

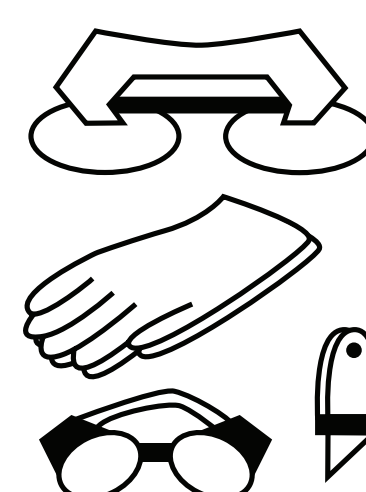
# BETASEAL™ 1585 Adhesive Application Guide

Choice of two sizes – 420 ml or 600 ml sausage packs. Also available in kits that include cleaning sponges and primer.

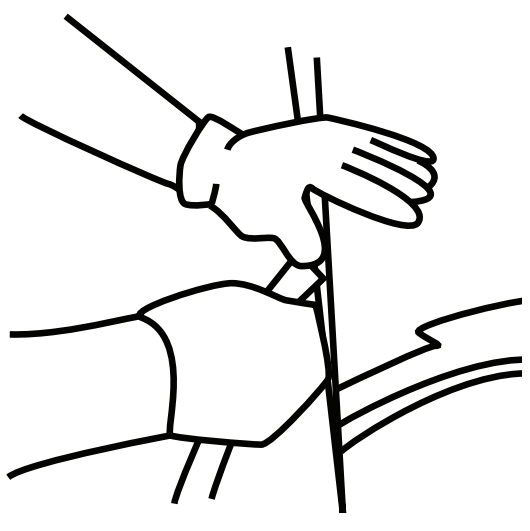


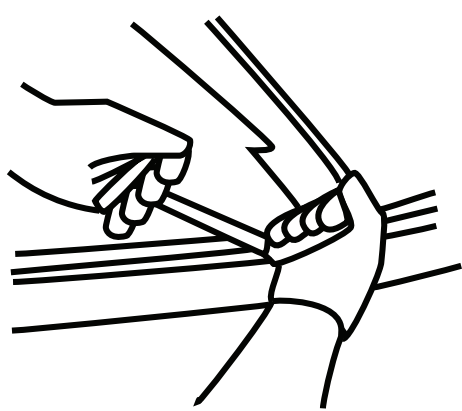
## IMPORTANT:

- 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™ 1585 adhesive and the vehicle
- Follow OEM application manual of the respective make and model

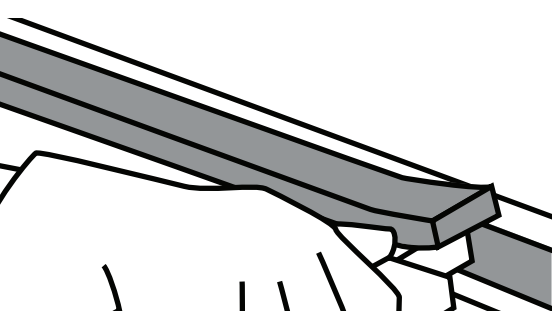


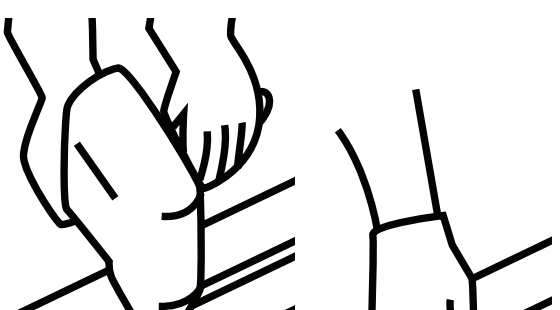
**Required materials:** Cutting-out equipment, trimming knife, glass suction, lint-free cleaning towel, primer applicators and adhesive dispenser. Ensure all products are within shelf life or open-time limitations. When opening new primer, note the date of opening on the bottle. Once open, primer is good for 7 days. Check the ARGIC code to ensure the glass specification is correct.

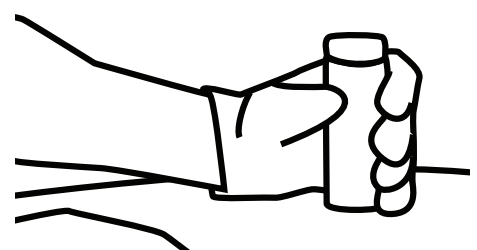
**1**  **Remove all mouldings, rearview mirrors, trims and wipers,** and disconnect all electrical devices and cowlings that could be impacted by cut out and installation. Open vehicle side windows and cover adjacent external and internal surfaces.

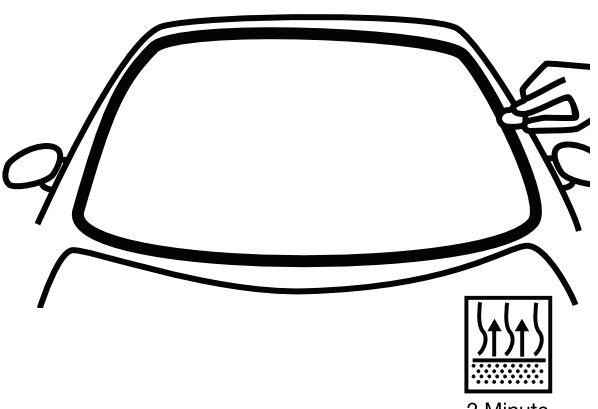
**2**  **Cut through the existing glass bond line** using your preferred method, taking care not to damage the vehicle or any electrical systems or cables.

