

## BETAPRIME 5404A Pinchweld and Encapsulation Primer

*BETAPRIME™ 5404A simplifies installations – use for priming pinchwelds, PAAS, RIM and PVC applications.*

BETAPRIME 5404A promotes adhesion to vehicle body and inhibits rust in small nicks and scratches. It activates PAAS (Pre-Applied Adhesive System) beads and promotes adhesion to PVC substrates and RIM encapsulations. BETAPRIME 5404A is easy to use and meets all OEM requirements. It is available in bottles.

Product benefits include:

- ▶ Simplifies applications – use as pinchweld primer, PVC primer and urethane activator for PAAS applications
- ▶ Reduces inventory – carry one primer instead of three
- ▶ Saves money – buy one primer instead of three
- ▶ Meets all long-term durability requirements



Note: exposed bare metal areas over 1/2" x 1/2" (1.3 cm x 1.3 cm) require an etching primer, such as BETAPRIME 5201TF Bare Metal Etch Primer, to restore bond strength and durability.

## BETAPRIME™ 5500 1-Step Glass/Frit Primer

*BETAPRIME 5500 preps and primes the windshield in one pass.*

BETAPRIME 5500 chemically prepares glass and frit to assure optimal chemical link with the adhesive. It is easy to use and meets all OEM requirements. BETAPRIME 5500 is available in bottles or BETAPRIME 5500SA single-application units.

Product benefits include:

- ▶ Saves time – prep and prime the windshield in one pass
- ▶ Saves money – save up to 30% per installation on primer
- ▶ Meets all long-term durability requirements



## BETAPRIME™ 5201TF Bare Metal Etch Primer

*BETAPRIME 5201TF enables shops to keep simple bare metal priming application in house to save time and ensure compatibility.*

BETAPRIME 5201TF primes bare metal areas larger than 1/2" x 1/2" (1.3 cm x 1.3 cm). It cures 50 times faster than two-part bare metal etch primers and is compatible with all BETASEAL™ adhesive systems. BETAPRIME 5201TF is easy to use, toluene free and chromate free. It meets all OEM requirements and is available in bottles.

Product benefits include:

- ▶ One-part bare metal etch primer
- ▶ Primes bare metal in one quick and easy step
- ▶ Fast – dries in 30 minutes or less
- ▶ Meets all long-term durability requirements



Note: when corrosion destroys or reduces the metal's strength and thickness, take the vehicle to an autobody repair facility to restore the rusted area to its original OEM condition.

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## BETAPRIME™ 5404A Pinchweld and Encapsulation Primer

### *Applications*

- ▶ Priming automotive body pinchwelds
- ▶ Integral component of all BETASEAL™ glass bonding systems
- ▶ PAAS system requires BETAPRIME 5404A for the fresh bead of urethane adhesive to adhere to the PAAS bead
- ▶ PVC bonding to urethane adhesive
- ▶ Bonding RIM encapsulation

### *Application details*

- ▶ See vehicle manufacturer's recommendations for additional details. Do not use any other manufacturers' primers, cleaners or other chemicals in conjunction with any BETASEAL adhesive system.
- ▶ Apply at temperatures of 40°F (4.4°C) and warmer

### *Physical properties*

- ▶ Color – black
- ▶ Flash point – 16°F (-7.8°C)
- ▶ Solids content – 26%
- ▶ Density – 7.53 lbs/gal (.9 kg/l)

### *Primer performance properties*

- ▶ Brushability – no voids, bare spots or brush marks
- ▶ Hiding power – complete black-out
- ▶ Open time at room temperature –
  - Minimum: 6 minutes
  - Maximum: 24 hours, if the primed part is properly stored and dust free. To reactivate, apply BETAPRIME™ 5404A again (one time maximum).

