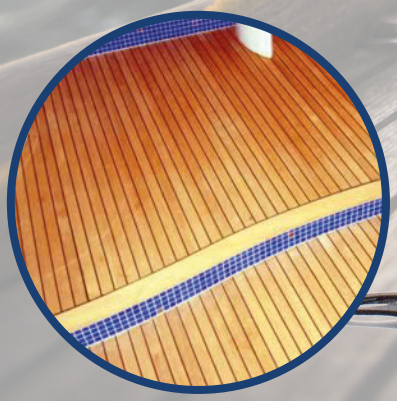
PANTERA®

1C Alcoxy Silicone

CASTING COMPOUND FOR TEAK DECK PLANKS

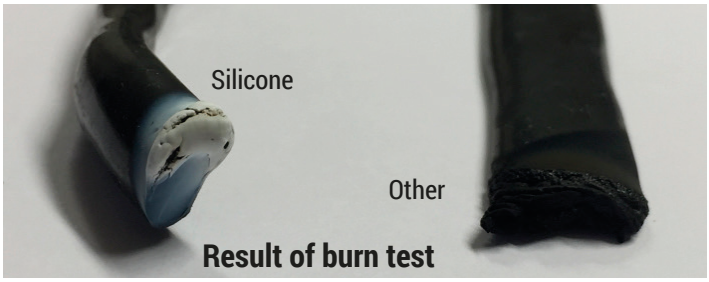
for repairs and new caulking



SEA LINE 1000 DC

GENERAL

Sea Line 1000 DC was especially developed to provide a silicone-based, durable, elastic and highly extensible sealing compound for the planking of wooden decks. Due to the low Shore A hardness of approx. 40 and an elongation at break of approx. 350%, Sea Line 1000 DC reliably and quickly relieves the stresses in the sealing joint caused by drying and moistening of the wood.



Result of burn test

Replacement of sealing joints

Before starting work, check which product was used previously in the joint. PU, SMP, polysulfide or silicone?
If silicone was used in the joint, the refit work has to be done out with our marine silicone Sea Line 1000 DC, Art. no. 3726. You can always switch to Sea Line 1000 DC, even if there was another sealant in the joint before. But you will have to continue using Sea Line 1000 DC in the future. Remove the
1 old joint. This can be done either with a knife (e.g. cutter) or a machine (e.g. FEIN Multimaster). The old sealant has to be thoroughly removed and any damage to the wood needs to be touched up. Use our Pantasol Light spray
2 for cleaning the joints. For **large** replacement areas, the wooden deck must now be sanded flat. Clean the joint again afterwards. Apply the sealant to the joint with aid of a hand, pneumatic or battery gun. During the open working
3 time, press the sealant in using a spatula. After curing, remove the protruding sealant with a scraper and sand off any residues from the wood. We recommend sandpaper with a grit of 80–120. Always sand in the direction of the joint.
4 In the case of **minor** refit work, mask the wood areas around the joint with tape beforehand. Clean the joint, apply the sealant, press it in, and then remove the tape. Any sealant edges that have formed after curing can be
5 smoothed out using our scraper (ERGO Pocket Scraper, Art. no. 625).

Caulking after new laying

Teak should have a core moisture of about 12% before caulking, but in no case more than 16%. After sanding the newly laid deck smooth, thoroughly vacuum out the joints and clean with Pantasol Light (flash-off time at least 30 minutes!). If necessary, apply our Technical Adhesive Primer (Art. no. 3504) to the clean sides of the joint (always prime end-grain surfaces!). Apply the sealant to the joint using a hand, pneumatic or battery gun, taking into account the drying times of the adhesive primer. During the open working time, press the sealant in using a spatula. After the joint sealant has 6 cured (at the earliest 60 h at a constant +23 °C with 50% relative humidity), remove the excess with a scraper (ERGO Heavy Duty Paint Scraper, Art. no. 665) and sand any residues out of the wood. For very large decks, clarify the use of break tapes (separating tapes) with us beforehand. Sea Line 1000 DC 7 is also excellently suited for all other sealing applications on boats and around the house.

Our guidelines for the application of Sea Line 1000 DC must be strictly observed. They do not release the user from the obligation to check and document the applicability. Preliminary tests must always be carried out on the original material. Please be sure to follow our important instructions!

