Adhesive solutions
BODO MÖLLER CHEMIE is a specialist for adhesive systems and applications in many industrial areas, especially in the automotive, railway, aerospace, medical and electronics industries. We offer a wide range of solutions specifically tailored to structural, semi-structural or elastic bonding of different materials like metal, glass, composites, wood and plastic.

We support customers with individual services such as design of adhesive joints and testing in our adhesive laboratory, process testing and troubleshooting, customer-specific training as well as preparation and implementation of certification audits in accordance with DIN 6701 and DIN 2304.
Adhesive solutions

Epoxy resin adhesives (EP)
- Araldite® Epoxy resin adhesives (1C / 2C)
- Araldite® Epoxy core and edge fillers (2C)*
- BETAMATE™ Epoxy resin adhesives (1C / 2C)
- Epibond® Epoxy resin adhesives (2C)
- Epocast® Epoxy core and edge fillers (1C / 2C)*
- LOCTITE® Epoxy resin adhesives (2C)
  * partially with FR/FST fire properties

Polyurethane adhesives (PUR)
- Araldite® Polyurethane structural adhesives (2C)
- BETAFLII™ Polyurethane sealants (1C)
- BETAFORCE™ Polyurethane structural adhesives, high modulus (2C)
- BETALINK™ Polyurethane semi-structural adhesives (1C / 2C)
- BETAMATE™ Polyurethane structural adhesives (1C / 2C)
- BETASEAL™ Polyurethane adhesives for direct glazing (1C / 2C)
- Uralane® Polyurethane adhesives (2C)

Methyl methacrylate adhesives (MMA)
- Agomet® Methyl methacrylate adhesives (No-Mix / 2C)
- Araldite® Methyl methacrylate adhesives (2C)

Anaerobic adhesives
Anaerobic adhesives and sealants

Cyanoacrylate adhesives
- LOCTITE® Cyanoacrylate

Phenolic resins & polycondensation adhesives
- Araldite® Phenolic polycondensation adhesives

Hybrid adhesives & sealants
- BETAMATE™ Silane-modified polymer adhesives (1C)
- LOCTITE® Hybrid adhesives (2C)
- L&L Seal Silane-modified polymer adhesives (1C)
- PACTAN Silane-modified polymer adhesives (1C)

Silicone adhesives & high temperature silicones
- Bluesil™ RTV silicones (2C)
- CAF® Silicone adhesives (1C / 2C)
- Dowsil™ Silicone adhesives and sealants
- PACTAN Silicone adhesives and sealants (1C / 2C)

UV-curing adhesives
- LOCTITE® UV-Alkoxy silicones
- LOCTITE® UV-Cyanoacrylate
- LOCTITE® Acrylate
- LOCTITE® Acrylate Urethane

Not all products are available in all countries. Please contact our sales representatives for more information.
Hotmelt & packaging adhesives

**Advanta**® Packaging hotmelts
**Swift®melt** Hotmelts
**Swift®therm** Hotmelts
**Aquence**® Water-based adhesives
**Euromelt**® Polyamide hotmelt adhesives
**Technomelt**® Hotmelts

Sealants

**BETAFLII™** Polyurethane sealants
**BETAFLII™** Polyurethane seam sealer (1C)
**BETAGUARD™** Rubber-based sealants, relining adhesives
**Bluesil™** RTV silicones (2C)
**CAF**® Silicone adhesives (1C / 2C)
**CeraPur**® Polyurethane foam gasket (1C)
**DowSil™** Silicone adhesives and sealants
**L&L** Acoustic sealants
**L&L** Core splice adhesives
**L&L** Hybrid sealants
**L&L** Room temperature curing sealants/adhesives
**PACTAN** Silicone and hybrid sealants
**RTF** Silicone foam gasket (2C)

Products for pretreatment & posttreatment of adhesive surfaces

**BETABRADE™** Contamination and silicone remover
**BETACLEAN™** Surface cleaners
**BETAPRIME™** Primer
**BETAWIPE™** Activators
**BONDERITE®** Cleaners
**BONDERITE®** Pretreatment technologies
**LOCTITE®** Activators & cleaners
**LOCTITE®** Polyolefin primer for pretreatment

Not all products are available in all countries. Please contact our sales representatives for more information.
For any application

The construction with adhesives joints has several advantages compared to conventional joining technologies. Adhesives are suitable for bonding a variety of different materials. With the correct surface treatments most metallic, glass, plastic and polymer composite materials can all be joined to either themselves or each other with joint strengths superior to other joining techniques.

