PANTERA®

1K- Alcoxy Silicone

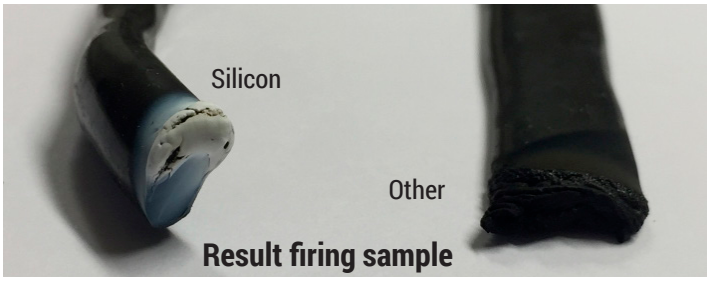
Teak deck joint sealant

For repairs and re-pointing

SEA LINE 1000 DC

GENERALLY

Sea Line 1000 DC was especially developed to provide a silicone-containing, durable, elastic and highly flexible teak deck sealing compound for wooden decks. Due to the low Shore A hardness of approx. 40 and an elongation at fracture 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.



Exchange of sealing joints

Before the beginning of works, it haas to be ascertained which product was used in the sealing joint. PU. SMP, polysulfide or silicone?

If silicone was used in the joint, the touch-up work must be carried out with our marine silicone Sea Line 1000 DC, Art. no. 3726. You can always switch to Sea Line 1000 DC, even if you had used another sealant in the joint before But you 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 damages in the wood need to be touched up. Use our Pantasol Light detergent for cleaning the joints. For **larger** replacement areas, the wooden deck must now be sanded flat. Clean the joint again afterwards, Put the sealant into
2. the joint with aid of a handl, compressed air or accumulator press. During the open processing time, press the sealant in with a spatula. After curing,
3. remove the sealant edges with a drawing blade and polish any residues from the wood. We recommnend a sandpaper with a grit of 80-120. Always sand in the direction of the joint.
4. In the case of **minor** repair work, tape the wooden areas around the joint beforehand. Clean joint, apply sealant, press it in and remove tape. Any sea-
5. lant edges that have formed can be smoothed after curing with our scraper (ERGO Pocket Scraper, Art. No. 625).

Jointing after new laying

Teak should have a core humidity of about 12 % before jointing. In any case, no more than 16%. After level sanding of the newly laid deck, thoroughly vacuum out the joints and clean with Pantasol Light (drying time at least 30 min). If necessary, apply our primer technical adhesive coat (Art. No. 3504) to the now clean joint flanks (always prime end grain surfaces!). Apply the joint sealant to the joint using a hand, compressed air or battery press, taking into account the drying times of the primer. During the open processing time, press in sealant with a spatula.
After the joint sealant has cured (at the earliest 60 h at a constant +23 °C at 50 % relative humidity), remove the edges with a scraper (ERGO Kraftschaber, Art. No. 665) and sand any residues out of the wood.
For very large decks, the use of break tapes (separating tapes) should be clarified with us. Sea Line 1000 DC can also be used for all other waterproofing work around the ship and the port.

Our notices for the application of SeaLine 1000 DC are to be strictly observed. They do not release the user from the obligation to check and document the applicability. Pre-tests on original material should always be carried out Please take account of our important notices!

IMPORTANT NOTICES

- When you are working with Sea Line 1000 DC, climatic conditions should be controllable. Covered storage is to be preferred.
- Sea Line 1000 DC is a one-component joint sealant, which cures by absorbing humidity.
- Strictly adhere to the recommended temperature and humidity (see also climate/humidity chart)!
- For cleaning the wood, use only the Parasol Light detergent recommended by us.
- Teak is a low-maintenance, natural product. It usually doesn't require treatment with maintenance products.
- If teak care products, such as oil or brighteners, are used, they must not be applied for at least 12 months after Sea Line 1000 DC has been applied and prior compatibility testing has been carried out on the original material.
- We do not recommend the use of detergents or algae protectants with oxalic acid (e.g. Boracol 10Y). Under certain circumstances, this can lead to damage to the sealing joint (smearing). This appplies also for the use of such agents in the months before applying 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 the new product.
- • For the cleaning of decks and wooden surfaces, we recommend our MultiCleaner PLUS (Article 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 it to an area that can be easily repaired and observe it for several days/weeks to avoid major damage.
- **Sea Line 1000 DC has an expiry date. The product can be used for up to 14 days after this date. Afterwards, the product will not cure anymore. (See photo page 3, top)**

TECHNICAL DATA

When processing, our processing instructions must be observed.
Safety data sheet for professional users available on request.