IMPORTANT INSTRUCTIONS

- When working with Sea Line 1000 DC, you should be able to control the climatic conditions. Covered storage is to be preferred.
- Sea Line 1000 DC is a one-component joint sealing compound that cures by absorbing moisture from the air.
- Adhere strictly to the recommended temperature and humidity (see also the climate/humidity table)!
- For cleaning the wood, use only the Pantasol Light spray recommended by us (see page 4, Accessories).
- Teak is a low-maintenance natural material. It usually does not require any treatment with care products.
- If teak care products, such as oil or brighteners, are to be used, they must not be applied for at least 12 months after Sea Line 1000 DC has been applied and a compatibility test has been carried out on the original material beforehand.
- We do not recommend the use of cleaners containing oxalic acid or anti-algae agents (e.g. Boracol 10Y). Under certain circumstances, this can lead to damage to the sealing joint (smearing). This also applies to the use of such care products in the months prior to the application of Sea Line 1000 DC. Especially if you have used such chemicals and damage has occurred, always carry out compatibility tests on easily replaceable deck parts before using them again.
- For the cleaning of decks and wooden surfaces, we recommend our MultiCleaner PLUS (Art. no. 4045) or sea water. In the event that you wish to use cleaners that have not been approved by us, we recommend that you apply them to an area that can be easily repaired and observe them for several days or even weeks to avoid major damage.
- **Sea Line 1000 DC has an expiry date. The product may be used for a maximum of 14 days beyond this date. Afterwards, the product will not cure anymore. (See photo on page 4, top)**

TECHNICAL DATA

Observe our processing instructions at all times.
Safety data sheet for professional users available on request.

Base	Alcoxy silicone rubber
Odor	Neutral
Open working time	30 to 45 min. at +23 °C / 50% relative humidity
Viscosity	approx. 65,000 mPa·s (at 8 s-1, +25 °C)
Shore hardness A to DIN EN ISO 868	approx. 40
Tear strength to ISO 34-10	9.70 N/mm
Elongation at break to DIN EN ISO 8339	approx. 350%
Volume shrinkage to EN ISO 10563	approx. -4%
Sanding	After 60 h at +23 °C / 50% relative humidity
Curing	approx. 2 mm / 24 h depending on temperature and air humidity
Working temperature	+5 °C to +35 °C
Thermal stability	-50 °C to +140 °C without discoloration
Overpainting	Not possible
UV resistance	See UV exposure table
Shelf life	BBD (best by date) on cartridge, maximum 4 months after date of manufacture, closed container
Storage temperature	Store original container tightly closed and dry at +15 °C to +25 °C without direct sunlight.
Chemical resistance	Good: against water, salt water, aliphatic solvents, oils, greases, diluted inorganic acids and alkalis. Moderate: against esters, ketones and aromatics. Not resistant: to concentrated acids and chlorinated hydrocarbons.
For caulking of	Teak decks, mahogany and oak decks, larch, pitch pine and pine decks, parquet and laminate flooring

Max. moisture absorption after 7 days of water storage: approx. 1.95%

Mechanical properties and ageing

Design of teak sample bodies, type DIN EN ISO 8339 (joint 12 x 12 x 50 mm), cleaning of the wood bodies with Pantasol Light.

UV exposure	Max. strength under tension	Tensile strength	Elongation at break	Type of break
Zero value – unloaded storage after 28 days indoor climate +23 °C/50%	RL5F28 N	0.88 N/mm²	59%	Cohesive
Test specimens – unloaded storage after 4 months indoor climate	486 N	0.81 N/mm²	55%	Cohesive
Test after 1,000 hours of storage at tensile strength	438 N	0.71 N/mm²	88%	Cohesive
Test after 2,000 hours of storage at tensile strength	426 N	0.69 N/mm²	85%	Cohesive
Test after 2,500 hours at +65 °C, 80% relative humidity	414 N	0.69 N/mm²	85%	Cohesive
Special testing: Teak sample with Boracol 10Y (applied with brush and placed in PE bag). After 300 hours of UV storage.	474 N	0.79 N/mm²	71%	Cohesive

Conclusions: Under the requirements described above, the adhesion of Sea Line 1000 DC to teak under all occurring conditions is in no way in doubt.

Climate/humidity table

The following table shows the combinations of air temperature and relative humidity that yield ideal conditions for the cross-linking of our product.

For the values highlighted in green, our product cross-links optimally. The decisive factor is the amount of water in grams per m³ of air. This results from the air temperature and the relative humidity.

At values above 9 g water/m³ air, the product reacts more quickly, i.e. cross-linking is accelerated.

At values below 5 g water/m³ air, cross-linking may stop, i.e. the product remains sticky even after a longer period of time.

