MasterWeld® 622
Multi-purpose, flexible polyurethane adhesive/sealant
FORMERLY DEGASEAL™ 22

DESCRIPTION
MasterWeld 622 is polyurethane based, one component, moisture-curing adhesive/sealant. It maintains permanent flexibility with high bond strength that provides outstanding durability.

PRODUCT HIGHLIGHTS
• Permanently flexible for long lasting durability
• Compatible with a variety of paints to achieve desired aesthetic performance
• Primerless adhesion eliminates an installation step to improve the process and application time
• Low VOC for use in all regions

APPLICATIONS
• Multi-purpose construction grade adhesive
• Various truck, bus, and trailer assemblies
• Rail car and cargo container assemblies

LOCATION
• Interior and exterior

SUBSTRATE
• Concrete
• Masonry
• Wood
• Clay & concrete roof tiles
• Aluminum

COLORS
White, black, bronze and aluminum gray. For special orders of other colors, contact Customer Service.

PACKAGING
– 300 mL cartridges, 12 cartridges per case
– 20 oz. sausages, 20 sausages per case

YIELD
– A 300 mL cartridge seals 24 linear feet in 7/16" by 7/16" (6 by 6 mm) joint

STORAGE
Protect unopened containers from heat and direct sunshine. In cool or cold weather, store containers at room temperature for at least 24 hours before using.

SHELF LIFE
– Cartridges: 1 year when stored in unopened containers at 75° F (24° C) and 50% relative humidity.
– Sausages: 1 year when stored in unopened containers at 75° F (24° C) and 50% relative humidity.

VOC CONTENT
35 g/L or <2.9%, less water and exempt solvents.

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Technical Data

Composition
MasterWeld 622 is a multi-purpose polyurethane flexible adhesive/sealant.

Compliances
- ASTM C 557-73
- Federal Specification TT-S-00230C, Type II, Class A
- ASTM C 920-87, Type S, Grade NS, Class 25, Use NT, M and A

Test Data

<table>
<thead>
<tr>
<th>PROPERTY</th>
<th>RESULTS</th>
<th>TEST METHOD</th>
</tr>
</thead>
<tbody>
<tr>
<td>Base</td>
<td>Synthetic rubber-resin</td>
<td></td>
</tr>
<tr>
<td>Viscosity, poise</td>
<td>2,800 ±500 (trowelable)</td>
<td>ASTM D 2393</td>
</tr>
<tr>
<td>Application</td>
<td>Caulking gun or power pump</td>
<td></td>
</tr>
<tr>
<td>Open time, minutes</td>
<td>20 ±5, depending on temperature and humidity</td>
<td></td>
</tr>
<tr>
<td>Density, lbs per gallon</td>
<td>9.85 ±0.1</td>
<td>ASTM D 1475</td>
</tr>
<tr>
<td>Solids, %</td>
<td>80 ±2</td>
<td>ASTM D 1259</td>
</tr>
<tr>
<td>Lap shear, psi</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Wet lumber</td>
<td>225</td>
<td>ASTM D 1002</td>
</tr>
<tr>
<td>Dry lumber</td>
<td>250</td>
<td>ASTM D 1002</td>
</tr>
<tr>
<td>Plywood/concrete</td>
<td>140</td>
<td>ASTM D 1002</td>
</tr>
<tr>
<td>Plywood/drywall</td>
<td>160</td>
<td>ASTM D 1002</td>
</tr>
<tr>
<td>Plywood/aluminum</td>
<td>100</td>
<td>ASTM D 1002</td>
</tr>
<tr>
<td>Service temperature range, ° F (° C)</td>
<td>-40 to 200 (-40 to 93)</td>
<td></td>
</tr>
<tr>
<td>Extrudability, seconds</td>
<td>3</td>
<td>ASTM D 603</td>
</tr>
<tr>
<td>Rheology, vertical sag, 120° F</td>
<td>No sag</td>
<td>ASTM C 639</td>
</tr>
<tr>
<td>Tack-free time, (maximum 72 hrs)</td>
<td>Passes</td>
<td>ASTM C 679</td>
</tr>
<tr>
<td>Tensile strength, psi</td>
<td>350</td>
<td>ASTM D 412</td>
</tr>
<tr>
<td>Elongation, at break, %</td>
<td>800</td>
<td>ASTM D 412</td>
</tr>
<tr>
<td>Hardness, Shore A</td>
<td>25–30</td>
<td>ASTM C 661</td>
</tr>
<tr>
<td>Movement capability, %</td>
<td>±25</td>
<td>ASTM C 719</td>
</tr>
<tr>
<td>Bond durability, %</td>
<td>±25, no failures</td>
<td>ASTM C 719</td>
</tr>
<tr>
<td>Glass, aluminum, concrete</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Accelerated weathering</td>
<td>No elastomeric property change after 3,000 hours</td>
<td>Atlas 6500 xenon arc model</td>
</tr>
<tr>
<td>Exterior Perimeter Sealing</td>
<td>Pass</td>
<td>AAMA 808.3</td>
</tr>
</tbody>
</table>

