



Technical data sheet

Dow Automotive

BETASEAL 1965

Description / Application:

One-component, high-viscosity, atmospheric and humidity-curing polyurethane bonding compound with high shear modulus and excellent paint adhesion. Due to these qualities a higher body stiffness can be reached by using this material in the field of direct glazing.

All Dow Automotive products are primarily developed in co-operation with the automobile manufacturers, according to their needs and their specifications; they are approved for the specific applications as defined by the customer.

The use of the product other than approved application have to be released in written form by the Technical Service of Dow Automotive.

Technical Data:

Basis	polyurethane prepolymer
Colour	black
Density	1.25 +/- 0.1 g/cm ³ at 23 °C
Solid content	> 98%
Flash point	> 100 °C
Processing temperature	23 -65 °C
Open time	> 10 min at 23 °C/50% rh
Sagging behavior	good
Tack-free time	approx. 20 min at 23 °C/50% rh
Viscosity (Extrusion, Ballan 4 mm nozzle, 4 bar)	pasty, cold pumpable 10-24 g/min at 23 °C
Cure rate	> 3.0 mm in 24 h at 23 °C/50% rh
Tensile strength (DIN 53 504)	> 5 MPa
Elongation at break (DIN 53 504)	approx. 300%
Lap shear strength (EN 1465)	min. 5 MPa after 7 d 23 °C/50% rh
G-Modulus	> 2.8 MPa at 10% strain after 7 days 23 °C > 2.2 MPa at 10% strain after 7 days 80 °C (height of adhesive layer: 1.75 mm)

Specific electrical volume resistivity	> 10 ⁶ Ohm cm
Temperature stability	-40 °C to 100 °C
Resistance to chemicals	Highly resistant to aqueous chemicals, petrol, alcohol and mineral oils; conditionally resistant to esters, ketones, aromatics and chlorinated hydrocarbons
Bonding surface preparation	All bonding surfaces must be free of dirt, dust, water, oil and grease. Glass surfaces should be primed. Verify compatibility or consult our technical service department.
Processing equipment	Cartridges: hand-operated or pneumatic heated gun with mechanical piston Drums, pails: commercial pumping system with connection to automatic applicator, if required.
Cleaning	Uncured BETASEAL 1965 residues can easily be removed with BETACLEAN 3500. Hardened BETASEAL 1965 residues can only be removed mechanically. Immerse equipment in BETACLEAN 3000
Shelf life	Short time storage temperatures: -10 °C to 40 °C 6 months at +5 °C to +25 °C in unopened containers. (See "use before" date printed on container.)
Containers	300 ml cartridges, cardboard packs of 12 Drums: 200 litres
Protection measures	See health and safety data sheet.

Application:

Dow Automotive quality assurance

Quality is our utmost goal. Dow Automotive works according to a modern quality management system conforming to ISO/TS 16949:2002.

Environment: All sites of Dow Automotive are conforming to ISO 14001:2004.

All statements, technical information and recommendations contained in this document are based on tests that we believe are reliable.

However, the accuracy or completeness of the statements, information and recommendations is not guaranteed, as before using, the user should determine the suitability of the product for user's intended purpose.

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