



No need to make your customers wait

BETASEAL™ Xpress30 HMNC Urethane Adhesive
30-minute minimum drive away down to 0°F

Simple three-step process: Clean, Prime, Bond

- Exclusive RPM adhesive technology
- High modulus, non-conductive
- Excellent pumpability, no heating required and easy-to-tool
- Use with BETAPRIME™ 5504G All-in-One or CLEAR Advanced primers
- Short tails and outstanding decking
- 8-10 minute working time
- Single component – 600 ml sausage or 310 ml cartridge





Made in the USA

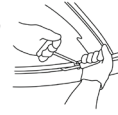



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Windshield installation instructions

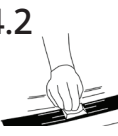
- 1**  **Wear appropriate safety equipment**
- Protect yourself
 - Wear safety equipment, such as work gloves, nitrile chemical-resistant gloves, safety glasses, work apron or other protection required by your company


- 2**  **Inspect replacement glass**
- Spray glass bonding surface and vision area with BETACLEAN™ GC-800 Glass and Surface Cleaner and wipe glass clean with a lint-free paper towel
 - Inspect replacement glass for defects, damage or signs of contamination
 - Verify primer and adhesives are within use-by dates

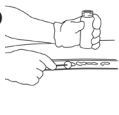
- 3**  **Cut out the glass**
- Protect the customer's vehicle
 - Remove all hardware and reveal moldings
 - Cut out the windshield using your preferred method

- 4**  **Prepare the glass**
- Many contaminants are difficult to detect and remove
 - Spray glass with BETACLEAN™ GC-800 Glass and Surface Cleaner
 - Use Easy-go melamine foam sponge or Scotch-Brite pad to wet scrub the surface
 - This is a mechanical abrasion step, make sure to use some pressure
 - Ensure the entire bonding surface is treated
 - While the surface is still wet, wipe surface with a clean paper towel
 - Spray glass again with BETACLEAN™ GC-800
 - 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**  **Prime fritted glass (skip this step if using BETASEAL™ ACE or BETASEAL™ Express APG)**
- Point pad of BETAPRIME™ CLEAR Advanced SA 1-Step/Frit Primer toward the surface to be primed and pinch tube between thumb and forefinger to break internal vial, releasing the primer
 - Allow the pad to saturate; it is not necessary to squeeze the tube. Do not repeatedly break the glass ampoule or "milk" the stick in an effort to squeeze more primer out
 - Slowly draw the applicator twice around the surface to be primed to get an even glossy primer film (do not wipe off)
 - Wait 2 minutes for the primer to dry before installing the glass in temperatures down to 0°F (-18°C)
 - If glass is not installed within 24 hours of original priming, clean then reprime the glass with BETAPRIME™ CLEAR Advanced primer; do not reprime more than once
 - When priming glass with BETAPRIME™ CLEAR Advanced primer in temperatures from 0°F (-18°C) to 40°F (4.4°C), the glass should be cleaned at a temperature at or above 40°F (4.4°C) and stored in a manner that will keep it clean and contaminant free
- Note:** On clear glass without any frit, apply two coats of BETAPRIME™ 5504G allowing each coat to dry.

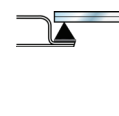
- 4.2**  **Prepare encapsulation or PAAS**
- Clean RIM or PVC encapsulation with BETACLEAN™ GC-800 Glass and Surface Cleaner and a clean, lint-free paper towel
 - "Wet scrub" the encapsulation with an abrasive pad and BETACLEAN™ GC-800 glass cleaner until the gloss is removed from the surface and it appears matte in finish. Clean again with BETACLEAN™ GC-800 to remove any debris on the surface and allow to dry completely.
 - Check the expiration date on the container
 - Apply BETAPRIME™ 5504G All-in-One Primer to the RIM or PVC encapsulation surface with dauber
 - Apply BETAPRIME™ 5504G to any molding surface that contacts new urethane to promote adhesion
 - Allow primer to dry for 2 minutes at 20°F (-7°C) and above and from 20°F (-7°C) down to 0°F (-18°C) allow primer to dry for 6 minutes
 - Replace inner seal and cap on bottle immediately
- Note:** Refer to the DuPont Fixed Glass Installation Guide for instructions on preparing PAAS


- 5**  **Trim back the urethane**
- Clean any dirt and debris from around the existing urethane with BETACLEAN™ GC-800 Glass and Surface Cleaner or water and a clean towel
 - Trim the urethane, leaving a 1 mm to 2 mm base of original equipment urethane on the pinch weld
 - Take care not to damage the vehicle paint or pinch weld
 - Any areas of trimmed urethane that require additional cleaning should be carefully wiped with BETACLEAN™ GC-800 Glass or water and a clean towel


- 6**  **Prepare the pinch weld**
- Once body surface is clean and dry, follow these priming steps:**
- Check the expiration date on the container
- For priming any areas of bare metal (large or small, including scratches):**
- Open the bottle of BETAPRIME™ 5504G All-in-One Primer carefully and insert a clean, unused dauber; to avoid spilling, never pour liquid on dauber
 - Apply one coat of BETAPRIME™ 5504G with a clean wool dauber to any scratches in the paint or large areas of bare metal
 - Allow primer to dry for 2 minutes at 20°F (-7°C) and above. From 20°F (-7°C) down to 0°F (-18°C), allow primer to dry for 6 minutes.
 - Apply second coat of BETAPRIME™ 5504G and allow primer to dry for 2 minutes at 20°F (-7°C) and above. From 20°F (-7°C) down to 0°F (-18°C), allow primer to dry for 6 minutes.


- For priming painted bonding surfaces (Skip this step if using BETASEAL™ ACE applied to clean OEM paint):**
- Open the bottle of BETAPRIME™ 5504G All-in-One Primer carefully and insert a clean, unused dauber; to avoid spilling, never pour liquid on dauber
 - Apply one coat of BETAPRIME™ 5504G All-in-One Primer 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
 - Allow primer to dry for 2 minutes at 20°F (-7°C) and above and from 20°F (-7°C) down to 0°F (-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.

- 7**  **Apply BETASEAL™ Adhesive (Choose either glass or pinch weld application)**
- 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
 - 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 pinch weld perimeter directly on top of the freshly cut original equipment urethane film
 - Either application: Hold the applicator in a vertical position (90°) and dispense the adhesive with a continuous motion in a uniform "V" shaped bead
 - Make sure bead is uniform and has no gaps; add material or gently tool joints, if necessary

- 8**  **Install the glass**
- Carefully place the glass in the body opening
 - Adjust glass to precise alignment
 - Lightly press it into position

- 9**  **Clean up**
- Clean any excess uncured urethane
 - Clean the newly installed glass with BETACLEAN™ GC-800 Glass and Surface Cleaner
 - Clean up any remaining debris or broken glass on seats, floor, door handles and/or dash console

- 10**  **Recordkeeping**
- Attach master lot code sticker to paperwork or manually record primer and adhesive lot numbers
 - Record D.O.T. number from glass part on sticker
 - Communicate to the customer when MDAT will be reached and when the vehicle can be driven

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