



BETAMATE™ 1486

Structural Adhesives

BETAMATE™ 1486 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 and bonds to all grades of steel and lubricants found under normal body shop conditions.

Features and Benefits

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 exceptional bond durability and corrosion resistance. It has exceptional toughness at temperatures as low as -40C and is compatible with other mechanical and thermal joining techniques. It is also 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	1.22 g/cm ³	ISO 845

Rheological properties

Viscosity, Casson	40 - 70 Pa.s
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Typical mechanical properties

Stress at break	34 MPa	ISO 1798
Strain at break	6 %	ISO 1798
Lap shear strength	≥30 MPa	DIN EN 1465
Peel strength, T-Peel	8 ^[2] N/mm	ISO 11339
Peel strength, Impact-Peel	30 ^[3] N/mm	ISO 11343

[1]: tested on 1.6mm CRS

[2]: Tested on 0.8mm HDG

[3]: tested on 0.8mm HDG

Additional information

Adhesives

Surface Prep

The material is designed for use in the body shop area conditions where it is designed to tolerate typical oily substrates found in the body shop

Application

All Dupont adhesives products are primarily developed in cooperation with the automobile manufacturers, according to their needs and 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 department of DuPont Adhesives

Application Equipment

Cartridges: hand-operated or pneumatic heated gun with mechanical piston



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Application Parameters

The product is cold pumpable and can be applied as bead / swirl / jet-spray. The ideal material temperature for conveying is >18°C. It can be processed with the following parameters:

Application speed: up to 500 mm/s

Temperature follower plate: unheated possible; >18°C

Temperature follower plate to doser: Per heating zone 5°C heat increase, temperature at doser 40-55°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 Conditions

Standard Body shop oven cures are appropriate. Standard cure is 180°C for 30 min.

Cleaning

In house solvents evaluated upon request

Delivery form

Product is available in Drums, Pails or Cartridges

Storability

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.

DuPont

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