

TECHNICAL DATA SHEET

DOLPHIN 630 Structural Glazing Sealant

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PRODUCT DESCRIPTION

Dolphin 630HP is a single - component, neutral cure, high modulus silicone sealant. It is highly flexible with Joint movement Capability 50%. Hence, ideal for a wide verity of glazing applications. Dolphin 630HP is designed to meet the stringent performance needs for both 2- and 4-sided structural and protective glazing.

TECHNICAL PROPERTIS



Properties	Test Method	Unit	Specifications
Chemical Base			1-C Silicone
Cure Mechanism			Moisture
Cure Type			Alkoxy
Joint Movement Capability <i>As Supplied @ 25°C, 50% RH</i>	ASTM C 719	%	±50
Color			Black, White
Consistency			Homogeneous paste
Density	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	~ 2.5
<i>As Cured – 7 Days @ 25°C, 50% RH</i>			
Hardness (Shore A)	ASTM D 2240	Points	30 – 35
Tensile Strength	ASTM D 412	N/mm ²	< 1.30
Elongation	ASTM D 412	%	≤ 650
Young's Modulus	ASTM D 412	MPa	< 0.40
Service Temp.		°C	-40 to +250
Application Temp.		°C	5 to 45

Note:

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

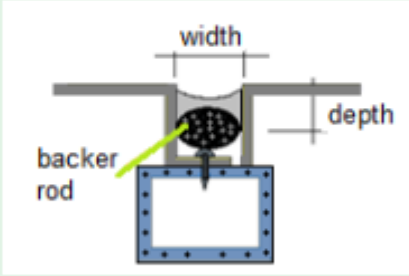
* Information on this data sheet is subject to change without prior notice and should not be used for writing specifications

TYPICAL USES

- Structural Glazing
- Protective Glazing
- Curtain Walling
- Double glazed glass insulation

KEY FEATURES

- Non-Corrosive
- Negligible Shrinkage
- High-Flexibility
- High adhesion

COLORS	DOLPHIN 630 Structural Glazing Sealant is available in Black and White color. *Special color orders may require lead time and minimum order quantities
PACKAGING	DOLPHIN 630 Structural Glazing Sealant is available in standard caulking cartridges, packed sausages (600ml) and 200 Liter drum.
SURFACE PREPARATION	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
JOINT DESIGN	<p>For General Use:</p> <p>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> <p style="text-align: center;">width to depth ratio = 2:1</p> $\frac{\text{width}}{\text{depth}} = \frac{1}{0.5} \text{ or } w = 2d$ <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> 
COVERAGE	Coverage in Linear Meter = $\frac{\text{Material Volume (ml)}}{\text{Width (mm) X Depth (mm)}}$
BACK-UP MATERIAL	The backing material shall be closed cell polyethylene foam backer rod
TOOLING AND FINISHING	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.
CLEANUP AND REMOVAL	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.
LIMITATION	Not Paintable. Substrate compatibility test is always recommended.
CLASSIFICATIONS / STANDARDS	DOLPHIN 630 Structural Glazing Sealant meets or exceeds the requirements of the following specification for a one-part sealant. <ul style="list-style-type: none"> • ASTM C1184: Type S, Use A, G, NT ,M and O • ASTM C920: Type S, Grade NS, Class 50, Use NT, A, G, O,M • Meets low VOC Rating
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



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