Belzona 1141

(CONDUCTIVE METAL)

BELZONA®
Repair • Protect • Improve

INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

APPLY ONLY TO CLEAN, FIRM, DRY AND WELL ROUGHENED 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). Use a flame to sweat out oil from deeply impregnated surfaces.

b) Roughen surfaces by blast cleaning, deeply scoring or grinding. This surface preparation should ensure complete removal of all paint and oxide films for electrical contact with substrate.

c) Finally degrease again. Use clean rags to avoid spreading contamination.

WHERE BELZONA® 1141 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

Transfer the entire contents of the Base and Solidifier modules on to the **Belzona® Working Surface**. Mix thoroughly together to achieve a uniform material free of any streakiness.

1. MIXING AT LOW TEMPERATURES

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

2. WORKING LIFE

From the commencement of mixing, **Belzona® 1141** 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	60 min.	40 min.	25 min.

3. MIXING SMALL QUANTITIES

For mixing small quantities of **Belzona® 1141** use:
3.0 parts Base to 1 part Solidifier by volume
4.3 parts Base to 1 part Solidifier by weight

4. VOLUME CAPACITY OF MIXED BELZONA® 1141

51 cu.in. (833 cm³) per 1.5 kg unit.

3. APPLYING BELZONA® 1141

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.

FOR REBUILDING

a) Apply the **Belzona® 1141** directly on to the prepared surface with the plastic applicator or spatula provided. Press down firmly to fill all cracks, remove entrapped air, and ensure maximum contact with the surface.

b) Contour the **Belzona® 1141** to the correct profile with the plastic applicator or alternatively allow to cure and then machine down.

FOR BONDING

a) Apply a thin smear of **Belzona® 1141** to both bonding surfaces.

b) Press together to exude excess **Belzona® 1141** and scrape away.

FOR REPAIRING

a) Spread the **Belzona® 1141** on to the **Belzona® 9341** (Reinforcement Tape).

b) Apply the bandage to the area to be repaired with the coated side adjacent to the substrate.

c) Apply a final coat of **Belzona® 1141** on top of the **Belzona® 9341.**

CLEANING

Mixing tools should be cleaned immediately after use with **Belzona® 9111** or any other effective solvent e.g. Methyl ethyl ketone (MEK). Brushes, injection guns, spray equipment and any other 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® 1141** to solidify as below subjecting it to the conditions indicated.

Temper-ature	Movement or use involving no loading or immersion	Machining and/or light loading	Full electrical, mechanical or thermal loading	Immersion in chemicals
50°F/10°C	10 hours	1 day	3 days	12 days
59°F/15°C	5 hours	12 hours	2 days	7 days
68°F/20°C	2½ hours	4 hours	1 day	4 days
77°F/25°C	2 hours	3 hours	16 hours	2½ days
86°F/30°C	1 hour	2½ hour	12 hours	1½ day

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

5. APPLICATION OF A FURTHER LAYER OF BELZONA® 1141

When a further layer of **Belzona® 1141** is required, this should be applied as soon as possible after the first layer. Once **Belzona® 1141** has become dimensionally stable then the surface must be roughened otherwise intercoat adhesion will be impaired.

HEALTH & SAFETY INFORMATION

Please read and make sure you understand the relevant Material Safety Data Sheets.

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