Due to the continuous nature of adhesive bonding, it helps reducing high stress concentrations that occur in mechanical fastening systems and results in stiffer joints and structures. Superior fatigue resistance can be achieved compared with welded or riveted joints. A continuous bead of adhesive can also provide sealing properties. In addition to the mechanical properties, bonding also brings aesthetic advantages. Compared to welding or mechanical fasteners, the adhesive seam can be applied invisibly.

Adhesive family properties comparison

<table>
<thead>
<tr>
<th>Adhesive Family</th>
<th>Speed</th>
<th>Substrate Diversity</th>
<th>Stability</th>
<th>Safe Handling</th>
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</thead>
<tbody>
<tr>
<td>1C-Epoxy resin adhesives (EP)</td>
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<tr>
<td>2C-Epoxy resin adhesives (EP)</td>
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<tr>
<td>Polyurethane adhesives (PUR)</td>
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<td>Methyl methacrylate adhesives (MMA)</td>
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<td>Phenolic resins &amp; polycondensation adhesives</td>
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<td>Hotmelt adhesives</td>
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<tr>
<td>Anaerobic adhesives</td>
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</tbody>
</table>

- = good  ◼ = medium  ▲ = bad
# Advantages and applications of adhesive systems

<table>
<thead>
<tr>
<th>Adhesive System</th>
<th>Advantages</th>
<th>Applications</th>
</tr>
</thead>
<tbody>
<tr>
<td>1C-Epoxy resin adhesives (EP)</td>
<td>High strength, crash-stable</td>
<td>Automotive, General Industry</td>
</tr>
<tr>
<td>2C-Epoxy resin adhesives (EP)</td>
<td>High strength, very versatile, environmental resistance, cure speed</td>
<td>General Industry, Aerospace, BTR, Automotive and many other industries</td>
</tr>
<tr>
<td>1C-Polyurethane adhesives (PUR)</td>
<td>High flexibility, perfect strength too, elongation ratio, easy to use, humidity cure</td>
<td>Glass Bonding, General Industry, BTR, Automotive and many other industries</td>
</tr>
<tr>
<td>2C-Polyurethane adhesives (PUR)</td>
<td>High flexibility, perfect strength too, elongation ratio, humidity independent cure</td>
<td>Glass Bonding, General Industry, BTR, Automotive and many other industries</td>
</tr>
<tr>
<td>No-mix Methyl methacrylate adhesives (MMA)</td>
<td>Snap cure after open time, long pot life due no-mix process</td>
<td>General Industry, Aerospace, BTR, Automotive and many other industries</td>
</tr>
<tr>
<td>2C-Methyl methacrylate adhesives (MMA)</td>
<td>Snap cure after open time, very versatile, good adhesion properties without pretreatment</td>
<td>General Industry, Aerospace, BTR, Automotive and many other industries</td>
</tr>
<tr>
<td>Phenolic resins &amp; polycondensation adhesives</td>
<td>Very high temperature resistance</td>
<td>Automotive, Brake Bonding</td>
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<tr>
<td>Silicone adhesives &amp; high temperature silicones</td>
<td>Flexible and high temperature resistant, easy to use</td>
<td>General Industry, Aerospace and many other industries</td>
</tr>
<tr>
<td>Hybrid adhesives &amp; sealants</td>
<td>Flexible, easy to use, EHS friendly, very wide adhesion properties</td>
<td>General Industry, BTR, Automotive and many other industries</td>
</tr>
<tr>
<td>Cyanoacrylate adhesives</td>
<td>Very fast adhesion built up, extremely versatile</td>
<td>General Industry, BTR, Automotive and many other industries</td>
</tr>
<tr>
<td>UV-curing adhesives</td>
<td>«On demand» cure possible, very fast cycle times possible</td>
<td>Medical, Glass &amp; PC, PMMA Bonding</td>
</tr>
<tr>
<td>Hotmelt adhesives</td>
<td>Very fast cycle times</td>
<td>Electronics, Packaging</td>
</tr>
<tr>
<td>Sealants</td>
<td>High flexibility, easy to use</td>
<td>General Industry, BTR, Automotive and many other industries</td>
</tr>
<tr>
<td>Anaerobic adhesives</td>
<td>Unlimited open time on air, only reacts when in contact with reactive surfaces</td>
<td>Threadlocker in every industry</td>
</tr>
<tr>
<td>Products for pretreatment &amp; posttreatment</td>
<td>High guarantee of bonding quality</td>
<td>Should be checked in every bonding process</td>
</tr>
</tbody>
</table>

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**Do you need support in selecting a suitable product for your application?** Please contact our technical consultants for detailed product information, samples and process advice. We will be pleased to support you.
Designing strong bonds

**Loading of adhesive joints** — The strength of an adhesive bonding strongly depends on the direction and distribution of the stresses formed in the joint as a result of the loads applied to it. Typical forces are illustrated below. In practice, a bonded structure has to simultaneously sustain a combination of forces.

