Belzona 1151

FN10017

BELZONA®
Repair • Protect • Improve

INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

APPLY ONLY TO BLAST CLEANED SURFACES

a) Brush away loose contamination and degrease with a rag soaked in **Belzona® 9111** (Cleaner/Degreaser) or any other effective cleaner which does not leave a residue e.g. methyl ethyl ketone (MEK).

b) Select an abrasive to give the necessary standard of cleanliness and a minimum depth of profile of 3 mils (75 microns).

Use only an angular abrasive.

c) Blast clean the metal surface to achieve the following standard of cleanliness:
ISO 8501-1 Sa 2½ very thorough blast cleaning
American Standard near white finish SSPC SP 10
Swedish Standard Sa 2½ SIS 05 5900

d) After blasting, metal surfaces should be coated before any oxidation of the surface takes place.

SALT CONTAMINATED SURFACES
Metal surfaces that have been immersed for any periods in salt solutions e.g. sea water, should be blasted to the required standard, left 24 hours to allow any ingrained salts to sweat to the surface and then washed prior to a further brush blast to remove these. This process may need to be repeated to ensure complete removal of salts.

WHERE BELZONA® 1151 SHOULD NOT ADHERE
Brush on a thin layer of **Belzona® 9411** (Release Agent) and allow to dry for 15-20 minutes before proceeding to step 2.

2. COMBINING THE REACTIVE COMPONENTS

a) Transfer approximately half of the contents of the **Belzona® 1151** Solidifier can to the **Belzona® 1151** Base unit.

b) Mix until a uniform consistency is achieved.

c) Add the remainder to the Solidifier and mix thoroughly to a uniform streak free material.

NOTES

1. MIXING AT LOW TEMPERATURES
To ease mixing when the material temperature is below 41°F (5°C), warm the Base and Solidifier components until the contents attain a temperature of 68-77°F (20-25°C).

2. WORKING LIFE
From the commencement of mixing, **Belzona® 1151** must be used within the times shown below.

Temperature	41°F (5°C)	59°F (15°C)	77°F (25°C)
Use all material within	50 min.	40 min.	30 min.

3. MIXING SMALL QUANTITIES
For mixing small quantities of **Belzona® 1151** use:
4 parts Base to 1 part Solidifier by volume
10.8 parts Base to 1 part Solidifier by weight

4. VOLUME CAPACITY OF MIXED BELZONA® 1151
25.0 cu.in. (409 cm^3) per kg.

3. APPLYING BELZONA® 1151

FOR BEST RESULTS
Do not apply when:

i) The temperature is below 41°F (5°C) or the relative humidity is above 90%.
ii) Rain, snow, fog or mist is present.
iii) There is moisture on the metal surface or is likely to be deposited by subsequent condensation.
iv) The working environment is likely to be contaminated by oil/grease from adjacent equipment or smoke from kerosene heaters or tobacco smoking.

a) Apply the **Belzona® 1151** directly on to the prepared surface with the plastic applicator or spatula provided.

b) Press down firmly to fill all cracks, remove entrapped air, and ensure maximum contact with the surface.

c) Contour the **Belzona® 1151** to the correct profile with the plastic applicator.

CLEANING
Mixing tools should be cleaned immediately after use with **Belzona® 9111** or any other effective solvent e.g. Methyl ethyl ketone (MEK). Application tools should be cleaned using a suitable solvent such as **Belzona® 9121,** MEK, acetone or cellulose thinners.

4. COMPLETION OF THE MOLECULAR REACTION

Allow **Belzona® 1151** to solidify as below before subjecting it to the conditions indicated.

Temperature	Overcoating	Machining and/or light loading	Full mechanical or thermal loading
41°F/ 5°C	5 hours	18 hours	7 days
59°F/15°C	3½ hours	9 hours	2 days
77°F/25°C	2½ hours	4½ hours	24 hours

These times are for a thickness of approximately 0.25 inch (6 mm); they will be reduced for thicker sections and extended for thinner sections.

5. APPLICATION OF A FURTHER LAYER OF BELZONA® 1151

Whenever possible, **Belzona® 1151** should be applied in a single layer to achieve the required thickness. **Belzona® 1151** can be overcoated as soon as it is firm enough to do so and should be completed within the 'Overcoating' times stated above.

After this time, the surface must be roughened by abrading or grit blasting to achieve a frosted appearance with a minimum surface profile of 40 microns before overcoating.

HEALTH & SAFETY INFORMATION
Please read and make sure you understand the relevant Safety Data Sheets.

Belzona products are manufactured under an ISO 9001 Registered Quality Management System

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