## BETAPRIME 5500 1-Step Glass/Frit Primer

### *Applications*

- ▶ Structurally bonded or direct glazed automotive glass, such as windshields, backlites, quarter glass and other stationary glass
- ▶ Use with all BETASEAL adhesives that require auto glass primers. Refer to the appropriate product sheet for details.
- ▶ An open time of longer than 24 hours necessitates reactivating the primer

### *Application details*

- ▶ See vehicle manufacturer's recommendations for additional details. Do not use any other manufacturers' primers, cleaners or other chemicals in conjunction with any BETASEAL™ adhesive system.
- ▶ Apply at temperatures of 40°F (4.4°C) and warmer

### *Physical properties*

- ▶ Color – black
- ▶ Flash point – 14°F (-10°C)
- ▶ Solids content – 35%
- ▶ Density – 8 lbs/gal (.95 kg/l)

### *Primer performance properties*

- ▶ Brushability – no voids, bare spots or brush marks
- ▶ Hiding power – complete black-out
- ▶ Open time at room temperature –
  - Minimum: 6 minutes
  - Maximum: 24 hours, if the primed part is properly stored and dust free. To reactivate, apply BETAPRIME™ 5500 again (one time maximum).

## BETAPRIME 5201TF Bare Metal Etch Primer

### *Applications*

- ▶ Priming bare metal areas larger than one-half square inch on automotive body pinchwelds

### *Application details*

- ▶ See vehicle manufacturer's recommendations for additional details. Do not use any other manufacturers' primers, cleaners or other chemicals in conjunction with any BETASEAL™ adhesive system.
- ▶ Apply at temperatures of 40°F (4.4°C) and warmer

### *Physical properties*

- ▶ Color – light gray-green
- ▶ Flash point – 35°F (2°C)
- ▶ Solids content – 45%
- ▶ Density – 10.3 lbs/gal at 73°F (23°C)

### *Primer performance properties*

- ▶ Brushability – no voids, bare spots or brush marks
- ▶ Hiding power – complete
- ▶ Open time at room temperature –
  - Minimum: 30 minutes
  - Maximum: 8 hours, if the primed part is properly stored and dust free

## Installation instructions



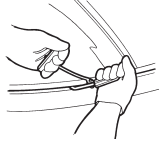
### 1. Wear appropriate safety equipment

- ▶ 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. Clean and inspect replacement glass

- ▶ Use BETACLEAN™ GC-800 Glass & Surface Cleaner and a clean, lint-free paper towel to clean the bonding surface of the glass
- ▶ Inspect replacement glass for defects
- ▶ Verify all primers 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 or body glass using your preferred method
- ▶ Clean any dirt and debris from around the existing urethane

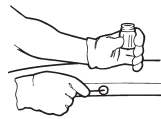


### 4. Dry fit the glass

- ▶ Fit new glass into the opening
- ▶ Determine how to best position the glass
- ▶ Mark this position with "paint safe" tape as guides

### 5. Prepare the glass

- ▶ Use BETACLEAN GC-800 and a clean, lint-free paper towel to clean the bonding surface of the glass
- Note:** if bonding to glass close to encapsulation, "wet scrub" the glass bonding surface
- ▶ If contamination is present, "wet scrub" the bonding surface with an abrasive pad and BETACLEAN GC-800. Apply a second application of BETACLEAN GC-800 and remove with a lint-free paper towel

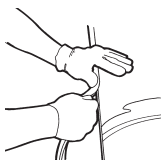


Apply BETAPRIME 5500 or BETAPRIME 5500SA



### 5a. Prime the glass

- ▶ Shake BETAPRIME 5500 1-Step Glass/Frit Primer for **at least one (1) minute** before application
- ▶ Open BETAPRIME 5500 bottle carefully. Insert a clean, unused dauber. To avoid spilling, never pour liquid on dauber.
- ▶ If using single application BETAPRIME 5500SA, activate according to the directions
- ▶ Apply BETAPRIME 5500 along the bond line
- ▶ Replace inner seal and cap on bottle immediately
- ▶ Allow a minimum of **six (6) minutes** for the primer to dry
- ▶ Apply the FlexiTrim™ reveal molding or original molding to the glass, if necessary

