



PRODUCT DATA

620
HOT MELT
STANDING SEAM ROOF SEALANT

DESCRIPTION

620 is a hot applied, flexible, non-sagging, thermoplastic sealant designed for metal standing seam roof systems. It has excellent properties at both high and low temperatures. It remains flexible at -50°F, but does not sag or flow at 220°F. 620 has excellent adhesion to oiled galvanized steel, Galvalume, aluminum coated steel, and painted steel. The applied bead will remain in place during application, handling and shipment. During panel seaming, 620 will not impede the roll forming operation.

620 is available in 5-gallon pails and 55-gallon drums. Both containers have removable, disposable liners to make disposal of the containers easier and less expensive and to comply with government and local disposal regulations.

PROPERTIES

Property	Test Method	Typical Values
Color	ASTM D1729	White to off-white
Odor		Mild to none
Service Temperature		-50°F to 220°F
Application Temperature		160°F to 180°F
Installation Temperature		Roof panels with pre-applied sealant can be installed between 0°F and 110°F
Cone Penetration, 150-g	ASTM D217	@ 0°F ≥ 40 dmm @ 77°F 70 – 150 dmm
% Solids	ASTM C681	>99% by weight
Specific Gravity	ASTM D71	1.10 ± 0.05 g/cm ³
Weight per Gallon		9.2 ± 0.5 pounds per gallon
Slump Resistance	ASTM D2202 30-minutes @ 250°F	0.00-inch typical 0.20-inch maximum
Ring & Ball Softening Point	ASTM E28	160°F – 220°F
Staining	ASTM D925, Method A – 7-days @ 175°F	No contact stains on fluoropolymer or polyester coatings.
	ASTM D925, Method B – 7-days UVA-340 sunlamp @ 140°F	No migration stains on fluoropolymer or polyester coatings.
Corrosive Effects	TP-008	No evidence of pitting or corrosion of aluminum, aluminum-zinc coated steel or galvanized steel after 168-hours immersion of sealant on metal in water @ 100°F.
Copper Staining	TP-009	No evidence of any darkening, etching or salt deposits on copper after 168-hours storage of polished copper in the sealant @ 158°F.

Property	Test Method	Typical Values
Discoloration from Ultraviolet Light Exposure	ASTM D1148, 2000-hrs UVA-340	Very slight yellowing.
Shelf Life		Indefinite when stored in the original container at normal warehouse temperatures.

REGULATIONS and SPECIFICATIONS

Department of Defense: Meets UFC 3-110-03, Section 5-3.3.3 Seam Sealant requirements.

FDA Regulation: Meets U.S. Food and Drug Administration (FDA) regulation 21 CFR 175.105 – Indirect food additives: Adhesives and components of coatings. For substances that may come into contact with food as part of packaging or processing equipment, but are not intended to be added directly to food.

LEED: Conforms to Leadership in Energy and Environmental Design (LEED) for New Construction Version 2.2, Indoor Environment material: Section 4.1, Low Emitting Materials: Adhesive & Sealants (SCAQMD) Rule # 1168, VOC limits.

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