

# BETAMATE™ 1480P

## Structural Adhesives

BETAMATE™ 1480P is a one component, highly toughened epoxy based adhesive, especially developed for the body shop. The adhesive is used in the car to increase performance and body stiffness.

### Benefits and Features

BETAMATE™ 1480P has excellent adhesion to a variety of substrates with good tolerance to oily and dry lubes. The product helps increase the stiffness and the crash durability of the entire car body with high durability of the adhesive bond and corrosion protection. It is compatible with other mechanical and thermal joining techniques, compatible with the e-coat process and is wash resistant. It is typically used in all areas of the vehicle body structure.

### Product information

Colour	Purple	
Density	1.24 g/cm <sup>3</sup>	ISO 845

### Typical mechanical properties

Stress at break	32 MPa	ISO 1798
Strain at break	9 %	ISO 1798
Lap shear strength, 3 days	≥32 MPa	DIN EN 1465
Peel strength, T-Peel	12 N/mm	ISO 11339
Peel strength, Impact-Peel	35 N/mm	ISO 11343

### Characteristics

Compatibility	Metals
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### Additional information

Adhesives

#### Surface Preparation

The material has been designed to tolerate up to 5 g/m<sup>2</sup> of surface oil.

#### Application

All Dupont T&I 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 T&I Adhesives.

#### Application Equipment

Cartridges: hand-operated or pneumatic heated gun with mechanical piston  
Drums, pails: heated pumping system

#### Application Parameter

The product is cold pumpable, can be applied as bead / swirl / jet spray. The ideal material temperature for conveying is >18°C.



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It can be processed with the following parameters:

Application speed: up to 500 mm/s

Temperature follower plate: unheated possible; minimum 18°C; max. 35-40°C

Temperature follower plate to doser: Per heating zone 5°C heat increase, max temperature at doser 55°C

Temperature nozzle: 45 - 65°C

For an optimum tack of the adhesive, the parts to bond should be stored at 16°C or higher.

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

### Curing Condition

Standard curing profile is 185C for 20 minutes. However the product will cure under typical body shop paint ovens and a full cure profile is available upon request

### Cleaning

Uncured material can be removed with BETACLEAN 3510. In house solvents can be evaluated upon request

### Delivery Form

Product is available in Drums, Pails or Cartridges

### Storage Stability

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

## DuPont

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