclosed in heavy-duty racks that require not just cooling (because large batteries and inverters produce heat) but also venting of any outgassed fumes and integration of fire-suppression systems. Each use case may emphasize a different mix of features – a battery cabinet in a mobile command post might prioritize cooling and fire safety, whereas a mining truck’s control cabinet emphasizes shock protection and dust sealing – but the foundational design principles remain consistent. In all cases, a modular rugged cabinet can be tailored by adding the right isolation mounts, gasket seals, cooling units, or protective coatings to meet the specific environment.

Each of these case studies reinforces a central message: the enclosure is an integral part of the system’s success in harsh environments. It is not a commodity box or afterthought; it must be engineered with the mission in mind. The best outcomes arise when end-users, system integrators, and enclosure experts collaborate early in the design process to anticipate challenges and incorporate the right features. For example, a missile defense program manager might not need to know the minutiae of gasket conductivity, but they will appreciate that the chosen cabinet already meets the required MIL standards and has been proven in similar deployments – which reduces program risk and allows the focus to remain on the higher-level system performance.

## Strategic Takeaways and Conclusion

Selecting a cabinet for harsh environments is a multidisciplinary decision that impacts the project’s cost, timeline, and long-term success. Below are some strategic considerations for engineers and program managers as they navigate this process:

### Engage Early with Experts

It pays to involve an experienced enclosure supplier early in the design phase. Many rugged cabinet providers offer consulting services to help map out requirements – expected shock levels, thermal loads, EMI needs, etc. – and can propose solutions or trade-offs before the system design is locked in. By exploring “what if” scenarios upfront (e.g., What if the system later needs to be deployed on a mobile platform? What if it needs additional cooling capacity for upgraded CPUs?), you can avoid painful redesigns down the road. Early engagement helps right-size the cabinet specification: robust enough for foreseeable challenges but avoiding unnecessary over-engineering that adds cost.

## Balance COTS and Custom

Today's modular enclosure designs blur the line between off-the-shelf and custom. Often the fastest and most cost-effective path is to start with a COTS modular base design that has known performance, and then tailor it to your needs. This approach provides confidence – since the base platform is already tested to relevant standards – and saves time, while still allowing customization of height, depth, cooling options, etc. Working with a vendor that has a library of proven platforms (for example, standard frame variants for seismic vs. non-seismic use, or for higher EMI levels up to TEMPEST) means you aren't reinventing the wheel for each requirement. You can also leverage prior case studies: ask vendors if they have built a similar cabinet for a radar system or an industrial robot before – chances are the answer is yes, and that design knowledge can be leveraged to jump-start your project.

## Think Future and Lifecycle

A good cabinet might outlast the electronics it houses several times over. Plan for future upgrades and changes. Features like extra rack space, removable panels for expansion, reserve cooling capacity, and accessible cable management are not just “nice-to-haves” – they can save significant time and money when an upgrade or modification is needed in the future. The SPY-6 radar example is instructive: by planning for technology insertion over decades, the Navy's chosen cabinet ensures they can upgrade radar electronics without replacing the physical enclosures. Similarly, in industrial settings, if you anticipate more sensors or drives being added later, choose a cabinet that can accommodate growth (maybe one that is slightly larger, or that has modular sections which can be added). The upfront cost of a somewhat bigger or more versatile enclosure is usually far less than the cost of replacing it entirely down the road.

## Certification and Testing

Insist on relevant certifications and test data for the cabinets you consider. A reputable cabinet supplier should be able to provide reports for MIL-STD tests or other standards their designs have passed. If your application has unique requirements (say, exposure to nuclear radiation or a specific acoustic noise limit), discuss whether the enclosure needs additional testing or design tweaks for that. It's often wise to include the enclosure in any full system qualification testing – for instance, when doing environmental tests on the integrated system, observe how the cabinet performs: do the doors stay latched during shock tests? Are there any rattles during vibration (which could indicate a need for better damping)? This holistic testing ensures no unpleasant surprises after deployment. In many cases, success is in the details – something as small as a latch or a fan bracket might need reinforcement to meet a standard, and it's better to catch that during qualification than in the field

## Human Factors

While technical specs dominate, don't forget the human element. Ease of use, maintenance, and even aesthetics can matter, especially for cabinets in manned environments. For example, a cabinet in an operations control room might be required to visually match other consoles (military programs sometimes have color/finish standards for equipment). If the cabinet is in a crewed space, consider acoustic noise from fans or vibration – perhaps acoustic-damping panels or isolators can be used to reduce ambient noise. For maintenance, features like quick-release fasteners, interior service lights, or

even a simple document pouch on the inside of the door (to hold schematics) can greatly facilitate field support. In harsh industrial sites, designing to ergonomic standards can improve safety – e.g., ensure frequently accessed controls and displays are at a reachable height, and that modules can be replaced without awkward maneuvers. These human-centric touches can enhance the usability and maintainability of the system.

## In Conclusion

The selection of a harsh-environment cabinet is a strategic decision that can significantly impact the success and longevity of military and industrial projects. A well-chosen enclosure ensures that sensitive electronics are protected against shock, vibration, electromagnetic interference, moisture, and thermal stress – whether they are on a Navy ship, a missile launcher, a factory floor, or a remote radar station. It will comply with the necessary standards, providing confidence and easing the path to certification for the overall system. It will incorporate modern innovations – from lightweight modular frames to advanced cooling and EMI shielding – to meet technical demands, while also offering the flexibility to adapt to future needs. And just as importantly, it will come from a vendor who can support you through design, testing, and deployment, acting as a partner in achieving your mission’s goals.

By carefully considering the points we’ve discussed across this four-part series – environmental standards, EMI suppression, materials and construction, thermal management, and application-specific requirements – program managers and engineers can make informed decisions and avoid costly pitfalls. The environment may be harsh, but with the right cabinet design, your electronics can thrive in it. Ultimately, the cabinet is more than just an enclosure; it is an enabling platform that allows sophisticated technology to perform reliably where it matters most. As systems continue to evolve with higher performance and push into harsher domains (from hypersonic weapons and naval railguns to deep-space communication nodes and smart grids in disaster zones), the humble equipment cabinet will remain a quiet linchpin of success – provided we give it the attention and engineering rigor it rightly deserves.

References (Part 4)

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