**3**  **Dry fit the glass after safe removal of existing glass.** Make sure the new unit fits properly and is free from defects.

**4**  **Prepare the vehicle aperture.** If the residual PUR bead is sound and stuck firmly, trim it back to a height of 1-2 mm to provide a clean, level and secure surface for rebonding. Take care not to damage paint. Clean the aperture with BETACLEAN™ 3300 and wipe off with lint-free towel.

**5**  **Check for corrosion.** If necessary, grind/abrade any corrosion in and around the bond line area down to bare metal, clean with BETACLEAN™ 3300 and wipe off with lint-free towel. For larger damaged area, repair at a body shop may be required.


**6**  **Apply BETAPRIME™ 5504G No-Shake primer to bare metal.** Follow package directions and apply using wire applicator. Apply two coats of primer to build up protection. Allow a minimum of two (2) minutes for the primer to dry.

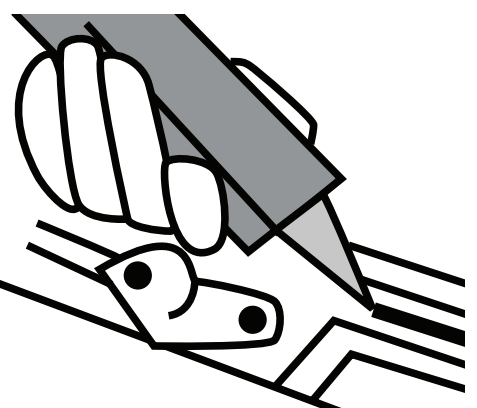
**7**  **No priming is necessary** if PU cut-back bead is firmly secure to the body aperture and freshly trimmed (up to 2 hours). If the remaining PU bead is insecure or missing, then prime the aperture bond line with BETAPRIME™ 5504G No-Shake primer in a continuous movement. Otherwise, apply BETAPRIME™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

**8**  **Remove any glass contamination.** For common contaminants, spray bond-line area with BETACLEAN™ 3300 and clean with Easy-Go Cleaning Sponge.

**9**  **Prime glass ceramic with BETAPRIME™ 5504G No-Shake primer.** Following package directions, apply one even coat in a continuous movement.

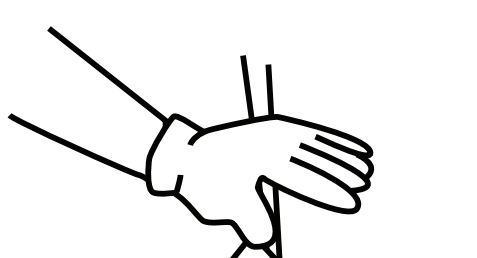
Note: For RIM and PUR pre-applied encapsulations, if encapsulations fall within the bond line, it may be necessary to clean with BETACLEAN™ 3300 and dry with lint-free towel prior to priming. Allow primer to flash off for 2 minutes.

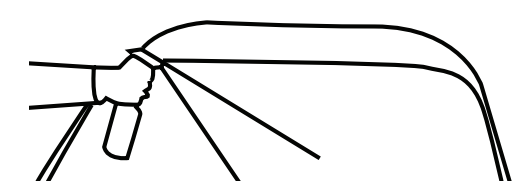
**10**  **If necessary, fix continuous trim around the glass prior to installation.** Be careful not to damage or contaminate the primer film.

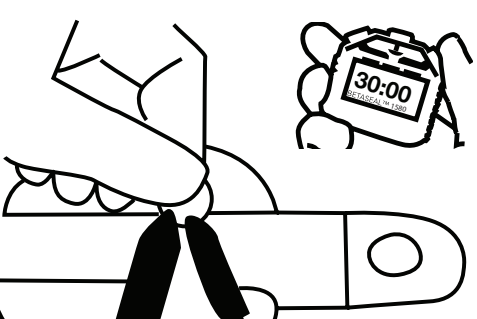
**11**  **Using an 18v dispenser, apply BETASEAL™ 1585 adhesive** at the bottom of the aperture or glass, using a pre-cut triangular nozzle, ensuring the new adhesive is applied over the old remaining bead where applicable. Hold the dispenser at a near-90° angle to ensure a high triangular bead. A single-only joint is preferred. Overlap the joint and tool to form a complete bead with no gaps or air pockets.

**12**  **Affix the glass to the body immediately after extrusion and tooling.** Take care to position the glass with minimal alignment.

**13**  **Compress the glass to the correct height within the aperture.**

**14**  **Reconnect all electrical sensors and other driver-assist systems.** Reinsert mouldings and trims, secure all cowlings under the hood and affix wipers and rearview mirrors. Check that all systems work correctly.

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

**16**  **Record and hand back after only 30 minutes.** Record time, 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.