



### 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.

#### Standards Compliance

- **ASTM C-920** Type S, Grade NS, Class 35, Use: NT, M, A and G – Primed (HG92)
- **ASTM C-920** Type S, Grade NS, Class 25, Use: NT, A and G – Non-Primed classification
- **ISO 11600** Type F, Class 25, Subclass LM
- **ASTM C-719** – Highly Flexible -  $\pm 35\%$  of original joint width (primed)
- **ASTM C794** (Adhesion in Peel) – PASS
- **ASTM C793** Weatherability - Excellent resistance to weathering and UV radiation, resists yellowing
- **ASTM C1442** Adhesion in peel under cycle UVA/ASTM G154 Cycle 1 - PASS
- **ASTM C510** Staining and colour change - PASS
- **AS1530.3-1999** – Method for fire tests on building components and structures: Reaction to fire (Report 8043-03-02C IO1 R00)
  - Spread of Flame Index = 5
  - Heat Evolved = 5
  - Smoke Developed = 3

#### Benefits

- Isocyanate and solvent free
- Highly flexible -  $\pm 35\%$  of original joint width (ASTM C-719).
- Excellent resistance to weathering and UV radiation, resists yellowing (ASTM C793, C1442 & C510)
- 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
- Meets the criteria of a sealant for use in AS3740-2021 (Waterproofing of Domestic Wet Areas) waterproofing applications
- Australian formulated and manufactured

### Our Focus is Clear. Perfecting Adhesives.

**IMPORTANT:** Information, specifications, procedures and recommendations provided ("information") are based on our experience and we believe this to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

**NOTE TO USER:** by ordering/receiving product you accept the **H.B. Fuller General Terms and Conditions of Sale** applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence or for death or personal injury caused by negligence or for breach of any mandatory implied terms.

**Australia**  
Tel: +61 1800 423 855  
customer.service@hbfuller.com  
**China & Hong Kong**  
Tel: +86 20 82068291  
cs.china@hbfuller.com  
**Indonesia**  
Tel: +62-21-5307232/33

**Korea**  
Tel: +82 2 786 8296  
cskorea@hbfuller.com  
**Malaysia**  
Tel: +603 3345 5200  
**New Zealand**  
Tel: +64 800 555 072  
customer.service@hbfuller.com

**Philippines**  
Tel: +63 2 5194073  
**Taiwan**  
Tel: +886 2 26033385  
**Thailand**  
Tel: +66 2 3757442  
**Vietnam**  
Tel: +84 8 2225558



## TECHNICAL DATA SHEET

## 技术资料

### 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 0g/L.

This product is VOC-free.

### Compatible Substrates

Concrete	Ceramic
Cement sheeting	Plastics (pretest)
Masonry	ABS
Plasterboard	Aluminium
Steel	Glass
Timber	XPS & EPS Polystyrene
Powdercoated Aluminium	Aerated Concrete (AAC)
Galvanised Steel	Zinculume®

### 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	ca. 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 620 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 600ml sausages.

## Our Focus is Clear. Perfecting Adhesives.

**IMPORTANT:** Information, specifications, procedures and recommendations provided ("information") are based on our experience and we believe this to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

**NOTE TO USER:** by ordering/receiving product you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence or for death or personal injury caused by negligence or for breach of any mandatory implied terms.

**Australia**  
Tel: +61 1800 423 855  
customer.service@hbfuller.com  
**China & Hong Kong**  
Tel: +86 20 82068291  
cs.china@hbfuller.com  
**Indonesia**  
Tel: +62-21-5307232/33

**Korea**  
Tel: +82 2 786 8296  
cskorea@hbfuller.com  
**Malaysia**  
Tel: +603 3345 5200  
**New Zealand**  
Tel: +64 800 555 072  
customer.service@hbfuller.com

**Philippines**  
Tel: +63 2 5194073  
**Taiwan**  
Tel: +886 2 26033385  
**Thailand**  
Tel: +66 2 3757442  
**Vietnam**  
Tel: +84 8 2225558

**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. 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

**Our Focus is Clear. Perfecting Adhesives.**

**IMPORTANT:** Information, specifications, procedures and recommendations provided ("information") are based on our experience and we believe this to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

**NOTE TO USER:** by ordering/receiving product you accept the **H.B. Fuller General Terms and Conditions of Sale** applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence or for death or personal injury caused by negligence or for breach of any mandatory implied terms.

