

PRODUCT DATA SHEET

SikaBond[®]-622

(formerly MWeld 622)

MULTI-PURPOSE, FLEXIBLE POLYURETHANE ADHESIVE/SEALANT

PRODUCT DESCRIPTION

SikaBond[®]-622 is a polyurethane-based, one-component, moisture-curing adhesive/sealant. It maintains permanent flexibility with a high bond strength that provides outstanding durability.

USES

- Multi-purpose construction-grade adhesive
- Various truck, bus, and trailer assemblies
- Railcar and cargo container assemblies

Location

- Interior and exterior

Substrate

- Concrete
- Masonry
- Wood
- Clay & concrete roof tiles
- Aluminum

PRODUCT INFORMATION

Chemical Base	SikaBond [®] -622 is a multi-purpose polyurethane flexible adhesive/sealant. Base: Synthetic rubber-resin
Packaging	<ul style="list-style-type: none"> ▪ 300 mL cartridges, 12 cartridges per case ▪ 20 oz. sausages, 20 sausages per case
Shelf Life	<ul style="list-style-type: none"> ▪ Cartridges: 1 year when stored in unopened containers at 75 °F (24 °C) and 50% relative humidity. ▪ Sausages: 1 year when stored in unopened containers at 75 °F (24 °C) and 50% relative humidity.
Storage Conditions	Protect unopened containers from heat and direct sunshine. In cool or cold weather, store containers at room temperature for at least 24 hours before

CHARACTERISTICS / ADVANTAGES

- Permanently flexible for long-lasting durability
- Compatible with a variety of paints to achieve desired aesthetic performance
- Primerless adhesion eliminates an installation step to improve the process and application time
- Low VOC for use in all regions

APPROVALS / STANDARDS

- ASTM C 557-73
- Federal Specification TT-S-00230C, Type II, Class A
- ASTM C 920-87, Type S, Grade NS, Class 25, Use NT, M and A

using.

Color	White, black, bronze and aluminum gray. For special orders of other colors, contact Customer Service.	
Density	9.85 ±0.1 lbs per gallon	(ASTM D 1475)
Solid content by mass	80 ±2%	(ASTM D 1259)
Viscosity	2,800 ±500 poise (trowelable)	(ASTM D 2393)

TECHNICAL INFORMATION

Shore A Hardness	25–30	(ASTM C 661)
Tensile Strength	350 psi	(ASTM D 412)
Elongation at break	800%	(ASTM D 412)
Movement Capability	±25%	(ASTM C 719)
	Bond Durability	
	±25% no failures on glass, aluminum, and concrete	(ASTM C 719)
Shear Strength	Lap Shear	
	Wet lumber	225 psi (ASTM D 1002)
	Dry lumber	250 psi
	Plywood/concrete	140 psi
	Plywood/drywall	160 psi
	Plywood/aluminum	100 psi
Service Temperature	-40°F to 200°F (-40°C to 93°C)	
Resistance to Weathering	No elastomeric property change after 3,000 hours (Atlas 6500 xenon arc model)	
Design Considerations	Exterior Perimeter Sealing	
	Pass	(AAMA 808.3)
Extrusion rate	Extrudability	
	3 seconds	(ASTM C 603)

APPLICATION INFORMATION

Coverage	A 300 mL cartridge seals 24 lineal feet in 1/4" by 1/4" (6 by 6 mm) joint	
Sagging	Rheology	
	No vertical sag at 120 °F	(ASTM C 639)
Open Time	20 ±5 minutes, depending on temperature and humidity	
Curing Rate	<ul style="list-style-type: none">▪ 16 hours: 100 °F (38 °C), 95% relative humidity▪ 1 day: 70 °F (21 °C), 55% relative humidity▪ 3 days: 40 °F (4 °C), 50% relative humidity▪ Cure through times are based on a 1/4" (6 mm) diameter bead.	
Tack Free Time	Passes maximum 72 hrs	(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

NOTES ON INSTALLATION

- Do not apply over freshly treated wood; it must have weathered for at least 6 months.
- SikaBond®-622 should not come into contact with oil-based caulking, silicone sealants, polysulfides, or fillers impregnated with oil, asphalt, or tar.
- Do not use in joints deeper than 1/2".
- SikaBond®-622 is not recommended for continuous water immersion.
- Make certain the most current versions of the product data sheet and SDS are being used.
- 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

1. Surfaces must be dry, clean, and free of dirt, moisture, loose particles, oil, grease, asphalt, tar, paint, wax, rust, waterproofing, or other contaminants.
2. On metal surfaces, remove scale, rust, or other coatings to expose a bright white surface. Aluminum window frames are frequently coated with a clear lacquer that must be removed before the application of SikaBond®-622.
3. Clean concrete, stone, and other masonry surfaces by grinding, sandblasting, or wire brushing. Expose a sound surface free of contamination and laitance.
4. Wood surfaces must be clean and sound. Scrape away any paint to bare wood.

APPLICATION METHOD / TOOLS

Caulking gun or power pump

APPLICATION

1. SikaBond®-622 bonds well to a variety of substrates and is ideally suited for use in interior/exterior joints, waterproofing overlap seams, fascia, and other structural components. SikaBond®-622 remains permanently elastic for long-lasting performance.
2. Surface temperatures above 40 °F (4 °C) are recommended during application. SikaBond®-622 can be applied below freezing temperatures only if substrates are completely dry, free of moisture, and clean.
3. SikaBond®-622 comes ready to use. Do not open cartridges until preparatory work has been completed. Trim nozzle to desired size opening. Place cartridge in dispensing gun and puncture seal inside nozzle.
4. Fill joints from the deepest point to the surface by holding a properly sized nozzle against the back of the joint.
5. Dry tooling is recommended.

CLEANING OF TOOLS

Immediately after use, clean the equipment with the appropriate solvent. Use proper precautions when handling solvents. Cured sealant can be removed by cutting with a sharp-edged tool. Thin films by abrading.

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**

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Product Data Sheet

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