



FULAFLEX 620

Description

Fulaflex 620 is a high performance, isocyanate free methoxysilyl-terminated silane polymer designed for use as a low-modulus construction sealant. Fulaflex 620 cures to form a seal that is tough, elastic and weatherproof with good chemical resistance. Fulaflex 620 is suitable for use in situations that may experience significant expansion and contraction. Fulaflex 620 is easy to apply and tool off.

Benefits

- ISO 11600 Type F, Class 25, sub-class LM
- Tested to AS1530.3-1999 (Report 21-002528)
 - Spread of Flame Index = 0
 - Heat Evolved Index = 3
 - Smoke Developed Index = 2
- Meets the criteria of a sealant for use in AS3740-2010 (Waterproofing of Domestic Wet Areas) waterproofing applications
- Isocyanate and solvent free
- Highly flexible - $\pm 25\%$ of original joint width.
- Excellent resistance to weathering and UV radiation, resists yellowing
- Mould Resistant – Will not support fungal growth
- Excellent long term chemical resistance to seawater, caustic solutions and cleaning agents
- Short term chemical resistance to petrol, grease and mineral oils
- No bubble formation when curing
- Paintable with high build, flexible emulsion coatings

- Does not sag or slump in joints up to 35mm
- Strong adhesion
- Sag Resistant

Uses

- Sealing expansion and control joints in tiling, walls, roofs, wall, door and window frame perimeters, cladding and brickwork.
- In applications where a level of chemical resistance is required.
- In seals where acoustic properties is required.
- As a waterproofing perimeter fillet beneath waterproofing membranes (refer to HB Fuller technical department for specific membrane recommendations) including those required to satisfy AS3740-2010
- As a sealant in fibre cement façade systems (pre-testing recommended – refer to HB Fuller sales representative or technical department)

VOC Content

VOC content: (Californian South coast air quality management rule 1168) is 15g/L.

Compatible Substrates

Concrete	Ceramic
Cement sheeting	Plastics (pretest)
Masonry	ABS
Plasterboard	Aluminium
Steel	Glass
Timber	XPS & EPS Polystyrene

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Performance Data

Property	Data
Polymer Base	STP Polymer
Specific Gravity	ca. 1.45
Sag	Nil @ 25°C
Shrinkage	0%
Skin time	ca. 30-40 minutes @23°C / 50% RH
Cure Rate	>2 mm / day @ 23°C / 50% RH
Full Cure	After 7 days
Storage Life	12 months unopened
Durometer Hardness	ca. Shore A 25
Service Temperature	-40°C to 100°C
Modulus – 50%	ca. 0.2MPa
Modulus – 100%	ca. 0.3MPa
Max. Tensile Strength	ca. 1.4MPa
Elongation (ISO 37)	>450%
Application temperature	5°C to 40°C

Coverage

Approximate linear meters coverage of Fulaflex 625 sealant as per table:

Joint Width mm	Joint Depth mm	Yield (440g cartridge) (Linear metres)	Yield (600ml sausage) (Linear metres)
6 (min)	6	8.4	16.7
10	10	3.0	6.0
12	12	2.1	4.2
18	12	1.4	2.7
24	12	1	2.1
30	15	0.7	1.5

Pack Sizes

Fulaflex 620 is available in 440g cartridges and 600ml sausages.

Surface Preparation

All surfaces must be clean, dry, sound and free of dust, oil, old sealant or other contamination.

Lightly contaminated surfaces should be wiped with Isopropyl Alcohol (IPA) using the 2-rag wipe method. Apply IPA to a clean lint-free cloth and wipe onto the surface to be cleaned to solubilize and remove the majority of the contaminant. A clean dry cloth should then be applied to remove remaining contamination and dry the surface. Ensure wet cleaner is not allowed to dry on surface. For more heavily contaminated surfaces or where the IPA does not remove the contaminant, a generic wax and grease remover should be applied using the same 2-rag wipe method. Once this has been completed the surface should be given a final clean with IPA using the 2-rag wipe method to ensure the surface is adequately prepared.

Adhesion to metals and some surface finishes can be further improved by light abrasion prior to cleaning with IPA using the 2 rag-wipe method. Manufacturers of plastics should be consulted about suitable cleaning solvents. Adhesion to plastics should be pre-tested. Mask either side of joint to produce a neat finish.

Use a suitable sized foam backing rod or polyethylene bond breaker tape to prevent three sided joint contact impeding the free and even deformation of the sealant in a cyclic joint. Open-cell polyurethane foam is recommended. Use a size 25% wider than the joint width that will compress when inserted into the joint.

Joint Design

A good joint design is imperative if a sound, durable seal is to be achieved

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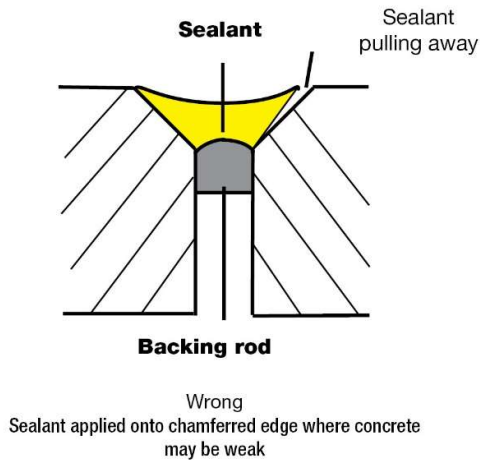
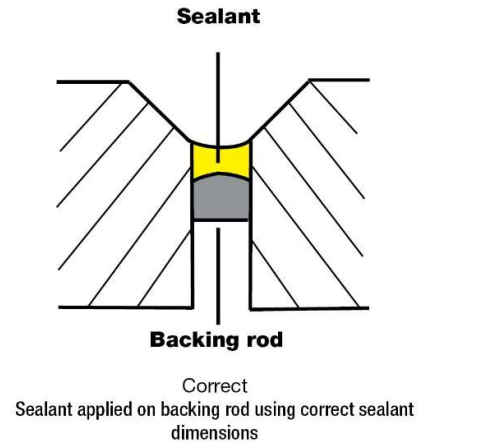


In general, joints should be designed to be at least 4 times as wide as the anticipated movement.