Strong bonded joints need to be designed that the loading stresses will be directed along the lines of the adhesive’s greatest strengths. A poorly designed joint can lead to high-stress concentrations in the joint itself and/or in the substrates connected. Adhesives are more resilient under shear, compression and tension stresses. Cleavage and peel loading are the most severe as they concentrate the applied force into a single line of high stress.

**Surface preparation and pretreatment** are decisive factors for the strength and fatigue performance of an adhesive bond. In order to ensure an optimum wetting on the substrate, a thorough surface preparation is required to remove contaminations, offer a clean surface and increase the bonding area and surface energy of the substrate. Common surface preparation methods are degreasing, abrading and special pretreatments. BODO MÖLLER CHEMIE offers a wide range of cleaners and surface technologies to provide adhesive joints an optimum strength and reliability.

**Degreasing**
The removal of oil or greases residues from the surface is essential but should be combined to other surface preparation like mechanical abrasion followed by loose particle removal or chemical pretreatment for optimizing the bonding.

Degreasing methods: Vapor degreasing, solvent immersion, brush or wipe with degreasing agent, detergent degreasing, alkaline degreasing, ultrasonic degreasing

**Abrading**
Lightly abraded surfaces provide better anchoring to adhesives than highly polished surfaces. After abrading the surface further treatment methods are required to ensure complete loose particles removal, like degreasing operation, lightly brushing with a clean soft brush or vacuum cleaning.

Abrading methods: Grit blasting, wire brush, abrasive cloth, abrasive paper

**Special pretreatments**
Degreasing and abrading methods are sufficient for most adhesive joints. In order to obtain maximum strength, reproducibility and long-term resistance to deterioration, a chemical or electrolytic pretreatment may be required.

Metal: Acid etching, anodising, primer applications
Plastics/composites: Low pressure plasma, atmospheric plasma, corona treatment, flame treatment
The specialists of our Adhesive Competence Center support customers in the design and construction of adhesive joints with extensive product and application know-how, FEM calculation and application tests in our Adhesive Laboratory.
With our Adhesive Competence Center, we offer full service in all matters related to adhesive application technology – from product selection all the way to product validation, process simulation and engineering data.

The Adhesive Competence Center is certified for the designing of bonding joints according to DIN 2304 S1 and DIN 6701-2 A1 and our Adhesive Laboratory has a Competence Approval for DIN 2304 S1 and DIN 6701-2 A1. All measurements are carried out in accordance with international DIN, EN and ISO standards.

**Determination of construction data**
- Long-term laboratory tests to determine the technical properties of adhesives as a basis for the calculation of adhesive joints

**Design & construction of adhesive joints**
- Calculation of structural and elastic adhesive joints
- Preparation of construction drawings

**Process design, process testing & troubleshooting**
- Support in setting up bonding processes
- Examination of existing bonding processes, fault analysis
- Optimization of bonding processes

**Laboratory tests**
- Testing of adhesive joints according to all common test methods
- Reference measurements
- Diagnosis of adhesion problems on the substrate

**Implementation & auditing according to DIN 6701/DIN 2304**
- Support for the qualification of production sites
- Preparatory audits, valid as independent pre-audit

**Seminars & training**
- Customer-specific seminars and laboratory trainings
- Trainings for production, quality control, construction
QUALITY & SAFETY

ISO 9001 Quality management
ISO 14001 Environmental management
ISO 45001 Occupational health & safety

EN 9120 Distribution and repacking for aviation industry
DIN 6701 Adhesive bonding of railway vehicles (laboratory)
DIN 2304 Quality requirements for adhesive bonding processes (laboratory)

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State 01/2020
Regional offices

GERMANY
Bodo Möller Chemie GmbH
Headquarters
Offenbach a. M.
Phone +49 69 838326-0
info@bm-chemie.de

AUSTRIA / SLOVENIA
Bodo Möller Chemie Austria GmbH
Korneuburg (Austria)
Phone +43 2262 61998
info@bm-chemie.at

