

BETASEAL™ 1125-1F



Value-priced adhesive for glass replacement

- 6-hour safe drive away
- UV stable for gap filling
- Medium modulus, non-conductive urethane reduces significantly interference with mobile devices
- No heating required for improved work efficiency
- Compatible with existing aftermarket cleaners and primers
- Available in 310ml cartridge or 400ml and 600ml sausage




BETASEAL™ Instruction Sheet

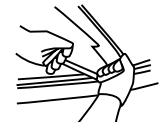
IMPORTANT:


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

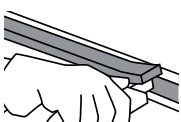


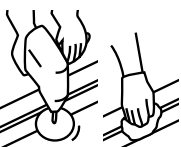
Required materials: Cutting-out equipment, trimming knife, glass suction, lint-free cleaning towel, primer applicators and adhesive dispenser. Ensure all products are within shelf life or open-time limitations. When opening new primer, note the date of opening on the bottle. Once open, primer is good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

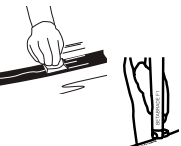
3  **Dry fit the glass after safe removal of existing glass.** Make sure the new unit fits properly and is free from defects.

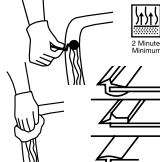
4  **Prepare the vehicle aperture.** If the residual PUR bead is sound and stuck firmly, trim it back to a height of 1-2 mm to provide a clean, level and secure surface for rebonding. Take care not to damage paint. Clean the aperture with BETACLEAN™ 3300 and wipe off with lint-free towel.


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.

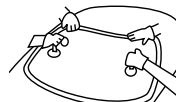
7  **No priming is necessary** if PU cut-back bead is firmly secure to the body aperture and freshly trimmed (up to 2 hours). If the remaining PU bead is insecure or missing, then prime the aperture bond line with BETAPRIME™ 5504G No-Shake primer in a continuous movement. If existing urethane was trimmed more than 2 hours prior, urethane must also be primed. 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. For heavy contamination, apply a thin bead (2 mm) of BETABRADE™ F1 around the ceramic bond line and wipe off with a clean, lint-free paper towel. Neutralise any remaining BETABRADE™ F1 by applying BETACLEAN™ 3300 around the glass. Wipe clean and dry with a clean, lint-free paper towel.


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 two (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  **Apply BETASEAL™ 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.

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 six hours.** 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.