

BETASEAL U-216 Urethane Adhesive

Supplement for Cold Weather Installations

For ambient
temperature
between 0°F (-17.8°C)
and 40°F (4.4°C).



1. If there is inclement weather (snow, ice, rain, mist, fog, etc.), perform glass installations in a controlled environment to assure proper adhesion

2. Prior to preparation, check replacement glass for moisture trails or condensation

3. Wear appropriate safety equipment

See step 1 of the *BETASEAL U-216 Urethane Adhesive Installation Instructions*.

4. Clean and inspect replacement glass

See step 2 of the *BETASEAL U-216 Urethane Adhesive Installation Instructions*.

5. Cut out the glass and trim back the urethane

See step 3 of the *BETASEAL U-216 Urethane Adhesive Installation Instructions*.

6. Dry fit the glass

See step 4 of the *BETASEAL U-216 Urethane Adhesive Installation Instructions*.

7. Prior to preparation, check pinchweld for condensation

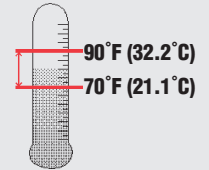
Confirm surfaces are dry and free of contaminants.

8. Follow standard procedures for pinchweld preparation and glass installation

See steps 5-6 of the *BETASEAL U-216 Urethane Adhesive Installation Instructions*.

9. Make sure the BETASEAL urethane adhesive is between 70°F (21.1°C) and 90°F (32.2°C)

Best application
temperature
for U-216



10. Follow normal installation procedures using U-216

See step 7 of the *BETASEAL U-216 Urethane Adhesive Installation Instructions*.

11. Install the glass

See step 8 of the *BETASEAL U-216 Urethane Adhesive Installation Instructions*.

12. Turn defroster ON and allow to run for a minimum of 15 minutes

At temperatures below 40°F (4.4°C) warm defroster air accelerates initial cure and ensures a good urethane adhesive bond between the pinchweld and glass.

13. Clean up

See step 9 of the *BETASEAL U-216 Urethane Adhesive Installation Instructions*.

14. When following these procedures below 40°F (4.4°C), U-216 drive away time is 60 minutes with a passenger side air bag and 30 minutes without a passenger side air bag in weather above 0°F (-17.8°C)

⚠ CAUTION

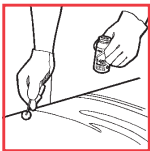
Always check the vehicle owner's manual for cautions and warnings from the manufacturer.

⚠ WARNING

Condensation can immediately reform on the surfaces. If condensation cannot be fully removed, the vehicle must be allowed to reach ambient temperature. Complete the installation in a controlled environment if you cannot eliminate condensation or contaminants.

🔧 Note

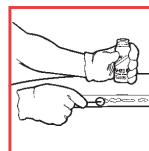
To improve primer curing in cold weather:



A. Replacement Glass. Glass may be pre-primed in the shop prior to leaving the facility. Inspect the glass primer on the windshield when you reach the site. If contaminated with moisture, dust, fingerprints or other foreign material, re-prime the glass using only U-402 or U-459 (depending on whether the one- or two-step priming procedure was used). The primer remains active for up to 8 hours. After 8 hours, re-apply the primer and allow it to dry prior to installation.

⚠ CAUTION

Primer solvents do not flash as quickly in lower temperatures. Visually inspect to make sure the primers are dry prior to completing the installation.



B. Pinchweld. Prime scratched or bare-paint areas with U-413. Warm the primed area on the pinchweld slightly with an industrial heat gun until it is above 40°F (4.4°C). Heat allows solvents to flash and primer to cure.

See *Essex ARG Technical Installation Guide* or the *Fixed Glass Installation Guide* for complete details.

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