



PRODUCT DATA SHEET

SikaBond®-620

(formerly MWeld 620)

VERSATILE ONE COMPONENT, ELASTOMERIC ADHESIVE/SEALANT

PRODUCT DESCRIPTION

SikaBond®-620 is a multi-purpose, elastomeric adhesive/sealant that provides excellent performance on a wide variety of substrates and applications.

USES

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

Location

- Interior and exterior

Substrate

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

CHARACTERISTICS / ADVANTAGES

- 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

APPROVALS / STANDARDS

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

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September 2024, Version 02.01

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PRODUCT INFORMATION

Chemical Base	SikaBond®-620 is a co-polymer sealant/adhesive.
Packaging	313 mL cartridges (10.3 fluid ounces), 24 cartridges per case Brush grade is also available in 1 gallon cans.
Shelf Life	Cartridges: 24 months
Storage Conditions	Store below 120° F (49° C).
Color	Available in clear, white, slate, and black; for availability of other colors, contact Sika Customer Service.
Density	8.2 ±0.1 lbs/gallon (ASTM D 1475)

TECHNICAL INFORMATION

Shore A Hardness	50 ±5 (ASTM C 661)
Tensile Strength	325 ±25 psi (ASTM D 412)
Elongation at maximum tensile stress	550 ±50 % (ASTM D 412)
Movement Capability	Bond durability 25% total joint movement (ASTM C 719)
Adhesion in peel	27 ±3 pli (ASTM C 794)
Resistance to Weathering	No change, xenon arc, 500 hours (ASTM C 793)
Extrusion rate	40–45 grams/second (ASTM C 603)

APPLICATION INFORMATION

Coverage	A 313 mL cartridge seals 24 linear feet in a 1/4 by 1/4" joint.
Sagging	None (ASTM C 2202)
Cure Time	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
Skin Time / Laying Time	25 ±3 minutes (Industry method)
Tack Free Time	25 ±5 minutes (ASTM C 679)

BASIS OF PRODUCT DATA

Results may differ based upon statistical variations depending upon mixing methods and equipment, temperature, application methods, test methods, actual site conditions and curing conditions.

ENVIRONMENTAL, HEALTH AND SAFETY

For further information and advice regarding

transportation, handling, storage and disposal of chemical products, user should refer to the actual Safety Data Sheets containing physical, environmental, toxicological and other safety related data. User must read the current actual Safety Data Sheets before using any products. In case of an emergency, call CHEMTREC at 1-800-424-9300, International 703-527-3887.

APPLICATION INSTRUCTIONS

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NOTES ON INSTALLATION

- Joints should be designed to a maximum of 1/2" by 1/2".
- When using SikaBond®-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.
- SikaBond®-620 is a flexible adhesive/ sealant designed for dynamic joint movement; consequently, the application of brittle paints may cause surface cracking.
- SikaBond®-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 the product data sheet and SDS are being used; call Customer Service to verify the most current version.
- Proper application is the responsibility of the user. Field visits by Sika personnel are for the purpose of making technical recommendations only and not for supervising or providing quality control on the jobsite.

SUBSTRATE 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. SikaBond®-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. SikaBond®-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. SikaBond®-620 comes ready to use. Do not open cartridges until preparatory work is completed. Cut the nozzle to create the appropriate size bead. Puncture the inner seal at the base of the nozzle. Apply bead, forcing SikaBond®-620 against the interfaces to be sealed to ensure full contact adhesion. Do not introduce air pockets to adhesive/sealant beads.
3. If necessary, SikaBond®-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 the adhesive cures.

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LEGAL DISCLAIMER

- KEEP CONTAINER TIGHTLY CLOSED
- KEEP OUT OF REACH OF CHILDREN
- NOT FOR INTERNAL CONSUMPTION
- FOR INDUSTRIAL USE ONLY
- FOR PROFESSIONAL USE ONLY

Prior to each use of any product of Sika Corporation, its subsidiaries or affiliates ("SIKA"), the user must always read and follow the warnings and instructions on the product's most current product label, Product Data Sheet and Safety Data Sheet which are available at usa.sika.com or by calling SIKA's Technical Service Department at 1-800-933-7452. Nothing contained in any SIKA literature or materials relieves the user of the obligation to read and follow the warnings and instructions for each SIKA product as set forth in the current product label, Product Data Sheet and Safety Data Sheet prior to use of the SIKA product.

SIKA warrants this product for one year from date of installation to be free from manufacturing defects and to meet the technical properties on the current Product Data Sheet if used as directed within the product's shelf life. User determines suitability of product for intended use and assumes all risks. User's and/or buyer's sole remedy shall be limited to the purchase price or replacement of this product exclusive of any labor costs. **NO OTHER WARRANTIES EXPRESS OR IMPLIED SHALL APPLY INCLUDING ANY WARRANTY OF MERCHANTABILITY OR FITNESS FOR A PARTICULAR PURPOSE. SIKA SHALL NOT BE LIABLE UNDER ANY LEGAL THEORY FOR SPECIAL OR CONSEQUENTIAL DAMAGES. SIKA SHALL NOT BE RESPONSIBLE FOR THE USE OF THIS PRODUCT IN A MANNER TO INFRINGE ON ANY PATENT OR ANY OTHER INTELLECTUAL PROPERTY RIGHTS HELD BY OTHERS.**

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