

### Product Description

EnerSEAL® JS680 is a one-component polyisobutylene-based primary sealant, specially developed for the manufacturing of IG units.

### Basic Uses

EnerSEAL JS680 provides a barrier to moisture vapor ingress and gas loss as an IG primary sealant, in the design of insulating glass units.

### Features and Benefits

- Flexible at low temperatures
- High ultraviolet resistance
- Very good adhesion to glass, aluminum, galvanized steel, stainless steel and rigid polymeric warm-edge spacers
- Non-fogging
- Extremely low moisture and gas permeability rates
- Very easy to use

### Availability

Available from your local Tremco Field Representative via Tremco Warehouses.

### Packaging

7 kg cylindrical slugs (9.75" x 7.5" dia.)

### Colors & Consistency

Black, odorless, permanently plastic

### Storage and Shelf Life

Store EnerSEAL JS680 in dry plant conditions between 40°F to 80°F.

Shelf life in original unopened packaging is 24 months.

### Applicable Standards

EnerSEAL JS680 when used with quality desiccant/spacer system(s) and keen workmanship will conform to:

ASTM 2190 and CAN/CGSB 12.8

### Limitations

- EnerSEAL JS680 is not suited for the manufacture of IG units with flexible spacers; Tremco recommends use of Tremco EnerSEAL JS780S for these applications.

### Substrate Preparation

Glass bonding surface must be cleaned with hot water over 120F (50C) and mechanical washing equipment. Glass and spacer bonding surfaces must be clean and dry. Coated glass may require edge deletion, so consult your glass supplier for their recommendations.

### Application

- EnerSEAL JS680 can be applied with extrusion machines that are commonly used in the insulating glass industry at a temperature of 230°F to 270°F (110°C to 130°C) depending on the desired pressure and extrusion speed.
- Wearing non-bleeding gloves is recommended while handling spacer frames to prevent any oily/fatty materials from being deposited on the surfaces, since this could weaken bonding to glass and create volatile fogging.
- Apply a regular and continuous profiled bead, following a minimum pre-established thickness or coverage weight/length for your design.
- Compression must be applied to ensure regular, sufficient deformation and wet-out of the EnerSEAL JS680 bead
- Pay particular attention to the continuity of the EnerSEAL JS680 profile beads in the corners.
- In service temperature range is -25°F to 180°F (-30°C to 82°C)

### Clean Up

Excess sealant and smears are best removed from glass with safety glass scrapers to hold the flat razor-blade. Where mechanical removal above is not possible, uncured material on plant manufacturing surfaces can be removed with acetone. Avoid heat guns, as they can overheat and generate fumes.

### Warranty

Tremco warrants its Products to be free of defects in materials but makes no warranty as to appearance or color. Since methods of application and on-site conditions are beyond our control and can affect performance, Tremco makes no other warranty, expressed or implied including warranties of MERCHANTABILITY and FITNESS FOR A PARTICULAR PURPOSE with respect to Tremco Products. Tremco's sole obligation shall be, at its option, to replace or refund the purchase price of the quantity of Tremco Products proven to be defective, and Tremco shall not be liable for any loss or damage.

Please refer to our website at [www.tremcosealants.com](http://www.tremcosealants.com) for the most up-to-date Product Data Sheets.

NOTE: All Tremco Safety Data Sheets (SDS) are in alignment with the Globally Harmonized System of Classification and Labelling of Chemicals (GHS) requirements.

**EnerSEAL JS680**  
**Polyisobutylene IG Primary Sealant**

**TYPICAL PHYSICAL PROPERTIES**

PROPERTY	TEST METHOD	TYPICAL VALUES
Type	-	Polyisobutylene IG primary sealant
Color	-	Black
Solids	EN 1279-6G	100%, volatility of 0.08%
Specific Gravity and Lbs./gal	ISO 1183	1.15 for about 9.6 lbs./gal
Moisture Vapor Transmission Rate	EN 1279-4C	<0.1 g/m <sup>2</sup> /day, 2 mm film
Argon Gas Permeability	EN 1279-4C	<0.001 g/m <sup>2</sup> /day, 2 mm film
Application Temperature		230°F to 270°F (110°C to 130°C)
Durability	ASTM 2190, EN 1279-2 & EN 1279-3	Passes

**0319/ESJS680DS-RW**

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