Relative air humidity

Air temperature	10%	20%	30%	40%	50%	60%	70%	80%	90%	100%
+35 °C	4*	7.9	11.9	15.8	19.8	23.8	27.7	31.7	35.6	39.6
+30 °C	3.0	6.1	9.4	12.1	15.2	18.2	21.3	24.3	27.3	30.4
+25 °C	2.3	4.6	6.9	9.2	11.5	13.8	16.1	18.4	20.7	23.0
+20 °C	1.7	3.5	5.2	6.9	8.7	10.4	12.1	13.8	15.6	17.3
+15 °C	1.3	2.6	3.9	5.1	6.4	7.7	9.0	10.3	11.5	12.8
+10 °C	0.9	1.9	2.8	3.8	4.7	5.6	6.6	7.5	8.5	9.4
+5 °C	0.7	1.4	2.0	2.7	3.4	4.1	4.8	5.4	6.1	6.8
0 °C	0.5	1.0	1.5	1.9	2.4	2.9	3.4	3.9	4.4	4.8
-5 °C	0.3	0.7	1.0	1.4	1.7	2.1	2.4	2.7	3.1	3.4
-10 °C	0.2	0.5	0.7	0.9	1.2	1.4	1.6	1.9	2.1	2.3

Data source for table: German Insurance Association (GDV)

* g water / m³ air

APPROVALS

0736/xxxx*
*Herstellungsjahr

U.S. Coast Guard approval number:
164.112/EC0736/118490-01

BG Transport and Traffic, Ship Safety Division: Approved according to the "Marine Equipment Directive 2014/90/EU".

Test for surface flammability according to FTP Code 2010 Part 5 as well as testing of smoke density and toxicity according to FTP Code 2010 Part 2, Approval No.: 118490-01

French
VOC emission class A+

The French VOC label informs customers about how many volatile organic compounds are emitted by a product during a 28-day test period. The eleven volatile substances considered are: Formaldehyde, acetaldehyde, toluene, tetrachloroethylene, xylene, 1,2,4 -trimethylbenzene, 1,4-dichlorobenzene, ethylbenzene, 2-butoxyethanol, styrene and total volatile organic compounds in general.

Choosing a product with an A+ rating will result in better indoor air quality, because the product emits fewer or no VOCs:
Class A+: very low pollutant emissions
Class A : low pollutant emissions
Class B : medium pollutant emissions
Class C : high pollutant emissions

GEV (classified as EMICODE class EC1 PLUS according to GEV criteria)

The product complies with all statutory requirements, in particular those of the chemical law and its ordinances.
The product is solvent-free according to the definition of TRGS610. Carcinogenic, mutagenic and teratogenic substances of class 1 and 2 are not added to the product during production.

BBD: at most 4 months from date of manufacture

Products

Container size ..... 290 ml / 393 g cartridge
Color ..... Black
Article number ..... 290 ml cartridge - Order no. 3726
UFI code QCMU-9CRP-TF3H-JGFY
Customs tariff number ... 32141090

Adhesive primer

Adhesive primer
for slightly absorbent surfaces (wood) ... Can 300 ml - Order no. 3504

Activator / wash primer for
non-absorbent surfaces ..... Can 300 ml - Order no. 3604

Accessories

Pro hand sealant gun COX ..... 310 ml - Order no. 9155
Pneumatic sealant gun COX ..... 310 ml - Order no. 9170
Pneumatic sealant gun COX ..... 600 ml - Order no. 9180
COX ElectraFlow Plus ..... 600 ml Order no. 9185 (combination in case (battery gun))
Pantasol Light cleaner ..... Spray can 500 ml - Order no. 4012 | Can 1,000 ml - Order no. 4212
Canister 5 l - Order no. 4114 | Canister 30 l - Order no. 4112
ERGO Pocket Scraper ..... Order no. 625
Replacement triangular blade for Art. no. 625 ..... Order no. 449
ERGO Heavy Duty Paint Scraper (dual handle) ..... Order no. 665
Replacement straight blade, 65 mm - for Art. no. 665 ..... Order no. 451
Latex gloves, 100 pcs, white ..... Size M - Order no. 5500 | size L - Order no. 5501 | size XL - Order no. 5502

Our specifications are based on practical experience and laboratory trials. We therefore recommend sufficient own tests on the original material in the original environment. Subject to technical modifications. With the publication of this data sheet, all previous versions cease to be valid.

Your stockist

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