**Australia**  
Tel: +61 1800 423 855  
customer.service@hbfuller.com  
**China & Hong Kong**  
Tel: +86 20 82068291  
cs.china@hbfuller.com  
**Indonesia**  
Tel: +62-21-5307232/33

**Korea**  
Tel: +82 2 786 8296  
cskorea@hbfuller.com  
**Malaysia**  
Tel: +603 3345 5200  
**New Zealand**  
Tel: +64 800 555 072  
customer.service@hbfuller.com

**Philippines**  
Tel: +63 2 5194073  
**Taiwan**  
Tel: +886 2 26033385  
**Thailand**  
Tel: +66 2 3757442  
**Vietnam**  
Tel: +84 8 22225588



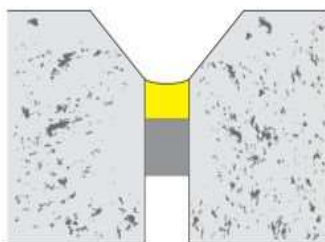
# H.B. Fuller



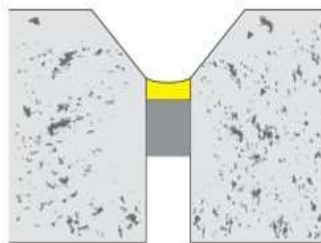
## TECHNICAL DATA SHEET

## 技术资料

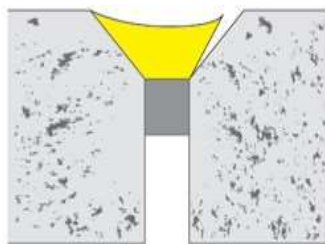
### Correct/Incorrect Joint Design



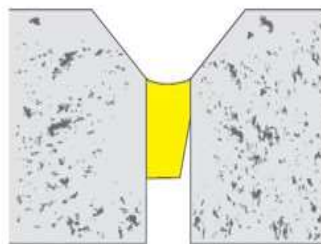
**Correct:** Correct depth/width ratio, correct amount of sealant adhering to substrate, acceptable backing rod application, tooling of sealant creating acceptable joint top surface



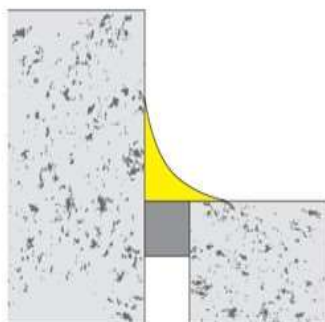
**Incorrect:** Incorrect joint depth/width ratio



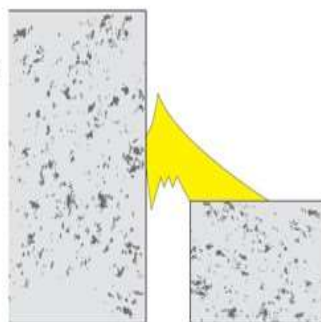
**Incorrect:** Incorrect sealant depth/width ratio and joint dimension, too much sealant adhering to substrate



**Incorrect:** No backing rod, poor sealant depth/width ratio, too much sealant adhering to substrate



**Correct:** Backing rod used correctly. Correct amount of sealant in joint (slightly concave). Correct amount of sealant adhering to substrate.



**Incorrect:** No backing rod used. Too much sealant in joint (not concave). Too much sealant adhering to substrates.

### Our Focus is Clear. Perfecting Adhesives.

**IMPORTANT:** Information, specifications, procedures and recommendations provided ("information") are based on our experience and we believe this to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

**NOTE TO USER:** by ordering/receiving product you accept the **H.B. Fuller General Terms and Conditions of Sale** applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence or for death or personal injury caused by negligence or for breach of any mandatory implied terms.

