Technical Data Guide

MASTER® BUILDERS SOLUTIONS

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Joint Sealants

MasterWeld® 620

Versatile one component, elastomeric adhesive/sealant

FORMERLY DEGASEAL™ 2000

PACKAGING
313 mL cartridges (10.3 fluid ounces), 24 cartridges per case

COLORS
Available in clear, white, slate, black; for availability of other colors, contact Master Builders Solutions Customer Service.

YIELD
A 313 mL cartridge seals 24 lineal feet in a 1/4 by 1/4" joint.

STORAGE
Store below 120° F (49° C).

SHELF LIFE
Cartridges: 24 months

BRUSH GRADE
Brush grade also available in 1 gallon cans.

DESCRIPTION
MasterWeld 620 is a multi-purpose, elastomeric adhesive/sealant which provides excellent performance on a wide variety of substrates and applications.

PRODUCT HIGHLIGHTS
- One component formulation provides enhanced application efficiency
- Withstands 25% total joint movement for use on moving joints and seams
- Bonds similar and dissimilar materials, including aluminum, glass, vinyl, ceramic, porcelain, plastics, rubber, painted metals, wood, fiberglass and composite materials, providing job site versatility
- Fast drying and tack-free in as little as 25 minutes for faster project completion
- Paintable within minutes to minimize process time and labor cost

APPLICATIONS
- Assembly of Metal buildings and metal roofing
- Assembly of Manufactured housing
- Various truck, bus, and trailer assemblies
- Rail car and cargo container assemblies

LOCATION
- Interior and exterior

SUBSTRATE
- Aluminum
- Glass
- Vinyl
- Ceramic
- Porcelain
- Plastics
- Rubber
- Wood
- Fiberglass and composite materials

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Technical Data

Composition

MasterWeld 620 is a co-polymer sealant/adhesive.

Compliances

- Federal Specification TT-S-00230C, Type II, Class B
- ASTM C920, Types Grade NS, Class 12.5 use NT, M, A and O

Test Data

PROPERTY	RESULTS	TEST METHOD
Extrusion rate, grams/second	40–45	ASTM C 603
Density, lbs/gallon	8.2 ±0.1	ASTM D 1475
Tack free time, minutes	25 ±5	ASTM C 679
Skin time, minutes	25 ±3	Industry method
Vertical sag	None	ASTM C 2202
Hardness, Shore A	50 ±5	ASTM C 661
Tensile strength, psi	325 ±25	ASTM D 412
Elongation, %	550 ±50	ASTM D 412
Peel adhesion, pli	27 ±3	ASTM C 794
Bond durability, %	25% total joint movement	ASTM C 719
Artificial weathering, Xenon arc, 500 hours	No change	ASTM C 793

Test results are averages obtained under laboratory conditions. Reasonable variations can be expected.

HOW TO APPLY

SURFACE PREPARATION

Surfaces must be dry and free of dirt, dust, debris, grease, peeling paint and any contaminants that could inhibit adhesion. Surface temperature must be above 40° F (4° C) for best results.

APPLICATION

1. MasterWeld 620 is a solvent-borne synthetic rubber adhesive specifically formulated to provide long-lasting bonds for sealing manufactured housing, metal buildings, RV's, trucks, trailers, buses and around openings in door windows and air conditioners. MasterWeld 620 bonds to a wide variety of substrates and is especially suited for waterproofing roofs, sidewall lap seams, bonding roof bows, waterproofing rivet seams and general purpose use.
2. MasterWeld 620 comes ready to use. Do not open cartridges until preparatory work is completed. Cut nozzle to create the appropriate size bead. Puncture inner seal at base of nozzle. Apply bead, forcing MasterWeld 620 against the interfaces to be sealed to ensure full contact adhesion. Do not introduce air pockets to adhesive/sealant bead.
3. If necessary, MasterWeld 620 can be tooled immediately with a putty knife dampened with mineral spirits.
4. To ensure solid, positive adhesion, temporary bracing or mechanical fasteners may be required until adhesive cures.

CURING

Tack free: 25 ± 3 minutes
Paintable: Within minutes
Handleable: 16–24 hours
Full cure: 14 days
All times listed are dependent on temperature and humidity. Times referenced above assume 70° C (21° C) F and 50% relative humidity.

FOR BEST PERFORMANCE

- Joints should be designed to a maximum of 1/2" by 1/2".
- When using MasterWeld 620 between windows and mortar or as an expansion joint seal, the use of backup material is necessary to provide the maximum 1/2" joint depth.
- MasterWeld 620 is a flexible adhesive/ sealant designed for dynamic joint movement; consequently, application of brittle paints may cause surface cracking.
- MasterWeld 620 bonds well to most substrates, however, it is strongly recommended to check the adhesion of the cured sealant on specific substrates.
- Make certain the most current versions of product data sheet and SDS are being used; call Customer Service (1-800-433-9517) to verify the most current version.
- Proper application is the responsibility of the user. Field visits by Master Builders Solutions personnel are for the purpose of making technical recommendations only and not for supervising or providing quality control on the jobsite.

HEALTH, SAFETY AND ENVIRONMENTAL

Read, understand and follow all Safety Data Sheets and product label information for this product prior to use. The SDS can be obtained by visiting www.master-builders-solutions.com/en-us, e-mailing your request to mbsbscst@mbcc-group.com or calling 1(800)433-9517. Use only as directed.

IN CASE OF EMERGENCY: Call CHEMTEL +1 (800) 255-3924 or if outside the US or Canada, +1 (813) 248-0585.

LIMITED WARRANTY NOTICE

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Master Builders Solutions Construction Systems US, LLC 889 Valley Park Drive, Shakopee, MN 55379
www.master-builders-solutions.com/en-us
Customer Service +1 (800) 433-9517
Technical Service +1 (800) 243-6739

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