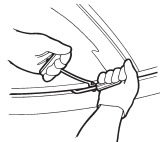




1. Wear appropriate safety equipment
 - ▶ **Protect yourself.**
 - ▶ **Wear safety equipment, such as work gloves, Nitrile chemical-resistant gloves, safety glasses, work apron or other protection required by your company or safety regulations.**



2. Clean and inspect replacement glass
 - ▶ **Use BETACLEAN* GC-800 Glass & Surface Cleaner and a clean, lint-free paper towel to clean the bonding surface of the glass.**
 - ▶ Inspect replacement glass for defects.
 - ▶ Verify all primers and adhesives are within **use-by dates.**



3. Cut out the glass
 - ▶ Protect the customer's vehicle.
 - ▶ Remove all hardware and reveal moldings.
 - ▶ **Cut out the windshield or body glass using your preferred method.**
 - ▶ **Clean any dirt and debris from around the existing urethane.**



4. Dry fit the glass
 - ▶ **Fit new glass into the opening.**
 - ▶ Determine how to best position the glass.
 - ▶ Mark this position with "paint safe" tape as guides.

5. Prepare the glass
 - ▶ **Use BETACLEAN GC-800 and a clean, lint-free paper towel to clean the bonding surface of the glass.**
 - Note: If bonding to glass close to encapsulation, "wet scrub" the glass bonding surface.**
 - ▶ **If contamination is present, gently "wet scrub" the bonding surface with an abrasive pad and BETACLEAN GC-800. Apply a second application of BETACLEAN GC-800 and remove with a lint-free paper towel.**

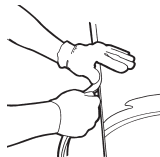
Important: If using BETASEAL* U-418 or BETASEAL U-418HV Primerless to Auto Glass Urethane Adhesive, proceed to step 5b.



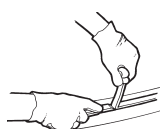
Apply BETAPRIME 5500 or BETAPRIME 5500SA



- 5a. Prime the glass
 - ▶ Shake BETAPRIME* 5500 1-Step Glass/Frit Primer for **at least one (1) minute** before application.
 - ▶ Open BETAPRIME 5500 bottle carefully. Insert a **clean, unused dauber.** To avoid spilling, never pour liquid on dauber.
 - ▶ If using single application BETAPRIME 5500SA, activate according to the directions.
 - ▶ **Apply BETAPRIME 5500 along the bond line.**
 - ▶ Replace inner seal and cap on bottle immediately.
 - ▶ **Allow a minimum of six (6) minutes** for the primer to dry.
 - ▶ Apply the FlexiTrim™ reveal molding or original molding to the glass, if necessary.



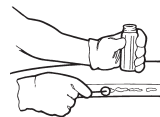
- 5b. Encapsulation and PAAS preparation
 - ▶ **Clean encapsulation or PAAS bead with BETACLEAN GC-800 and a clean, lint-free paper towel.**
 - ▶ Gently "wet scrub" the encapsulation with an abrasive pad, then clean again with BETACLEAN GC-800. **Allow to dry completely.**
 - Note: Skip this step if bonding to PAAS.**
 - ▶ Shake BETAPRIME 5404 Pinch weld and Encapsulation Primer for **at least one (1) minute** to ensure contents are thoroughly mixed.
 - ▶ Apply BETAPRIME 5404 to the encapsulation or PAAS surface with dauber.
 - ▶ Replace inner seal and cap on bottle immediately.
 - ▶ **Allow a minimum of six (6) minutes** for the primer to dry.



6. Trim back the urethane
 - ▶ **Trim the urethane with an appropriate tool leaving a 1 mm to 2 mm base of Original Equipment urethane on the pinch weld.**
 - ▶ Take care not to damage the vehicle paint or pinch weld.



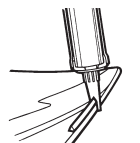
7. Prepare the pinch weld
 - ▶ **Note: Exposed bare metal areas over 1/2" x 1/2" (1.3cm x 1.3cm) require an etching primer to restore bond strength and durability. (See bare metal priming below.)**



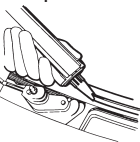
- ▶ Shake BETAPRIME 5404 for **at least one (1) minute** before application.
- ▶ Inspect the pinch weld for any bare metal or scratches.
- ▶ If found, prime these with BETAPRIME 5404.
- ▶ Open the bottle carefully. Insert a **clean, unused dauber.** To avoid spilling, never pour liquid on dauber.
- ▶ **Apply BETAPRIME 5404 to scratches along the bond line. Avoid priming existing urethane bead.**
- ▶ Replace inner seal and cap on bottle immediately.
- ▶ **Allow a minimum of six (6) minutes** for the primer to dry.

Bare metal priming:

- ▶ Clean metal surface with an abrasive pad making sure to rough up edges of painted areas.
- ▶ Wipe area to be primed with a **clean, lint-free paper towel** dampened with 100% acetone.
- ▶ **Allow two (2) minutes** to flash.
- ▶ Shake BETAPRIME U-5201 Bare Metal Etch Primer for **at least one (1) minute** before application.
- ▶ Using a **clean, unused dauber,** apply an even coat of BETAPRIME U-5201.
- ▶ Replace cap on bottle immediately.
- ▶ **Allow at least 30 minutes** for material to dry. Metal and air must be at least 40°F (4.4°C) for material to flash.
- ▶ Apply a coat of BETAPRIME 5404 on top of the primed area making sure to completely cover BETAPRIME U-5201 etching primer.
- ▶ Replace inner seal and cap on bottle immediately.
- ▶ **Allow a minimum of six (6) minutes** for the primer to dry.



Apply to glass or pinch weld



8. Apply BETASEAL urethane adhesive **(Choose either glass or pinch weld application.)**

Glass Application:

- ▶ Hold the applicator in a vertical position (90°) and dispense the adhesive with a continuous motion in a uniform "V" shaped bead.
- ▶ Apply adhesive to the glass on top of the bond line.

Pinch weld Application:

- ▶ Hold the applicator in a vertical position (90°) and dispense the adhesive with a continuous motion in a uniform "V" shaped bead.
- ▶ Apply adhesive to the pinch weld perimeter directly on top of the freshly cut Original Equipment urethane film.

Either Application:

- ▶ Make sure bead is uniform and has no gaps. Add material or tool joints, if necessary.



9. Install the glass
 - ▶ Apply BETAPRIME 5404 to any molding or encapsulation bonding surface that contacts new urethane to promote adhesion.
 - ▶ **Place the glass in the body opening.**
 - ▶ Use the tape guides to correctly position the glass. Adjust glass to precise alignment.
 - ▶ **Lightly press it into position.**
 - ▶ **Backpaddle urethane around edge of glass into gaps.**
 - ▶ Replace the press-in style molding, if required.
 - ▶ Replace any additional hardware.



10. Clean up
 - ▶ **Clean any excess uncured urethane with BETACLEAN U-424 Urethane Adhesive Cleaner.**
 - ▶ **Clean the newly installed glass with BETACLEAN GC-800.**
 - ▶ Complete the job paperwork and record lot numbers.
 - ▶ Release the car to the customer after the appropriate drive away time elapses.

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