BETASEAL™ APG

Trusted Quality, Every Time

Advanced **P**rimerless to **G**lass adhesive with new low monomeric diisocyanate formulation

- Primerless-to-glass (inner or outer frit) and primerless-to-cut-bead
- 60-minute minimum drive-away time (MDAT)
- Low diisocyanates is technician-friendly: safer handling and no mandatory training is needed
- Easy-to-dispense formula offers excellent sag or slide resistance, and easy-to-tool with short tails
- Primerless application to OEM paint
- High modulus and non-conductive
- Can be applied across a wide temperature spectrum

DuPont introduced direct glazing to the auto industry and we're still innovating. Let our 65+ years of experience work for you!

+1 Billion Windshields Bonded Using BETASEAL Adhesives OEM QUALITY

MADE IN EUROPE

DuPont Adhesives Proudly Made in Europe

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Windshield installation instructions

1

Wear appropriate safety equipment

a) Protect yourself

b) Wear safety equipment, such as work gloves, nitrile chemical-resistant gloves, safety glasses, work apron or other protection required by your company

2

Inspect replacement glass

a) Spray glass bonding surface and vision area with BETACLEAN™ 3300 MOD Glass and Surface Cleaner and wipe glass clean with a lint-free paper towel

b) Inspect replacement glass for defects, damage or signs of contamination

c) Verify primer and adhesives are within use-by dates

3

Cut out the glass

a) Protect the customer's vehicle

b) Remove all hardware and reveal moldings

c) Cut out the windshield using your preferred method

4

Prepare the glass

a) Many contaminants are difficult to detect and remove

b) Spray glass with BETACLEAN™ 3300 MOD Glass and Surface Cleaner

c) Use Easy-go melamine foam sponge to wet scrub the surface

- This is a mechanical abrasion step, make sure to use some pressure
- Ensure the entire bonding surface is treated

d) While the surface is still wet, wipe surface with a clean paper towel

e) Spray glass again with BETACLEAN™ 3300 MOD Glass and Surface Cleaner

- If the glass cleaner de-wets, repeat steps A through D
- If the glass cleaner does not de-wet, proceed to glass priming step

4.1

Exception: Pre-primed fritted glass

a) Spray glass with BETACLEAN™ 3300 MOD Glass and Surface Cleaner

b) Use Easy-go melamine foam sponge to wet scrub the surface

c) While the surface is still wet, wipe surface with a clean paper towel

d) Apply BETAPRIME™ 5508 to the pre-primed fritted glass surface with dauber

e) Allow primer to dry for 2 minutes at -7˚C and above. Between -7˚C and -18˚C, allow primer to dry for 6 minutes

f) If glass is not installed within 24 hours of original priming, clean then reprime the glass with BETAPRIME™ 5508; do not reprime more than once

4.2

Exception: Encapsulation or PAAS

a) Clean RIM or PVC encapsulation with BETACLEAN™ 3300 MOD Glass and Surface Cleaner and a clean, lint-free paper towel

b) "Wet scrub" the encapsulation with an abrasive pad and BETACLEAN™ 3300 MOD glass cleaner until the gloss is removed from the surface and it appears matte and slightly foamy in finish. Clean again with BETACLEAN™ 3300 MOD Glass and Surface Cleaner to remove any debris on the surface and allow to dry completely.

c) Check the expiration date on the container

d) After Shaking homogenius, apply BETAPRIME™ 5508 to the RIM or PVC encapsulation surface with dauber

e) After Shaking homogenius, apply BETAPRIME™ 5508 to any molding surface that contacts new urethane to promote adhesion

f) Allow primer to dry for 2 minutes at -7˚C and above. Between -7˚C and -18˚C, allow primer to dry for 6 minutes

g) Close the bottle immediately with inner seal and cap

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Trim back the urethane

a) Clean any dirt and debris from around the existing urethane with BETACLEAN™ 3300 MOD Glass and Surface Cleaner or water and a clean towel

b) Trim the urethane, leaving a 1 mm to 2 mm base of original urethane on the pinchweld

c) Take care not to damage the vehicle paint or pinchweld

d) Any areas of trimmed urethane that require additional cleaning should be carefully wiped with BETACLEAN™ 3300 MOD Glass and Surface Cleaner or water and a clean towel

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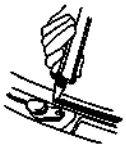
Prepare the pinchweld

Once body surface is clean and dry, follow these priming steps:

a) Check the expiration date on the container

For priming any areas of bare metal (large or small, including scratches):



b) After Shaking homogenius, open the bottle of BETAPRIME™ 5508 Primer carefully and insert a clean, unused dauber; to avoid spilling, never pour liquid on dauber

c) Apply one coat of BETAPRIME™ 5508 with a clean wool dauber to any scratches in the paint or large areas of bare metal

Note: For areas with large damage, we recommend to apply two coats of BETAPRIME™ 5508 to enable good corrosion protection.

d) Allow primer to dry for 2 minutes at -7˚C and above. Between -7˚C and -18°C allow primer to dry for 6 minutes.

e) Apply a second coat of BETAPRIME™ 5508 and allow primer to dry for 2 minutes at -7˚C and above. Between -7˚C and -18˚C, allow primer to dry for 6 minutes.

For priming painted bonding surfaces (Skip this step if using BETASEAL™ APG applied to clean OEM paint):

b) Open the bottle of BETAPRIME™ 5508 carefully and insert a clean, unused dauber; to avoid spilling, never pour liquid on dauber

c) Apply one coat of BETAPRIME™ 5508 with a clean wool dauber to the painted area where original adhesive may have peeled off or to extend the bonding area when applying adhesive to the glass part

d) Apply a second coat of BETAPRIME™ 5508 and allow primer to dry for 2 minutes at -7˚C and above. Between -7˚C and -18˚C, allow primer to dry for 6 minutes.

Warning: Do not reinsert (double dip) the dauber into the primer bottle if it has touched the body of the vehicle. This could contaminate the remaining primer in the bottle. Freshly painted areas can only be primed after minimum 24 hours for paint curing.

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Apply BETASEAL™ Adhesive (Choose either glass or pinchweld application)

a) Hold the applicator in a vertical position 90° to the glass and dispense the adhesive with a continuous motion in a uniform "V" shaped bead

b) Apply adhesive to the glass on top of the bond line, matching the location of the original adhesive bead on the glass or apply adhesive to the pinchweld perimeter directly on top of the freshly cut original equipment urethane film

c) Either application: Hold the applicator in a vertical position (90°) and dispense the adhesive with a continuous motion in a uniform "V" shaped bead

d) Make sure bead is uniform and has no gaps; add material or gently tool joints, if necessary

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Install the glass

a) Carefully place the glass in the body opening

b) Adjust glass to precise alignment

c) Lightly press it into position

Note: Hand impacts should be avoided

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Clean up

a) Clean any excess uncured urethane with BETACLEAN™ 3500AF

b) Clean the newly installed glass with BETACLEAN™ 3300 MOD Glass and Surface Cleaner

c) Clean up any remaining debris or broken glass on seats, floor, door handles and/or dash console

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Recordkeeping

a) Attach master lot code sticker to paperwork or manually record primer and adhesive lot numbers

b) Communicate to the customer when MDAT will be reached and when the vehicle can be driven

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