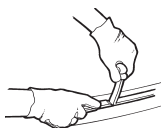


### 5b. Encapsulation and PAAS preparation

- ▶ Clean encapsulation or PAAS bead with BETACLEAN™ GC-800 and a clean, lint-free paper towel
- ▶ "Wet scrub" the encapsulation with an abrasive pad, then clean again with BETACLEAN GC-800. Allow to dry completely

**Note:** skip this step if bonding to PAAS

- ▶ Shake BETAPRIME™ 5404A Pinchweld and Encapsulation Primer for at least **one (1) minute** to ensure contents are thoroughly mixed
- ▶ Apply BETAPRIME 5404A to the encapsulation or PAAS surface with dauber
- ▶ Replace inner seal and cap on bottle immediately
- ▶ Allow a minimum of **six (6) minutes** for the primer to dry
- ▶ Apply reveal molding or original molding to the glass, if necessary



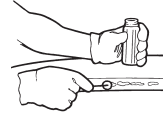
### 6. Trim back the urethane

- ▶ Trim the urethane with an appropriate tool leaving a 1 mm to 2 mm base of original equipment urethane on the pinchweld
- ▶ Take care not to damage the vehicle paint or pinchweld



### 7. Prepare the pinchweld

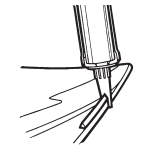
**Note:** exposed bare metal areas over 1/2" x 1/2" (1.3 cm x 1.3 cm) require an etching primer to restore bond strength and durability (See bare metal priming below)



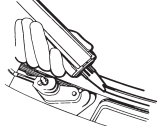
- ▶ Shake BETAPRIME 5404A for at least **one (1) minute** before application
- ▶ Inspect the pinchweld for any bare metal or scratches
- ▶ If found, prime these with BETAPRIME 5404A
- ▶ Open the bottle carefully. Insert a clean, unused dauber. To avoid spilling, never pour liquid on dauber
- ▶ Apply BETAPRIME™ 5404A to scratches along the bond line. Avoid priming existing urethane bead
- ▶ Replace inner seal and cap on bottle immediately
- ▶ Allow a minimum of **six (6) minutes** for the primer to dry

### Bare metal priming:

- ▶ Clean metal surface with an abrasive pad making sure to rough up edges of painted areas
- ▶ Wipe area to be primed with a clean, lint-free paper towel dampened with 100% acetone
- ▶ Allow **two (2) minutes** to flash
- ▶ Shake BETAPRIME 5201TF Bare Metal Etch Primer for at least **one (1) minute** before application
- ▶ Using a clean, unused dauber, apply an even coat of BETAPRIME 5201TF
- ▶ Replace cap on bottle immediately
- ▶ Allow at least **30 minutes** for material to dry. Metal and air must be at least 40°F (4.4°C) for material to flash.
- ▶ Apply a coat of BETAPRIME 5404A on top of the primed area making sure to completely cover BETAPRIME™ 5201TF etching primer
- ▶ Replace inner seal and cap on bottle immediately
- ▶ Allow a minimum of **six (6) minutes** for the primer to dry



Apply to glass or pinchweld



### 8. Apply BETASEAL™ Urethane Adhesive

(Choose either glass or pinchweld application.)

*Glass application:*

- ▶ Hold the applicator in a vertical position (90°) 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

*Pinchweld application:*

- ▶ Hold the applicator in a vertical position (90°) and dispense the adhesive with a continuous motion in a uniform "V"-shaped bead
- ▶ Apply adhesive to the pinchweld perimeter directly on top of the freshly cut original equipment urethane film

*Either application:*

- ▶ Make sure bead is uniform and has no gaps. Add material or tool joints, if necessary.



