

Silicone Elastomer

PRODUCT DESCRIPTION A two pack, silicone elastomer tie coat with no added biocides.

INTENDED USES As a tie coat which forms an integral part of the Intersleek foul release system by promoting adhesion between the specified priming system and the Intersleek finish coat.

PRACTICAL INFORMATION FOR INTERSLEEK 731

Colour	Light Pink
Gloss Level	Low Gloss
Volume Solids	63%
Typical Thickness	100 microns (4 mils) dry equivalent to 159 microns (6.4 mils) wet
Theoretical Coverage	6.30 m ² /litre at 100 microns d.f.t and stated volume solids 253 sq.ft/US gallon at 4 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Brush

Drying Time

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			Minimum	Maximum
10°C (50°F)	150 minutes	6 hours	6 hours	7 days
15°C (59°F)	140 minutes	5 hours	5 hours	7 days
25°C (77°F)	90 minutes	4 hours	4 hours	7 days
40°C (104°F)	30 minutes	2 hours	3 hours	7 days

REGULATORY DATA

Flash Point (Typical)	Part A 28°C (82°F); Part B 30°C (86°F); Mixed 29°C (83°F)	
Product Weight	1.15 kg/l (9.6 lb/gal)	
VOC	2.71 lb/gal (325 g/l)	EPA Method 24

See Product Characteristics section for further details

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SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to application all surfaces should be assessed and treated in accordance with ISO 8504:2000

Steel Substrates

Intersleek 731 should always be applied over a recommended anti-corrosive coating scheme. The primer surface should be dry and free from all contamination and Intersleek 731 must be applied within the overcoating intervals specified (consult the relevant product data sheet).

Areas of breakdown, damage etc., should be prepared to the specified standard (e.g. Sa2½ (ISO 8501-1:2007) or SSPC-SP10, Abrasive Blasting, or SSPC-SP11, Power Tool Cleaning) and patch primed with the full anti-corrosive system prior to the application of Intersleek 731.

APPLICATION

Mixing	Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.			
	<ul style="list-style-type: none"> (1) Agitate Base (Part A) with a power agitator. (2) Agitate Curing Agent (Part B) with a power agitator. (3) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator. 			
Mix Ratio	1.0 part(s) : 1.0 part(s) by volume			
Working Pot Life	10°C (50°F) 3 hours	15°C (59°F) 3 hours	25°C (77°F) 3 hours	40°C (104°F) 3 hours
Airless Spray	Recommended	Tip Range 0.38-0.53 mm (15-21 thou) Total output fluid pressure at spray tip not less than 211 kg/cm ² (3000 p.s.i.)		
Brush	Suitable - small areas only			
Roller	Not suitable			
Thinner	International GTA007	Do not thin more than allowed by local environmental legislation		
Cleaner	International GTA007			
Work Stoppages	Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA007. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.			
Clean Up	Clean all equipment immediately after use with International GTA007. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays.			
	All surplus materials and empty containers should be disposed of in accordance with appropriate regional regulations/legislation.			

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PRODUCT CHARACTERISTICS

This product contains silicones which can cause problems with the surface finish and subsequent adhesion of other coatings if contaminated with Intersleek 731. Good housekeeping practices are essential and care should be taken to avoid overspray onto conventionally coated areas.

All equipment must be thoroughly cleaned prior to use, and before re-use with other materials, to prevent contamination.

Any liquids used to clean up Intersleek must not be allowed to contaminate other liquid paints or coated surfaces.

Maximum film build in one coat is best attained by airless spray. When applying by methods other than airless spray, the required film build is unlikely to be achieved. Application by air spray may require a multiple cross spray pattern to attain maximum film build. Low or high temperatures may require specific application techniques to achieve maximum film build.

When applying Intersleek 731 by brush, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

Exposure to unacceptably low temperatures and/or high humidities during or immediately after application may result in incomplete cure and surface contamination that could jeopardise subsequent intercoat adhesion.

Over-application of Intersleek 731 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

Low molecular weight reactive additives, which will form part of the film during normal ambient cure conditions, will also affect VOC values determined using EPA Method 24.

SYSTEMS COMPATIBILITY

Intersleek 731 forms part of the Intersleek foul release system. As such, Intersleek 731 must always be applied over an approved epoxy anti-corrosive scheme.

Approved anti corrosive schemes are:

Intergard 264

Intersleek 731 should only be topcoated with itself, or Intersleek 970

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ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Material Safety Data Sheet and the container(s), and should not be used without reference to the Material Safety Data Sheet (MSDS) which International Protective Coatings has provided to its customers.

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult International Protective Coatings for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	2 US gal	1 US gal	2.5 US gal	1 US gal	1 US gal
For availability of other pack sizes, contact International Protective Coatings.					
SHIPPING WEIGHT (TYPICAL)	Unit Size				
	2 US gal	21.8 lb			
STORAGE	Shelf Life	12 months minimum at 25°C (77°F). 6 months minimum at 40°C (104°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.			

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

This Technical Data Sheet is available on our website at www.international-marine.com or www.international-pc.com, and should be the same as this document. Should there be any discrepancies between this document and the version of the Technical Data Sheet that appears on the website, then the version on the website will take precedence.

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