SWITZERLAND
Bodo Möller Chemie Schweiz AG
Winterthur
Phone +41 52 2031930
info@bm-chemie.ch

FRANCE
Bodo Möller Chemie France SAS
Sales Office Ruaudin
Phone +33 243 240429
bureau@bm-chemie.fr
Sales Office Lyon
Phone +33 478 982337
bureau@bm-chemie.fr

BENELUX
Bodo Möller Chemie Benelux N.V.
Antwerpen (Belgium)
Phone +32 3 2352135
info@bm-chemie.be

UNITED KINGDOM / IRELAND
Bodo Möller Chemie UK Ltd.
Winsford
Phone +44 1606 532115
info@bm-chemie.co.uk

DENMARK
Bodo Möller Chemie Denmark Aps
Stenløse
Phone +45 48 163470
info@bm-chemie.dk

SWEDEN / NORWAY
Bodo Möller Chemie Sweden AB
Källered (Sweden)
Phone +46 31 698952
info@bm-chemie.se

FINLAND / ESTONIA
Bodo Möller Chemie Finland Oy
Helsinki (Finland)
Phone +358 9 6829010
info@bm-chemie.fi

POLAND / LITHUANIA / LATVIA
Bodo Möller Chemie Polska Sp. z o.o.
Suchy Las (Poland)
Phone +48 61 8220975
info@bm-chemie.pl
Adhesive Competence Center & Laboratory
Poznań (Poland)
Phone +48 61 6722143
info@bm-chemie.pl

CZECH REPUBLIC / SLOVAKIA
Bodo Möller Chemie Czech & Slovakia, s.r.o.
Sales Office Bratislava (Slovakia)
Phone +421 2 33006732
info@bm-chemie.sk
Sales Office Prague (Czech Republic)
Phone +420 2 209 045301
info@bm-chemie.cz

HUNGARY
Bodo Möller Chemie Hungary Kft.
Tatabánya
Phone +36 34 782019
info@bm-chemie.hu

CROATIA
Bodo Möller Chemie Austria GmbH
Podružnica Zagreb
Phone +385 91 2620276
info@bm-chemie.at

RUSSIA
Bodo Möller Chemie Russia LLC
Moscow
Phone +7 495 9885850
info@bm-chemie.ru

INDIA
Bodo Moeller Chemie India Pvt. Ltd.
Mumbai
Phone +91 22 49741848
info@bm-chemie.in

CHINA
Bodo Moeller Chemie (Shanghai) Co., Ltd.
Shanghai (P.R. China)
Phone +86 21 64750182
info@bm-chemie.cn
Bodo Moeller Chemie Hong Kong Ltd.
Hong Kong
Phone +86 21 64750182
info@bm-chemie.hk

ISRAEL
BM Chemie Israel Ltd.
Tel Aviv
Phone +972 77 6935501
info@bm-chemie.co.il

MIDDLE EAST
Bodo Möller Chemie Middle East FZE
Dubai (UAE)
Phone +971 4 8813833
info@bm-chemieae

EGYPT
Bodo Moeller Chemie Egypt SAE
Bodo Moeller Chemie Egypt Import Ltd.
Sales Office Cairo
Phone +20 2 226963-91 / -92 / -93
info@bm-chemie.com.eg
Bodo Moeller Chemie Egypt SAE
Sales Office Alexandria
Phone +20 3 29022061 / +20 3 2902210
info@bm-chemie.com.eg
Production Plant Sadat City
Phone +20 2 28560337
info@bm-chemie.com.eg

MOROCCO
Bodo Moeller Chemie Morocco SARLAU
Casablanca
Phone +212 522 262732
info@bm-chemie.ma

KENYA
Bodo Moeller Chemie Kenya Ltd.
Nairobi
Phone +254 723 392566
info@bm-chemie.co.za

SOUTH AFRICA / SUB-SAHARA REGION
Bodo Möller Chemie South Africa (PTY) Ltd.
Sales Office Port Elizabeth
Phone +27 41 3641335
info@bm-chemie.co.za
Sales Office Johannesburg
Phone +27 11 275 0745
info@bm-chemie.co.za

USA
Bodo Moeller Chemie Corp.
Duluth, Georgia
Phone +1 770 2952888
info-us@bm-chemie.com

MEXICO
Bodo Möller Chemie México, S. de R.L. de C.V.
Puebla
Phone +52 222 2405168
info@bm-chemie.mx