**Australia**  
Tel: +61 1800 423 855  
customer.service@hbfuller.com  
**China & Hong Kong**  
Tel: +86 20 82068291  
cs.china@hbfuller.com  
**Indonesia**  
Tel: +62-21-5307232/33

**Korea**  
Tel: +82 2 786 8296  
cskorea@hbfuller.com  
**Malaysia**  
Tel: +603 3345 5200  
**New Zealand**  
Tel: +64 800 555 072  
customer.service@hbfuller.com

**Philippines**  
Tel: +63 2 5194073  
**Taiwan**  
Tel: +886 2 26033385  
**Thailand**  
Tel: +66 2 3757442  
**Vietnam**  
Tel: +84 8 2225588



# H.B. Fuller



### 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
- Not recommended for 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

## Our Focus is Clear. Perfecting Adhesives.

IMPORTANT: Information, specifications, procedures and recommendations provided ("information") are based on our experience and we believe this to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

**NOTE TO USER:** by ordering/receiving product you accept the H.B. Fuller General Terms and Conditions of Sale applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence or for death or personal injury caused by negligence or for breach of any mandatory implied terms.

**Australia**  
Tel: +61 1800 423 855  
customer.service@hbfuller.com  
**China & Hong Kong**  
Tel: +86 20 82068291  
cs.china@hbfuller.com  
**Indonesia**  
Tel: +62-21-5307232/33

**Korea**  
Tel: +82 2 786 8296  
cskorea@hbfuller.com  
**Malaysia**  
Tel: +603 3345 5200  
**New Zealand**  
Tel: +64 800 555 072  
customer.service@hbfuller.com

**Philippines**  
Tel: +63 2 5194073  
**Taiwan**  
Tel: +886 2 26033385  
**Thailand**  
Tel: +66 2 3757442  
**Vietnam**  
Tel: +84 8 22255588



out of reach of children. An MSDS is available from the H.B. Fuller representative in your state, HB Fuller Australia customer service, or downloadable from the HB Fuller web site, [www.hbfuller.com.au](http://www.hbfuller.com.au).

**Disclaimer**

This technical data sheet summarises at the date of issue to the best technical knowledge of HB Fuller Australia. Since HB Fuller Australia cannot anticipate or control the conditions under which the product may be used, each user must, prior to usage, review this technical data sheet in the context of how the user intends to handle and use the product in the workplace. If clarification or further information is needed to ensure that an appropriate assessment can be made, the user should contact this company. Our responsibility for the products sold is subject to our standard terms and conditions, a copy of which is sent to our customers and is also available on request

Version 9  
TDS Date: 02/07/2025

**Our Focus is Clear. Perfecting Adhesives.**

**IMPORTANT:** Information, specifications, procedures and recommendations provided ("information") are based on our experience and we believe this to be accurate. No representation, guarantee or warranty is made as to the accuracy or completeness of the information or that use of the product will avoid losses or damages or give desired results. It is purchaser's sole responsibility to test and determine the suitability of any product for the intended use. Tests should be repeated if materials or conditions change in any way. No employee, distributor or agent has any right to change these facts and offer a guarantee of performance.

**NOTE TO USER:** by ordering/receiving product you accept the **H.B. Fuller General Terms and Conditions of Sale** applicable in the region. Please request a copy if you have not received these. These Terms and Conditions contain disclaimers of implied warranties (including but not limited to disclaiming warranties of fitness for a particular purpose) and limits of liability. All other terms are rejected. In any event, the total aggregate liability of H.B. Fuller for any claim or series of related claims however arising, in contract, tort (including negligence), breach of statutory duty, misrepresentation, strict liability or otherwise, is limited to replacement of affected products or refund of the purchase price for affected products. H.B. Fuller shall not be liable for loss of profit, loss of margin, loss of contract, loss of business, loss of goodwill or any indirect or consequential losses arising out of or in connection with product supply.

Nothing in any term shall operate to exclude or limit H.B. Fuller's liability for fraud, gross negligence or for death or personal injury caused by negligence or for breach of any mandatory implied terms.

**Australia**  
Tel: +61 1800 423 855  
customer.service@hbfuller.com  
**China & Hong Kong**  
Tel: +86 20 82068291  
cs.china@hbfuller.com  
**Indonesia**  
Tel: +62-21-5307232/33

**Korea**  
Tel: +82 2 786 8296  
cskorea@hbfuller.com  
**Malaysia**  
Tel: +603 3345 5200  
**New Zealand**  
Tel: +64 800 555 072  
customer.service@hbfuller.com

**Philippines**  
Tel: +63 2 5194073  
**Taiwan**  
Tel: +886 2 26033385  
**Thailand**  
Tel: +66 2 3757442  
**Vietnam**  
Tel: +84 8 22225588