Joint width and depth should not be less than 6 mm and depth should never exceed width.

Joint Width.	Recommended Joint Depth.
< 10 mm	Depth = Width
10 mm - 35 mm	Width/Depth ratio 2:1

Correct and incorrect joint designs



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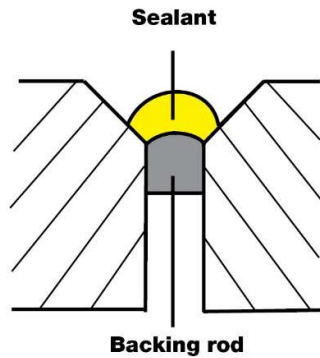
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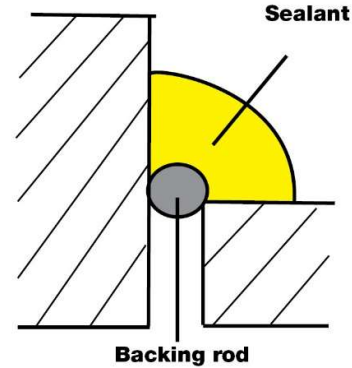
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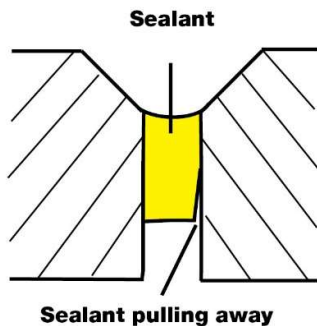
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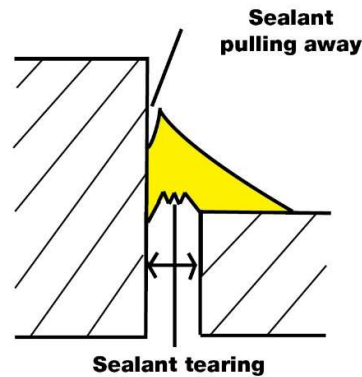
Correct
Alternative method of installation preserves ability of sealant to expand and contract



Correct
Sealant applied between two walls with backing rod to support movement



Wrong
Sealant extends too deep into joint leading to tearing away from sides or splitting



Wrong
Sealant applied without backing rod, or where excessive movement occurs, allows sealant to split away from the wall edges and tear

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Product Application

Cut tip off cartridge. Angle cut nozzle to desired size. Screw nozzle onto cartridge. Apply sealant in a steady, continuous flow by pushing the sealant ahead of the nozzle so that it completely fills the joint and is in contact with both sides. Immediately after application, tool the sealant using a spatula. A dilute soap/water detergent solution may be used to tool Fulaflex 620, although the solution should be pre-tested to confirm it does not affect the sealant in any way, as this can compromise long-term durability. Avoid contact with alcohol or other solvent cleaners during cure. Remember to remove the masking tape before the sealant skins.

Painting

Flexible, acrylic-based emulsion coatings are best over Fulaflex 620. Less flexible interior coatings are likely to crack due to their inflexibility.

Oil based coatings and coatings containing a solvent are likely to remain tacky for an extended period when used over Fulaflex 620.

Chemical Resistance

Long-term chemical resistance to fresh water, salt water, limewater, caustic solutions and cleaning agents. Short-term chemical resistance to petrol, grease and mineral oil. Not resistant to organic acids, concentrated mineral acids or solvents.

Clean Up

Best results are obtained by masking prior to sealing to avoid the necessity for clean up. However, if sealant is applied to areas where

it is unwanted, clean up uncured sealant using toluene*, xylene*, methyl ethyl ketone*, acetone* or mineral turpentine* and a cloth. Take precautions to avoid staining substrates when using solvents. Cured sealant should be removed by abrasion or trimmed with a sharp knife. Do not undercut seal.

Limitations

- Avoid exposure to high levels of chlorine
- Do not use in joints deeper than 20 mm
- Avoid contact with alcohol and other solvent cleaners during cure phase
- Pre-testing is required on marble or other highly porous stone - finish may be affected
- Solvent-based coatings may remain tacky
- Do not use on bituminous surfaces
- Do not use on materials that bleed oil and plasticisers or solvents, as this will affect adhesion (e.g. most rubbers)
- Not a fire rated or glazing sealant. Not suitable for glazing use with glass, acrylic or polycarbonate sheets
- Not suitable for floor applications or foot traffic areas
- Not suitable for use in roofing lap joint applications where the sealant is feathered down to zero application weight – for such applications consider the use of silicone.
- Not suitable for swimming pools or hot tubs

Safety Information

This product is not considered hazardous under the classification of GHS WHS Version 8. Further safety information is available on the product SDS. Avoid contact with skin and eyes. Store in a dry place below 30°C. Keep out of reach of children. An MSDS is available

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