Belzona 1341

(SUPERMETALGLIDE)

INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

i) METALLIC SURFACES - 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. The soluble salt contamination of the prepared substrate, immediately prior to application, should be less than 30mgs/m².

ii) SURFACES ALREADY REBUILT WITH BELZONA® 1111

a) If overcoating takes place within 2 hours, no further surface preparation is required.

b) After this maximum overcoating time has elapsed roughen the **Belzona® 1111** preferably by brush blasting before applying **Belzona® 1341**.

2. COMBINING THE REACTIVE COMPONENTS

a) Stir the contents of the Base container thoroughly to reincorporate any settlement.

b) Transfer the entire contents of the Solidifier can into the Base module.

c) Mix thoroughly together to achieve a uniform material free of any streakiness.

NOTES:

1. MIXING LARGE UNITS

When mixing 5 kg. units of **Belzona® 1341**, use a mechanical mixer, ensuring that material on the side and at the corners of the container is fully incorporated. Avoid incorporation of excessive amounts of air into the mixed material.

2. MIXING AT LOW TEMPERATURES.

To ease mixing when the material temperature is below 50°F (10°C), warm the Base and Solidifier modules until the contents attain a temperature of 68-77°F (20-25°C).

3. WORKING LIFE

From the commencement of mixing, **Belzona® 1341** must be used within the times shown below.

Temperature	41°F (5°C)	59°F (15°C)	77°F (25°C)	86°F (30°C)
Use all material within	2 hours	1 hour	30 min.	20 min.

4. MIXING SMALL QUANTITIES

For mixing small quantities of **Belzona® 1341** use:
1 part Base to 1 part Solidifier by volume
100 parts Base to 70 parts Solidifier by weight.

5. VOLUME CAPACITY OF MIXED BELZONA® 1341

22 cu.in. (360 cm³) per 500g unit
220 cu.in. (3.6 liters) per 5 kg unit.

3. APPLYING BELZONA® 1341

FOR BEST RESULTS
Do not apply when:

i) The temperature is below 50°F (10°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) **FIRST COAT**
Apply the **Belzona® 1341** directly on to the prepared surface with a stiff bristled brush or with the plastic applicator provided. To achieve the correct film thickness of 10 mils (250 microns), a practical coverage rate of 13.0 sq. ft (1.2 m²) per 500g unit or 130 sq.ft. (12 m²) per 5 kg unit should be obtained.

b) **SECOND COAT**
As soon as possible after application of the first coat, apply a further coat of **Belzona® 1341** as in (a) above. This time will be 4 - 6 hours at 68°F (20°C). The first coat must not be left longer than 24 hours before overcoating, irrespective of temperature. Should this occur, then the surface should be brush blasted or abraded before commencing application.

SPRAY APPLICATION
On suitable areas, **Belzona® 1341** may be applied by heated airless spray. Typical set up would be 63:1 airless spray unit with either in-line heater or trace heated lines capable of raising product temperature to at least 122°F (50°C). Solvent must **NOT** be added. Please contact Belzona direct for more specific information.

COLOR
Belzona® 1341 is available in blue and gray to facilitate application and to prevent misses. These colors are for identification only and there will be some variation between batches. In service the color of the applied product may change.

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® 1341** to solidify as below subjecting it to the conditions indicated.

Temperature	Movement or use involving no loading or immersion	Light loading	Full mechanical/ thermal loading or water immersion	Chemical contact
50°F/10°C	24 hours	48 hours	14 days	21 days
59°F/15°C	12 hours	24 hours	7 days	10 days
68°F/20°C	8 hours	16 hours	3 days	7 days
77°F/25°C	7 hours	14 hours	2½ days	6 days
86°F/30°C	6 hours	12 hours	2 days	5 days

5. FINAL SOLIDIFICATION OF BELZONA® 1341

When time is important and equipment usage is pressing, then by installing forced air heaters and taking steps to contain this heat around the equipment being reclaimed, final solidification time can be as little as 24 hours. Application of heat should not be carried out until the **Belzona® 1341** has initially gelled (typically 4 hours at 68°F (20°C) and the material temperature should not exceed 122°F (50°C).

Due allowance must be made for "warming up".
If there is any doubt regarding final solidification then **BE SAFE - MAKE MORE TIME.**

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

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Q 09335
ISO 14001:2004
EMS 509612
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Printed in England Publication No. 04-04-13