



# BETAMATE™1121

## Structural Adhesives

BETAMATE™1121 is a one component heat curable epoxy based adhesive especially developed for use in the automotive body shop.

### Benefits and Features

This adhesive has excellent adhesion to a variety of substrates found in the body shop. It has a good tolerance to both oily and dry lubes. It is compatible with other mechanical and thermal joining techniques and is resistant to wash-off. It is typically used in all areas of the body construction.

### Product information

Colour	Black	
Density	≥1.43 g/cm <sup>3</sup>	ISO 845

### Typical mechanical properties

Tensile Modulus	2800 MPa	ASTM D 638
Tensile Strength	33.0 MPa	ASTM D 412
Lap shear strength	26 MPa	DIN EN 1465
Peel strength, T-Peel	7 <sup>[2]</sup> N/mm	ISO 11339

[1]: Tested on 1.6mm CRS

[2]: Tested on 0.8mm CRS substrate

### Additional information

Adhesives

#### Surface Preparation

The material is designed for use in body shop area conditions where it can tolerate typical oily substrates with no preparation needed

#### 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  
Drums/Pails: Pumping system with zoned heat capability



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### Application Parameters

The product is cold pumpable and can be applied as a bead/swirl/jet spray  
Follower plate temperature is unheated  
Follower plate to doser starts unheated with a gradual increase in temperature to a range of 30 -50 degrees celcius  
Nozzle Temperature between 30-50 degrees celcius

### Curing Condition

Standard cure is 170 degrees celcius for 20 minutes. Minimum and maximum cure ranges are available upon request

### Cleaning

Dry wipe first followed with a solvent wipe  
Inhouse solvents evaluated upon request

### Delivery Form

Product is available in Drums, Pails, or Cartridges

### Storability

Shelf life dependent upon storage temperature of the material. Optimal storage conditions are five months at 25 degrees celcius or less. For complete storage stability conditions requests can be made to DuPont TS&D

## DuPont

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