

PRODUCT DATA SHEET



NITOHARD STRUCTURAL REINFORCEMENT PATCHES FOR STEEL SUBSTRATES

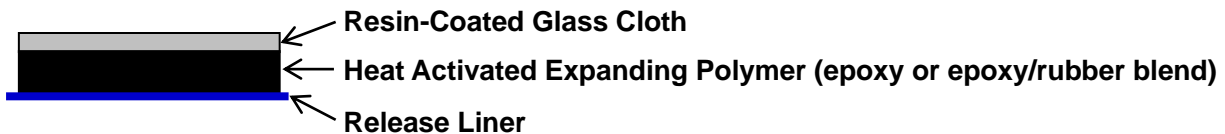
GENERAL DESCRIPTION

PA-7000, PM-7000, PE-7000, PE-7100, P-7000 & RE1000 are lightweight dual-layer products that are used to increase the bend strength of steel panels to prevent oil canning/palm denting and to correct subjective stiffness issues. The reinforcing characteristics are triggered by the heat from bake ovens during the e-coat/paint processes.

FEATURES

- Can be die-cut into any shape
- Self-adhering before bake
- Exhibits excellent initial adhesion to clean or oily substrates
- Patch designs to prevent sink mark after baking process

PRODUCT CONSTRUCTION



APPLICATION

- Apply in body shop before e-coat process. Some versions are applied after e-coat.
- Is designed to expand and cure during typical e-coat/paint bake cycles
- Ideal solution for effectively stiffening and eliminating oil-canning of body panels, such as doors, roof panels, hoods, liftgates, fenders, quarter panels, etc.

PROPERTIES

NITOHARD Products for Steel Substrates						
NITOHARD Type	PA-7000	PM-7000	PE-7000	PE-7100	P-7000	RE1000
Polymer Base	Epoxy Based					Epoxy-Rubber Based
Available Thicknesses	0.8mm - 2.0mm		0.8mm - 1.6mm		0.8mm - 2.0mm	
Adhesion Type	Tacky	Tacky/ Magnetic	Tacky			
Application	Paint Shop	Body Shop				
Minimum Bake Conditions	120C (248F) x 30 min 135C (275F) x 15 min	160C (320F) x 30 min 180C (356F) x 15 min				
Expansion Ratio*	~100%	~100%	~50%	~150%	~25%	~100%
Shelf Life	90 days when stored within proper storage conditions (15C-35C & 25%-50% RH)					

*Expansion ratio varies based on customer processing conditions

Disclaimer: The technical information on this product data sheet is based on measured value obtained from laboratory tests. Actual results may vary due to differences in lab/process evaluation conditions.