



## DOLPHIN WS 620 WEATHER SEALANT

**DOLPHIN WS 620 WEATHER SEALANT** is a one-part, neutral curing, high performance silicone sealant used in general construction. It is suitable for interior and exterior applications such as general glazing, weather sealing in curtain wall and building façades, and expansion joints. **DOLPHIN WS 620 WEATHER SEALANT** has superior weather resistance, virtually unaffected by sunlight, rain, snow, ozone.



### TECHNICAL PROPERTIES

Properties	Test Method	Unit	Specifications
Chemical Base			1-C Silicone
Cure Mechanism			Moisture
Cure Type			Alkoxy
<i>As Supplied @ 25°C, 50% RH</i>			
Color			Black
Consistency			Homogeneous paste
Specific Gravity	ASTM D 1475		1.50 ± 0.02
Flow Properties	ASTM C 639	mm	0 (Non-sag)
Skin Over Time	ASTM C 679	minutes	Approx. 6
Tack Free Time	ASTM C 679	minutes	Approx. 9
Depth Cure, 24 hrs	Lab Test	mm	~ 2.5
<i>As Cured – 7 Days @ 25°C, 50% RH</i>			
Hardness (Shore A)	ASTM D 2240	Points	38 – 43
Tensile Strength	ASTM D 412	N/mm <sup>2</sup>	≤ 2.00
Elongation	ASTM D 412	%	≤ 600
Young's Modulus	ASTM D 412	MPa	≤ 0.40
Service Temp.		°C	-40 to +250

*Note:*

\* Curing time (Skin Over Time & Tack Free Time) may vary depending on climatic condition during application.

\* Information on this data sheet is subject to change without prior notice and should not be used for writing specifications.

### TYPICAL USES

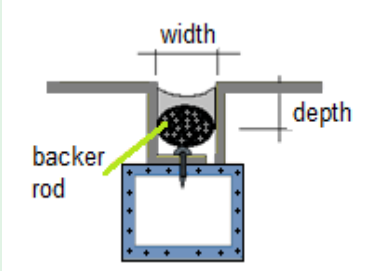
- Suitable for external weather sealing
- Used in some metals for construction without danger of corrosion from the sealant.
- Ideal for expansion, connection, perimeter and other movement joints.
- External walling and cladding joints.
- Curtain walling and sealing around window and door frames.

### KEY FEATURES

- Non-corrosive
- Neutral cure/low odor
- Non-sag
- Extremely durable
- Primerless adhesion to most materials
- Resistant to ozone, ultra-violet radiation and temperature extremes
- Joint movement capability ± 50%



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<b>COLORS</b>	<b>DOLPHIN WS 620 WEATHER SEALANT</b> is available in Black color. *Special color orders may require lead time and minimum order quantities.
<b>PACKAGING</b>	<b>DOLPHIN WS 620 WEATHER SEALANT</b> is available in standard caulking cartridges, packed sausages (600ml) and 200 Liter drum.
<b>SURFACE PREPARATION</b>	The substrate areas that will be in contact with sealant must be clean, dry and free of all loose materials, dust, dirt, rust, oil and other contaminants. Non-porous substrates should be cleaned with a solvent and a clean, lint-free, cotton cloth. Wipe dry immediately with another such cloth before the solvent evaporates from the surface. Porous surfaces may need to be grinded, free of dust and cleaned.
<b>JOINT DESIGN</b>	<p>For General Use:</p> <ul style="list-style-type: none"> <li>• joints up to 12 mm wide, width to depth ratio = 1:1  <math display="block">\frac{width}{depth} = \frac{1}{1} \text{ or } w = d</math> </li> <li>• joints over 12 mm wide, width to depth ratio = 2:1  <math display="block">\frac{width}{depth} = \frac{1}{0.5} \text{ or } w = 2d</math> </li> </ul> <div style="text-align: right;">  </div> <p>Install backing material, spacer, or joint filler to ensure correct depth to width ratio is achieved according to design. Backing materials provide back pressure and avoid three sided adhesion that limits sealants movement capability. Apply masking tapes to areas adjacent to joints to ensure neat sealant lines.</p>
<b>TOOLING AND FINISHING</b>	Immediately tool sealant after application and before skin formation. Tooling of sealant should be done in one continuous stroke. Remove masking tape immediately after tooling is completed.
<b>CLEANUP AND REMOVAL</b>	Uncured sealant may be removed from tools, equipment and non-porous surfaces with solvents. For porous substrates, allow the sealant to cure before removal by peeling or other mechanical means. Cured sealant can only be removed mechanically.
<b>LIMITATIONS</b>	Not paintable. Substrate compatibility test is always recommended.
<b>STORAGE AND SHELF LIFE</b>	When stored in original unopened container at or below 77°F (25°C) in dry warehouse conditions, <b>DOLPHIN WS 620 WEATHER SEALANT</b> has a shelf life of 12 months from manufacturing date. Containers should always be kept sealed when not in use.
<b>HANDLING PRECAUTIONS</b>	Use in well-ventilated area. Direct contact of uncured sealant may irritate eyes and skin. Over exposure to vapor may irritate eyes, nose and throat. Do not

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handle contact lenses with sealant on hands. In case of eye contact, flush eyes with water for 15 minutes. Obtain medical attention. In case of skin contact, remove from skin and flush with water.

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**KEEP OUT OF REACH OF CHILDREN • KEEP CONTAINER TIGHTLY CLOSED • FOR INDUSTRIAL & PROFESSIONAL USE**

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The information and data contained herein is believed to be accurate and reliable; however, it is the user's responsibility to determine suitability of use. Since the supplier cannot know all the uses, or the conditions of use to which these products may be exposed, no warranties concerning the fitness or suitability for a particular use or purpose are made. AMI reserves the right to change the properties of its products without notice.

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