

PRODUCT DESCRIPTION A two component silicone elastomer tie coat.

INTENDED USES As a tie coat between epoxy anti-corrosives and Intersleek 425 to ensure maximum system performance.

Suitable for use during new construction or maintenance and repair.

PRACTICAL INFORMATION FOR INTERSLEEK 381

Colour	Light Pink
Gloss Level	Low Gloss
Volume Solids	63% ± 2%
Typical Thickness	75-125 microns (3-5 mils) dry equivalent to 119-198 microns (4.8-7.9 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, Air Spray, Brush, Roller
Drying Time	

Temperature	Touch Dry	Hard Dry	Overcoating Interval with recommended topcoats	
			<i>Minimum</i>	<i>Maximum</i>
5°C (41°F)	3.5 hours	8 hours	8 hours	7 days
10°C (50°F)	2.5 hours	6 hours	6 hours	7 days
25°C (77°F)	1.5 hours	4 hours	4 hours	7 days
35°C (95°F)	30 minutes	3 hours	3 hours	7 days

REGULATORY DATA

Flash Point (Typical) Part A 27°C (81°F); Part B 30°C (86°F); Mixed 28°C (82°F)

Product Weight 1.3 kg/l (10.8 lb/gal)

VOC 2.71 lb/gal (325 g/lit) EPA Method 24

See Product Characteristics section for further details

**SURFACE
PREPARATION**

Paint only clean, dry surfaces. Remove all grease, oil, soluble contaminants and other foreign matter by "solvent cleaning" (SSPC-SP1).

Unpainted Surfaces

Properly prepare surface and apply recommended primer. Apply a coat of Intersleek 381 as specified (consult the relevant product datasheet for surface preparation and overcoating information).

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.			
	<ol 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 part(s) : 1 part(s) by volume			
Working Pot Life	5°C (41°F) 3 hours	10°C (50°F) 3 hours	25°C (77°F) 3 hours	35°C (95°F) 3 hours
Airless Spray	Recommended	Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 176 kg/cm ² (2503 p.s.i.)		
Air Spray (Conventional)	Recommended			
Brush	Suitable - small areas only	Typically 50-75 microns (2.0-3.0 mils) can be achieved		
Roller	Suitable - small areas only	Typically 50-75 microns (2.0-3.0 mils) can be achieved		
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.			

PRODUCT CHARACTERISTICS

This product contains silicones which can cause problems with the surface finish and subsequent adhesion of other coatings if contaminated with Intersleek 381. Good housekeeping practices are essential and care should be taken to avoid overspray onto conventionally coated areas.

All equipment must be thoroughly clean prior to use and before re-use with other materials, to prevent contamination. Liquid cleaners for Intersleek 381 must not be allowed to contaminate other paints.

Intersleek 381 has a short pot life. Mix full units only and use within the pot life specified.

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 381 by brush or roller, 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. Minimum application temperature is 10°C (50°F) and minimum relative humidity is 30%.

Over-application of Intersleek 381 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 381 is an integral part of the Intersleek fouling control system and must be applied over an approved epoxy anti-corrosive system. The only recommended primer is;

Intershield 300HS

This product should only be topcoated with itself or Intersleek 425.

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
	1 US gal	0.5 US gal	1 US gal
			0.5 US gal
For availability of other pack sizes, contact International Protective Coatings.			
SHIPPING WEIGHT (TYPICAL)	Unit Size		
		1 US gal	24 lb ¹
¹ Combined weight of all parts.			
STORAGE	Shelf Life	12 months minimum at 4-32°C (40-90°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 International Paint 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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