



# BETAMATE™ 1620S US

**Description** BETAMATE™ 1620S US is a one component, heat curing, epoxy based adhesive especially developed for the body shop. It is capable of bonding oily galvanized steel.

**Benefits & Features** Provides excellent long term durability, improved uncured humidity resistance, can be dispensed at ambient temperatures, excellent impact-peel strength

**Typical Applications** Bonding of the vehicle body structure and closure hem flange applications.

Uncured Properties	Nominal Value	Unit	Test Method
Color		Red	
Density (23°C)	1.23	g/cm <sup>3</sup>	ASTM D1875-03
Viscosity (45°C, Casson Model)	32	Pa·s	

  

Cured Properties	Nominal Value	Unit	Test Method
Lap Shear Strength <sup>1</sup>	33.0	MPa	ASTM D1002-10
Peel Strength	10.5	N/mm	ASTM D1876
Tensile Modulus	1400	MPa	ASTM D638
Tensile Strength	25.4	MPa	ASTM D638
Tensile Elongation at Break	10	%	ASTM D638

**Application Technique**

The product is swirtable, streamable, and applicable as a bead at temperatures between 20-65°C. It can be applied with the following parameters:

- Temperatures:
- Follower Plate: unheated
- Follower plate to shot meter: Maximum at shot meter 55°C\*
- Nozzle: 45-65°C\*
- For an optimum tack of the adhesive, the parts should be stored at 15°C or higher.

In case of an application break longer than 30 minutes the heating of the application equipment should be switched off.

**Packaging/Sizes Available**

5 gallon metal pails and 55 gallon metal drums with PE liner. Special containers can be supplied upon request from the customer.

**Storage & Stability**

Shelf life dependent upon storage temperatures of the material. Optimal storage conditions are three months at less than 25°C. For complete storage stability capabilities, please refer to Customer Test Report.

**Toxicity and Safety Information**

Read the Safety Data Sheet before using this material. Toxicity and safety information is included in the SDS.

**Food Contact Applications**

Dow Automotive products are not approved for direct or indirect food contact or drinking water applications. If your applications include food contact or drinking water requirements, please contact your Dow representative. For more information on the regulatory status of this product, please refer to the SDS for this product.

**Notes**

These are typical properties only and are not to be construed as specifications. Users should confirm results by their own tests.

<sup>1</sup> HDG: 1.6 mm

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This document is intended for use within North America

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