### 9. Install the glass

- ▶ Apply BETAPRIME 5404A to any molding or encapsulation bonding surface that contacts new urethane to promote adhesion
- ▶ Place the glass in the body opening
- ▶ Use the tape guides to correctly position the glass. Adjust glass to precise alignment.
- ▶ Lightly press it into position
- ▶ Back paddle urethane around edge of glass into gaps
- ▶ Replace the press-in style molding, if required
- ▶ Replace any additional hardware



### 10. Clean up

- ▶ Clean any excess uncured urethane with BETACLEAN U-424 Urethane Adhesive Cleaner
- ▶ Clean the newly installed glass with BETACLEAN GC-800
- ▶ Complete the job paperwork and record lot numbers
- ▶ Release the car to the customer after the appropriate drive-away time elapses

### *Safety precautions*

- ▶ Keep away from heat, sparks or open flame
- ▶ Use only with adequate ventilation
- ▶ Avoid breathing vapors
- ▶ If swallowed, call physician immediately
- ▶ For eye contact, flush with water for 15 minutes and get medical attention
- ▶ Wear appropriate safety equipment, such as gloves and eye protection, or as specified by your company
- ▶ Avoid skin contact; flush with water, if necessary
- ▶ Refer to Material Safety Data Sheet (MSDS) for additional information

### *Shelf life*

- ▶ Maximum shelf life, as stated on product packaging, is achieved when the product is stored at an ambient temperature that does not continuously exceed 110°F (43.3°C)
- ▶ All materials manufactured by or for Dow Automotive have a shelf life. Urethane adhesives and primers are marked with expiration dates. Unopened product is considered within shelf life up to and including the date marked on the product. Product is considered expired past the date marked and should not be used.

### *System compatibility*

- ▶ Use no other manufacturers' primers, cleaners or other chemicals in conjunction with any BETASEAL™ adhesive system

### *Dow Automotive's commitments*

- ▶ The products when shipped meet the then current sales specifications
- ▶ Dow Automotive will notify customer if the sales specifications are changed
- ▶ Dow Automotive will supply customer with current MSDS
- ▶ Dow Automotive conveys the product with good title, free from any lawful lien or encumbrance

### *Packaging*

<b>Product Number</b>	<b>Package Size</b>	<b>Type</b>	<b>Units/ Carton</b>	<b>Cartons/ Case</b>	<b>Approx Weight/Case</b>
5404A	3.4 oz (100 ml)	Bottle	5	5	10 lb (4.5 kg)
5500	1.4 oz (40 ml)	Bottle	10	5	10 lb (4.5 kg)
5500SA	.3 oz (10 ml)	Applicator	12	39	20 lb (9.1 kg)
5201TF	.5 oz (15 ml)	Bottle	5	6	3 lb (1.4 kg)

### *Exclusion of all other warranties*

THE COMMITMENTS IN THE SECTION "DOW'S COMMITMENTS" ARE DOW'S SOLE WARRANTIES RESPECTING THE PRODUCTS AND ARE MADE EXPRESSLY IN LIEU OF AND EXCLUDE ANY IMPLIED WARRANTIES OF MERCHANTABILITY AND FITNESS FOR A PARTICULAR PURPOSE AND ALL OTHER EXPRESS OR IMPLIED REPRESENTATIONS AND WARRANTIES PROVIDED BY STATUTE OR COMMON LAW. CUSTOMER ASSUMES ALL RISKS AND LIABILITIES RESULTING FROM THE USE OF THE PRODUCT DELIVERED HEREUNDER.

### *Limitation of liabilities*

NEITHER PARTY WILL BE LIABLE TO THE OTHER FOR CONSEQUENTIAL, PUNITIVE, SPECIAL, EXEMPLARY OR INCIDENTAL DAMAGES. CUSTOMER'S EXCLUSIVE REMEDY FOR CLAIMS (INCLUDING BREACH OF WARRANTY, NEGLIGENCE AND STRICT LIABILITY) IS LIMITED TO CUSTOMER HAVING THE OPTION OF REPLACEMENT OR REPAYMENT OF THE PURCHASE PRICE PAID FOR THE PRODUCTS WHICH ARE THE SUBJECT OF THE CLAIM.

*We listen. We deliver.*



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