



# BETASEAL™ X2500 PLUS (A+B)

## Glass Bonding Systems

BETASEAL™ X2500 Plus (A+B) is a two-component, rapid room temperature curing polyurethane adhesive designed for multi-material substrate bonding applications where differences are expected in the thermal expansion of dissimilar materials.

BETASEAL™ X2500 Plus (A+B) integrates ideal dissimilar substrate bonding properties like optimized modulus and strength with high elongation. Additional benefits include solvent-free, excellent sag resistance, joint sealing and non-conductive properties.

BETASEAL™ X2500 Plus (A+B) can be used in conjunction with DuPont's primer portfolio to enable durable adhesion to a wide variety of substrates.

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	Black
Density	1.25 - 1.29 g/cm <sup>3</sup>
Extrusion Viscosity, Component A	10 - 40 <sup>[1]</sup> g/min
[1]: At 23°C, 4mm nozzle/ 4bar	

### Component B

Basis, Component B	Polyol compound
Colour	Black
Density	1.19 - 1.23 g/cm <sup>3</sup>
Extrusion Viscosity, Component B	10 - 40 <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).	



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### Application technique

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

### 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	
Lap shear strength	≥4 MPa	DIN EN 1465

[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. Shelf life is calculated from date of manufacture, no minimum shelf life is guaranteed upon dispatch.

### 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) can be dispensed from a bulk dispense system and statically mixed. Due to the viscosity of the product, equipment requirements are application specific. Contact your account representative or DuPont Technical Service for specific information.

#### 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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