



DOLPHIN 630 STRUCTURAL GLAZING SEALANT

DOLPHIN 630 STRUCTURAL GLAZING SEALANT is a single-component, neutral-cure, high modulus silicone sealant ideal for a wide variety of glazing applications. **DOLPHIN 630 STRUCTURAL GLAZING SEALANT** offers fast through-cure and exceptional tensile strength. It is designed to meet the stringent performance needs for both 2- and 4-sided structural and protective glazing. It is utilized in unitized curtain wall manufactured in plant or a field-glazed project. All structural glazing applications must be reviewed and approved by AMI Technical Services.



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, White
Consistency			Homogeneous paste
Specific Gravity	ASTM D 1475		1.40 ± 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. 10
Depth Cure, 24 hrs	Lab Test	mm	~ 2.2
<i>As Cured – 7 Days @ 25°C, 50% RH</i>			
Hardness (Shore A)	ASTM D 2240	Points	28 – 33
Tensile Strength	ASTM D 412	N/mm ²	≤ 1.10
Elongation	ASTM D 412	%	≤ 650
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.

BENEFITS

- Produces a tough, flexible rubber cure for a tenacious, watertight seal.
- No mixing required for immediate application
- Meets the currently accepted engineering standards for structural glazing.
- Maintains elastomeric structural joints sealant properties permanently, even under harsh conditions.

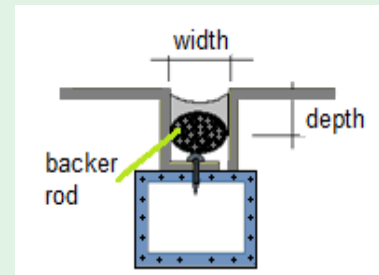
KEY FEATURES

- One-component product
- Odorless and non-corrosive cure system
- VOC Compliant
- Resistant to ozone, ultra-violet radiation and temperature extremes
- High strength silicone sealant has a very good adhesion properties to a broad range of building substrates.
- Excellent UV Stability
- Long Life Reliability



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<p>COLORS</p>	<p>DOLPHIN 630 STRUCTURAL GLAZING SEALANT is available in Black and White color. *Special color orders may require lead time and minimum order quantities.</p>
<p>PACKAGING</p>	<p>DOLPHIN 630 STRUCTURAL GLAZING SEALANT is available in standard caulking cartridges, packed sausages (600ml) and 200 Liter drum.</p>
<p>SURFACE PREPARATION</p>	<p>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.</p>
<p>JOINT DESIGN</p>	<p><u>For General Use:</u> The sealant must be able to withstand the expected joint movement. The joint movement capability of DOLPHIN 630 STRUCTURAL GLAZING SEALANT is ± 50. The recommended sealant depth to width ratio for is normally half the joint width. The minimum recommended joint depth is 6mm and the maximum is 15mm.</p> $\text{width to depth ratio} = 2:1$ $\frac{\text{width}}{\text{depth}} = \frac{1}{0.5} \text{ or } w = 2d$ <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>
<p>TOOLING AND FINISHING</p>	<p>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.</p>
<p>CLEANUP AND REMOVAL</p>	<p>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.</p>
<p>LIMITATIONS</p>	<p>Not paintable. Substrate compatibility test is always recommended.</p>
<p>CLASSIFICATIONS/ STANDARDS</p>	<p>DOLPHIN 630 STRUCTURAL GLAZING SEALANT meets or exceeds the requirements of the following specification for a one-part sealant.</p> <ul style="list-style-type: none"> • ASTM C1184: Type S, Use G and O • ASTM C920: Type S, Grade NS, Class 35, Use NT, A, G, O • Meets low VOC Rating



**DOLPHIN 630 STRUCTURAL GLAZING SEALANT****STORAGE AND
SHELF LIFE**

When stored in original unopened container at or below 77°F (25°C) in dry warehouse conditions, **DOLPHIN 630 STRUCTURAL GLAZING SEALANT** has a shelf life of 12 months from manufacturing date. Containers should always be kept sealed when not in use.

**HANDLING
PRECAUTIONS**

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 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.

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

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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