

## DOUBLEDAMP™ 1500 EXPANDABLE DAMPING SHEET

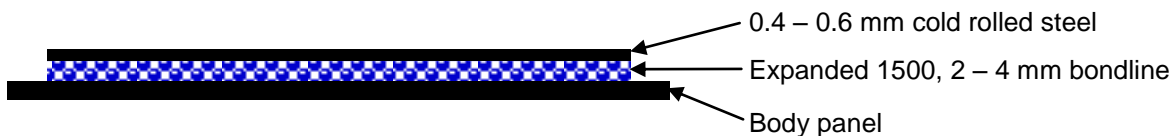
### GENERAL DESCRIPTION

A high-efficiency, expandable damping material for use with stamped steel constraining layers.

### FEATURES

- A non-blocking, die-cut sheet which can be heat staked to the stamped steel constraining layer
- Can also be mechanically or adhesively fastened
- Ensures complete fill between the constraining layer and the body steel
- Highest damping efficiency, especially at higher temperatures
- Assembly provides high degree of local stiffness
- Provides superior corrosion resistance to substrates
- Lighter weight, higher performance replacement for expandable asphalt

### PRODUCT CONSTRUCTION



### APPLICATION

- Applied in Stamping - Fabrication
  - Die-cut sheet applied to stamped steel or aluminum constraining layer
  - Fasten by heat staking, adhesive or staples
  - Welded to body panel
  - Expands & cures in E-Coat oven
  - Compatible with processes
- Treats precise areas; front of dash/plenum, tunnel, & wheel house

### PROPERTIES

<b>APPEARANCE</b>	Black, non-tacky sheet			
<b>SPECIFIC GRAVITY</b>	1.4 (before expansion)			
<b>WEIGHT/AREA</b>	Thickness		kg/m <sup>2</sup>	lb/ft <sup>2</sup>
	1.0 mm (0.040 in)		1.4	0.29
	1.5 mm (0.060 in)		2.1	0.43
<b>EXPANSION</b> Bake 20' @ 163°C			Volumetric	Vertical Rise
			125 - 200%	250 - 350%
<b>ADHESION PROPERTIES</b> Tested on oily galvanized & cold-rolled steel. Panels cured 20' @ 163°C + 30' @ 121°C.	Initial	Salt Spray 250 Hrs	Heat Aging, 250 250 Hrs @ 175°C	Humidity 250 Hrs @ 38°C & 100% RH
	100% Cohesive	100% Cohesive No undercutting corrosion	100% Cohesive	100% Cohesive No undercutting corrosion
<b>DAMPING PROPERTIES</b>	Oberst testing for composite loss factor, $\eta_c$ , was conducted per SAE J1637 0.8 mm base beam, 0.5 mm top beam, 2.5 mm bondline: 0.41 @ 25°C and 200 Hz			