Test results are averages obtained under laboratory conditions. Reasonable variations can be expected.
HOW TO APPLY

SURFACE PREPARATION
1. Surfaces must be dry, clean, free of dirt, moisture, loose particles, oil, grease, asphalt, tar, paint, wax, rust, waterproofings or other contaminants.
2. On metal surfaces, remove scale, rust or other coatings to expose a bright white surface. Aluminum window frames are frequently coated with a clear lacquer that must be removed before the application of MasterWeld 622.
3. Clean concrete, stone and other masonry surfaces by grinding, sandblasting or wire brushing. Expose a sound surface free of contamination and laitance.
4. Wood surfaces must be clean and sound. Scrape away any paint to bare wood.

APPLICATION
1. MasterWeld 622 bonds well to a variety of substrates and is ideally suited for use in interior/exterior joints, waterproofing overlap seams, fascia and other structural components. MasterWeld 622 remains permanently elastic for long lasting performance.
2. Surface temperatures above 40° F (4° C) are recommended during application. MasterWeld 622 can be applied below freezing temperatures only if substrates are completely dry, free of moisture and clean.
3. MasterWeld 622 comes ready to use. Do not open cartridges until preparatory work has been completed. Trim nozzle to desired size opening.
4. Fill joints from the deepest point to the surface by holding a properly sized nozzle against the back of the joint.
5. Dry tooling is recommended.

CURING
- 16 hours: 100° F (38° C), 95% relative humidity
- 1 day: 70° F (21° C), 55% relative humidity
- 3 days: 40° F (4° C), 50% relative humidity
Cure through times are based on a 1/4” (6 mm) diameter bead.

CLEAN UP
Immediately after use, clean equipment with the appropriate solvent. Use proper precautions when handling solvents. Cured sealant can be removed by cutting with a sharp-edged tool; thin films by abrading.

FOR BEST PERFORMANCE
- Do not apply over freshly treated wood; it must have weathered for at least 6 months.
- MasterWeld 622 should not come into contact with oil-based caulking, silicone sealants, polysulfides or fillers impregnated with oil, asphalt or tar.
- Do not use in joints deeper than 1/2”.
- MasterWeld 622 is not recommended for continuous water immersion.
- Make certain the most current versions of product data sheet and SDS are being used; call Customer Service (1-800-433-9517) to verify the most current version.
- Proper application is the responsibility of the user. Field visits by BASF personnel are for the purpose of making technical recommendations only and not for supervising or providing quality control on the jobsite.

HEALTH, SAFETY AND ENVIRONMENTAL
Read, understand and follow all Safety Data Sheets and product label information for this product prior to use. The SDS can be obtained by visiting www.master-builders-solutions.basf.us, e-mailing your request to basfbscst@basf.com or calling 1(800)433-9517. Use only as directed. For medical emergencies only, call ChemTrec® 1(800)424-9300.
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