Dow Automotive

Provisional Technical Datasheet

BETAMATE™ 1640

Crashresistant Structural Adhesive

Description / Application:

BETAMATE™ 1640 is a one component, epoxy based adhesive especially developed for the body shop. The adhesive is used in the car to increase the operation durability, the crash performance and the body stiffness.

Properties:

- Excellent process and storage stability.
- Excellent adhesion to automotive steels, including coated steels and pretreated aluminium with good tolerance to oil and drylubes.
- Helps to increase the stiffness and the crash stability of the entire car body.
- High durability of the adhesive and the adhesive bond.
- Due to its sealing capability the metal and weld points are protected against corrosion.
- Compatible with other mechanical and thermal joining techniques.
- Compatible with the electro coat process and wash off resistant.
- Precureable.
- Until eight weeks open time in the uncured bond

Application:

The product is cold applicable. It can be applied as a bead, can be swirled or jet streamed. It can be applied with the following parameters:

application speed	Until 300 mm/s
temperatures:	**recommended:**
follower plate	30 – 40°C
follower plate - dozer	unheated possible Per heating zone approx. 5°C heat increase. In dozer: 55°C
nozzle	55 - 65°C

For an optimum tack of the adhesive, the parts to bond should be stored at 15°C or higher. In case of a longer application break longer than 2 hours the heating of the application equipment should be switched off.

All Dow Automotive 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 has to be released in written form by the Technical Service of Dow Automotive.

Technical Data:

Basis	epoxy resin
Color	purple
Density 23°C (DIN 52451)	1.22 g/ml
Solid Content	> 99%
Viscosity / Yield stress (45°C, Bohlin, Casson)	approx. 90 Pas / 700Pa
G'-modulus at 0.05% deformation/ η* and tan δ at 10% deformation (Anton Paar MC302; DIN 54458 at 45°C)	59kPa / 380 Pa s/ 1.79
Curing Condition	> 140°C / 30 minutes
Standard Curing	180°C / 30 minutes
Tensile Strength (DIN EN ISO 527-1)	38 MPa
Elongation at Break (DIN EN ISO 527-1)	approx. 5%
E-Modulus (DIN EN ISO 527-1)	approx. 2600 MPa
T_G (DMA on TA Rheometer) 25 – 250°C / 3° / min / 1Hz	116°C
Lap Shear Strength (DIN EN 1465) (IFC 210Y350T-U+GI 0.9mm) Bonding dimension: 25mm x 10mm Adhesive layer thickness: 0.2mm	25 MPa
Lap Shear Strength (DIN EN 1465) (HC220B–ZE–B 0.9mm) Bonding dimension: 25mm x 10mm Adhesive layer thickness: 0.2mm	25MPa
Lap Shear Strength (DIN EN 1465) (AC 170 gebondert 1.2mm) Bonding dimension: 25mm x 10mm Adhesive layer thickness: 0.2mm	24MPa
T-Peel Strength (DIN 11339) (IFC 210Y350T-U+GI 0.9mm) Bonding dimension: 100mm x 25mm Adhesive layer thickness: 0.2mm	10N/mm
Impact Peel Strength (ISO 11343) (IFC210Y350T-U+GI 0.9mm, 23°C, 2m/s) Bonding dimension: 20mm x 30mm Adhesive layer thickness: 0.2mm	34 N/mm
Impact Peel Strength (ISO 11343) (HC220B-ZE-B 0.9mm, 23°C, 2m/s) Bonding dimension: 20mm x 30mm	38N/mm

Adhesive layer thickness: 0.2mm

Bonding Surface Preparation	The material has been designed to tolerate up to 5 g/m^2 of surface oil.
Application Tool	**Cartridges:** hand-operated or pneumatic heated gun with mechanical piston. **Drums, pails:** heated pumping system.
Cleaning	Uncured material can be removed with BETACLEAN 3510. **Attention:** The contact with bonded areas should be avoided.
Containers	Drums, pails: 20 kg, 45 kg and 200 kg (re-usable pails with PE-liner). Cartridges**:** 0,36 kg
Shelf life	Storable at temperatures below 30°C for six months.

The given data are standard values.

Health and Safety:

Bulk Exothermic Reaction

The material curing reaction is exothermic. If the material is held in bulk the reaction is accompanied by a rapid build-up of exothermic heat. To avoid the risk of this bulk exothermy, containers of the material should in no circumstances be heated by e.g. hot plates or simple drum heaters. If heating a bulk quantity of the material is considered necessary, advice should be sought.

Caution

The adhesive resins are generally quite harmless to handle provided that certain precautions normally taken when handling chemicals are observed. The uncured materials must not, for instance, be allowed to come into contact with foodstuffs or food utensils, and measures should also be taken to prevent the uncured materials, from coming into contact with skin, since people with particularly sensitive skins may be affected. The wearing of impervious rubber or plastic gloves will normally be necessary; likewise the use of eye protection. The skin should be thoroughly cleaned at the end of each working period by washing with soap and warm water. The use of solvents is to be avoided. Disposable paper - not cloth towels - should be used to dry the skin. Adequate ventilation of the working area is recommended. For further and more detailed precaution measures see the Health and Safety Data Sheet.

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