



# BETASEAL™ X2500 PLUS (A+B)

## Glass Bonding Systems

BETASEAL™ X2500 PLUS (A+B) is a two-component polyurethane adhesive for glass and structural bonding applications. BETASEAL™ X2500 PLUS (A+B) is a high-viscosity, non conductive adhesive, which cures almost independently of moisture.

BETASEAL™ X2500 Plus has a 1 hour Safe-Drive-Away-Time, crash tested to FMVSS 212 specification with twin airbags.

All DuPont Adhesives 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 must be released in written form by the Technical Service of DuPont Adhesives.

Unless specified otherwise test are conducted at 23°C/50% relative humidity.

### Component A

Basis, Component A	Polyurethane - prepolymers
Colour, Component A	Black
Density, Component A	1.25 - 1.29 g/cm <sup>3</sup>
Extrusion Viscosity, Component A	10 - 26 <sup>[1]</sup> g/min
[1]: At 23°C, 4mm nozzle/ 4bar	

### Component B

Basis, Component B	Polyol compound -
Colour, Component B	Black
Density, Component B	1.19 - 1.23 g/cm <sup>3</sup>
Extrusion Viscosity, Component B	10 - 30 <sup>[1]</sup> g/min
[1]: At 23°C, 4mm nozzle/ 4bar	

### Product information

Solid content	≥96 %
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### Uncured Properties

Sagging	30 <sup>[2]</sup> °
[2]: On vertical wall tilting (maximum).	

### Application technique

Working time	6 - 12 min
Processing temperature	15 - 40 °C

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### Cured properties

Temperature stability	-40 - 100 °C
Volume resistivity	1E10 Ohm.cm

### Typical mechanical properties

Stress at break	5 <sup>[3]</sup> MPa	ISO 1798
Strain at break	150 %	ISO 1798
Shear modulus	≥2.5 MPa	
[3]: After 24 hours		

### Storage and stability

Shelf life	9 <sup>[4]</sup> months
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[4]: Shelf life is assured at +5°C to +25°C in unopened containers. Short time storage temperatures: 0°C to +40°C

### Characteristics

Compatibility	Glass, Paint
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### Additional Information

Adhesives

#### Bonding surface preparation

All bonding surfaces must be free of impurities (dirt, dust, water, oil, grease, release agent and similar contaminants). In general surfaces should be primed. Verify compatibility or consult our technical service department.

#### Application Equipment

BETASEAL X2500 Plus (A + B) is preferably mixed dynamically. A special dynamic mixing head is included with every set. The BETAGUN (TM) electro-mechanical processing device is an application gun that was developed for the processing of BETASEAL X2500 Plus (A + B) sets and ensures optimal processing.

#### Cleaning

Uncured adhesive residues can easily be removed with BETACLEAN™ 3500. Hardened adhesive residues can only be removed mechanically. Immerse equipment in BETACLEAN™ 3000.



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