BETASEAL™ 16605
Urethane Adhesive

Automotive Systems

Description
BETASEAL 16605 Urethane Adhesive is a primerless to paint, one component, fast curing, high viscosity adhesive. **BETASEAL 16605** is suitable for stationary glass bonding when used with the appropriate primers. It is resistant to extended outdoor weathering without losing its adhesion and physical characteristics. This adhesive can be used in conjunction with BETASEAL 16100A.

Application Technique
BETASEAL16605 adhesive is applied in bead form with a pressurized flow gun or other suitable application system. Can be applied manually or robotically.

Safety Precautions
Refer to the Material Safety Data Sheets.

Storage
BETASEAL16605 adhesive is a moisture-sensitive material and must be stored in airtight, dry containers at temperatures between 18°C (65°F) and 35°C (95°F). **Do not store outside or in direct sunlight.**

Storage Stability
The shelf life of this material is assured for 6 months (from the date of manufacture) at temperatures not to exceed 35°C (95°F). The material is capable of withstanding a maximum temperature of 43°C for up to three days. Urethane adhesive and primer packages are marked with expiration dates.

Clean-up
If clean-up is required, the uncured material shall be readily removed from production topcoats, glass surfaces, glass inner liners and vinyl top materials with VM&P Naphtha or other solvent agreed upon at time of approval with appropriate engineering groups.

Packaging
Standard packaging is 55 gallon drums.

Physical Properties	
Appearance	Black
Solids Content, Minimum, %	98
Density, lb/gal (kg/L)	10.1 (1.21)
Flash Point Setaflash, °F °C	>230° >110°
Viscosity (Flow Rate), Initial at 23˚C, 50% RH, seconds, [0.157" (4 mm) orifice, 80 psi (550kPa)]	20-50
Sag	None
Tack Free Time, Maximum**,** minutes *At 23℃ and 50% RH*	30

Cured Physical Properties	
Hardness, Shore "A" Durometer, average, *After 7 days at 23℃, 50% RH*	70 ± 6
Elongation at Break, Minimum, % *After RT cure*	>200
Tensile at Break, Minimum, psi (kPa) *After RT cure*	>1015 (7000)

Performance Properties Bonding Systems	
Lap shear Minimum, psi (kPa) *After 3 days at 23°C, 50%RH*	> 500 (3400)

Contact your Dow Automotive Sales Representative for more detailed information.

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