Base	Alcoxy Silicon rubber
Smell	neutral
open	processing time 30 to 45 min at +23C/ 50 % relative humidity
Viscosity	approx. 65.000 mPa*s (at 8s-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 DIN EN ISO 8339	approx. 350 %
Volumenschrumpfung nach EN ISO 10563	approx. -4 %
Sandable	after 60 h bei +23 °C / 50 % relative humidity
Curing	approx. 2 mm / 24 h depending on temperature and air humidity
Processing temperature	+5 °C to +35 °C
Temperature resistance	-50 °C to +140 °C without discoloration
Overpainting	not possible
UV resistance	s. Table UV exposure
Shelf life	s. Best before date on cartridge, maximum 6 months from date of manufacture, closed container Storage
Storage temperature	Store original container tightly closed, 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 grouting	For grouting 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 aging

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 at tension	Tensile strength	Elongation at break	Type of fracture
Zero value - unloaded storage after 28 days room climate +23°C/50%	RL5F28 N	0,88 N/mm²	59%	cohesive
Test specimens - unloaded storage after 4 months room climate	486 N	0,81 N /mm²	55%	cohesive
Test after 1.000 hours of storage tensile strength	438 N	0,71 N /mm²	88%	cohesive
Test after 2.000 hours of storage 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 (rubbed 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 under the existing conditions need not be questioned in any case.

Klima-/Feuchttabelle

The following table shows at which interplay of air temperature and relative humidity are given ideal conditions for the connectivity of our product.

For the values highlighted in green, our product networks optimally. The decisive factor is the amount of water in grams per m³ of air. This is determined by the air temperature and the relative humidity.

With values above 9 g water/m³ air, the product reacts more quickly, i.e. the connectivity is accelerated.

With values below 5 g water/m³ air, a connectivity standstill can ensue, i.e. the product stays sticky even after a longer period of time.

Relative 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 chart Gesamtverband der Deutschen Versicherungswirtschaft e.V.

*g Water / m³ airt

APPROVALS

0736/xxxx*
*Year of production

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

BG-Verkehr, Dienststelle Schiffssicherheit: (Ship Safety Division, BG Transport and Traffic) Approved according to the „Marine Equipment Directive 2014/90/EU".
Test of surface flammability according to FTP-Code 2010 Part 5 as well as testing of smoke development and toxicity according to FTP-Code 2010 Part 2 Approval No.: 118490-01

French
VOC emission class A+

The French VOC label informs customers how many volatile organic compounds are emitted by a product during a 28-day test period.
The eleven volatile pollutants 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.

Approved in accordance with „Directive 2014/90/EU. Selecting an A+ rated product results 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: heavy pollutant emissions

GEV (Classified in the chemical law and its regulations. EMICODE class EC1 PLUS)

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

Use-by date:
up to 6 months after date of production

Products

Package size ..... 290ml / 393g cartridge
Color ..... black, Order no. 3726
Color according to RAL, Order no. 3726 + RAL No.
Article no ..... 290 ml cartridge - Order no. 3726
UFI-Code QCMU-9CRP-TF3H-JGFY
Customs tariff number 32141090

Adhesive primer

Adhesive primer
for lightly absorbent surfaces (wood) ..... Tin 300 ml - Order no 3504

Aviator/ washing primer for
Non-absorbent surfaces ..... Tin 300 ml - Order no 3604

Accesories

Profihandpresse Cox ..... 310 ml Bestell.-Nr. 9155
Druckluftpresse Cox ..... 310 ml Bestell.-Nr. 9170
Druckluftpresse Cox ..... 600 ml Bestell.-Nr. 9180
Cox Electraflow Plus ..... 600 ml Bestell.-Nr. 9185 (Combi im Koffer (Akkupresse))
Pantasol Light Reiniger ..... Sprühdose 500 ml - Bestell.-Nr. 4012 | Dose 1.000 ml - Bestell.-Nr. 4212
Kanister 5 l - Bestell.-Nr. 4114 | Kanister 30 l - Bestell.-Nr. 4112
ERGO Taschenschaber ..... Bestell.-Nr. 625
Ersatz Dreikant-Klinge, f. Art.-Nr. 625 ..... Bestell.-Nr. 449
ERGO Kraftschaber (Zweihandgriff) ..... Bestell.-Nr. 665
Ersatz Gerade Klinge, 65 mm - f. Art.-Nr. 665 ..... Bestell.-Nr. 451
Latexhandschuhe, 100 St., weiss ..... Größe M - Bestell.-Nr. 5500 | Größe L - Bestell.-Nr. 5501 | Größe XL - Bestell.-Nr. 5502

Our specifications are grounded in practical and laboratory experience We therefore recommmend sufficient pre- tests of the original material in an 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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