

BETASEAL 1580

BETASEAL 1580 Multi - Job kit Adhesive Process



Offer your customers a 30-minute minimum drive-away time

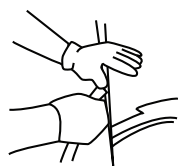
IMPORTANT:

- Wear appropriate Personal Protection Equipment, including protective and chemical-resistant gloves and eye protection
- Consult MSDS and familiarise yourself with all relevant health information and safety procedures for both BETASEAL™ 1580 adhesive system and the vehicle
- Follow OEM application manual of the respective make and model
- Batch trace-ability stickers are part of the BETASEAL 1580 Multi-job kit, please use them



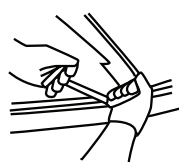
Required materials: Cutting-out equipment, trimming (cut-back) chisel, glass suction, lint-free cleaning towels, primer applicators and adhesive dispenser. Ensure all products are within shelf life or open-time limitations. When opening new primer, note the date of opening on the bottle. Once open, primer is good for only open time pot life. **Check the ARGIC code to ensure the glass specification is correct & no damage to the glass prior to the replacement process.** Ensure the used-by date on all products are within date, use a marker pen to itemise the open pot life on primer bottle neck at time of opening.

1



Remove all moldings, rear-view mirrors, trims and wipers,
Disconnect all electrical devices and cowlings that could be impacted by cut out and installation. Cover adjacent external and internal surfaces.

2



Cut through the existing glass bond line using your preferred glass removal method, taking care not to damage the vehicle or any electrical systems or cables.

3



Dry fit the glass after safe removal of existing glass.
Make sure the new glass unit fits correctly, has the correct specification and is free from defects.

4



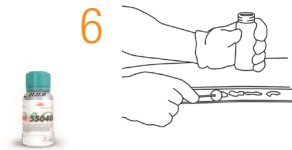
Prepare the vehicle aperture - No corrosion present.
If the residual PUR bead is sound & stuck firmly, trim it back to a height of 1-2 mm to provide a clean, level and secure surface for the bonding process.
Initially brush away loose debris & clean aperture with BETACLEAN™ 3300 to remove dirt & grime. Reclean the aperture with Heptane based wipes in a continuous (non scrubbing) motion to provide an effective clean & high surface tension bonding area (refer to separate instructions for refilling Heptane wipe containers)

5



Corrosion Process (if no corrosion present or bare metal incl nicks or scratches, then move to step 7)
Corrosion present: Grind / abrade corrosion in and around the bond line area down to bare metal. Clean the aperture with Heptane based wipes in a continuous (non scrubbing) motion. For larger damaged area, repair at a body shop may be required. **It is an unsafe replacement, if less than 100% of the vehicle aperture is available for re-bonding.**

6



Exposed Bare Metal
Apply BETAPRIME™ 5504G No-Shake Primer to bare metal including any nicks and scratches in the paint
Apply using stick or wire applicator **two coats** of primer to build up protection. Allow one (1) minute dry time between coats and two (2) minutes dry time after 2nd coat.

Open pot life 10 days

7



No priming is necessary if PU cut-back bead is firmly secure to the body aperture and freshly trimmed (up to 2 hours). If the remaining PU bead is insecure or missing, then prime the aperture bond line with BETAPRIME™ 5504G No-Shake Primer in a continuous movement. Otherwise, apply BETAPRIME™ 5504G No-Shake Primer between remaining bead and paint. Apply one even coat in a continuous movement. Take care with trim-less glass to only prime areas not seen once installation is complete.

Open pot life 10 days

8



Spray glass bonding surface and vision area with BETACLEAN™ 3300 & Decontaminate.
Visibly inspect the bondline surface by spraying BETACLEAN™ 3300, this also aids removal of labels. Scrub entire bonding area with BETACLEAN™ Easy-Go cleaning sponges, whilst lubricating the sponge with BETACLEAN™ 3300. Spray once again the entire windscreen with BETACLEAN™ 3300, wipe clean with a lint-free paper towel.
NOTE: Do not re-use old sponges on additional glasses. In the event of **extreme contamination** & / or non wetting-out of the BETACLEAN™ 3300 then use BETABRADE™ F1 instead of Easy-Go sponges with a lint free cloth.

9



Prime glass ceramic with BETAPRIME 5504G™ No-Shake Primer. Apply one even coat in a continuous movement.

Note: For RIM and PUR pre-applied encapsulations. If encapsulations fall within the bond line, it may be necessary to clean with BETACLEAN™ 3300 and dry with lint-free towel prior to priming. Allow primer to flash off for 2 minutes.

Open pot life 10 days

10

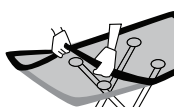


Polycarbonate & composite bonding with BETAPRIME™ 5061

- Abrade bond line with medium grit paper or abrasive pad.
- Clean bond line with BETACLEAN™ 3300 Glass Cleaner.
- Shake BETAPRIME™ 5061 Primer for 60 seconds.
- Apply coat of BETAPRIME™ 5061 and flash off for a minimum of 10 mins.
- Surface is now ready for bonding.

Open pot life 5 days

11



If necessary, fix continuous trim around the glass prior to installation.

Be careful not to damage or contaminate the primer film. *Important note - wear chemically protective gloves to ensure primer film is not to damaged or contaminated*

12

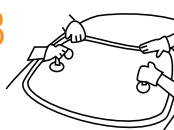


Apply BETASEAL™ 1580 adhesive

At the bottom of the aperture using a pre-cut triangular nozzle, ensuring the new adhesive is applied over the old remaining bead where applicable. Hold the dispenser at a near-90° angle to ensure a high triangular bead. A single-only joint is preferred. Overlap the joint and tool to form a complete bead with no gaps or air pockets for best adhesion.

Do not over work the joint such that air pockets are created.

13



Affix the glass to the body immediately after extrusion & tooling.

Take care to position the glass as accurately as possible minimising the need to realign. A windscreen setting tool allows the required level of control and is the preferred method in single technician operations

14



Compress the glass to the correct height within the aperture.

Care should be taken not to over compress. Use gentle pressure and not tap or bang the glass which can adversely affect the urethane bead.

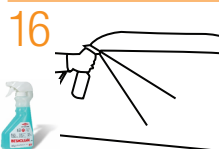
15



Reconnect all electrical sensors and other Advanced Driver Assisted Systems (ADAS)

Reinsert moldings and trims, secure all cowlings under the bonnet and affix wipers and rear-view mirror, sensors, & ADAS equipment (where applicable). Check that all systems work correctly.

16



Clean up.

Remove all protective covers from vehicle interior and exterior. Clean glass with BETACLEAN™ 3300 and wipe off with lint-free paper towel.

17



30 minutes to recalibrate ADAS &/or Drive away time

Recalibrate any ADAS necessary, record & hand back after 30 minutes, display and inform vehicle owner of minimum drive-away time. **Record all product batch numbers on job card** to ensure quality and full traceability. Complete paperwork and hand back keys to customer.