Belzona 6111

(LIQUID ANODE)

BELZONA®
Repair • Protect • Improve

INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE BOND

Thoroughly clean steel contaminated by chemicals using a high pressure water wash. Steel contaminated by oil, grease, etc., must first be thoroughly washed down with **Belzona® 9111** (Cleaner/Degreaser), **Belzona® 9121** (Universal Thinners) or any other effective cleaner which does not leave a residue, e.g. methyl ethyl ketone (MEK).

Blast clean the steel to be treated with **Belzona® 6111** to ensure intimate contact between the steel and the **Belzona® 6111.**

The minimum standards of cleanliness are:-

ISO 8501-1 Sa 2½ - very thorough blast cleaning
American Standard - near white finish SSPC-SP-10
Swedish Standard - Sa 2½ SIS 05 5900

The selection of abrasive grit is dependent upon the condition of the steel and recovery conditions. Abrasives can be either metallic or non-metallic and when cleaning to the required standard, a profile depth of 2 - 3 mil (50 - 75 microns) should be obtained.

2. COMBINING THE REACTIVE COMPONENTS

Belzona® 6111 is a two component material - Base and Solidifier. Immediately after blast cleaning the steel surface, prepare the **Belzona® 6111** for application by first stirring the Base component to achieve an even consistency. Slowly add the entire contents of the Solidifier can, stirring all the time until complete mixing is achieved.

3. APPLYING BELZONA® 6111

APPLICATION OF FIRST COAT
(For spray details see below)
Apply the first coat of **Belzona® 6111** within two hours of blast cleaning, with a clean, good quality, short bristled brush, ensuring that all edges, crevices and bolt heads are evenly coated. In order to achieve the required dry film thickness, do not exceed the average practical coverage rate shown overleaf.

APPLICATION OF SECOND COAT
Apply the second coat of **Belzona® 6111** within the recommended overcoat time (see "Technical Data", overleaf). Once again, to achieve the required dry film thickness do not exceed the average practical coverage rate shown overleaf.

NOTES:
1. CLEANING EQUIPMENT
Clean all application equipment IMMEDIATELY after use with **Belzona® 9121**. It is not satisfactory to simply soak equipment in **Belzona® 9121** as **Belzona® 6111** continues to harden chemically even when immersed.

2. SPRAYING
A typical spray set-up for **Belzona® 6111** using a Pressure Feed spray gun is:-

DeVilbiss JGA 502-1, No 54 air cap, EX-Fluid Needle and tip.
Atomizing pressure 40 - 50 p.s.i. (2.8 - 3.5 kg/sq.cm.)
Pot pressure 10-20 p.s.i. (0.7 - 1.4 kg./sq.m.) with air supply 9.7 cu.ft./min.(0.27 cu.meter/min.).

Adequate ventilation and exhaust facilities must be provided at all times.

3. STORAGE
Belzona® 6111 and **Belzona® 9121** are flammable in the liquid state. They should, therefore, be stored in a cool place away from naked lights.

4. THINNING
In hot, dry atmospheres, strong winds or for certain low pressure spray equipment, the **Belzona® 6111** can be diluted with up to 5% **Belzona® 9121.**

4. TECHNICAL DATA

USABLE LIFE
Once mixed, **Belzona® 6111** has a usable life which will vary with temperature as indicated below:-

Temperature	Usable Life
50°F (10°C)	72 hours
68°F (20°C)	48 hours
86°F (30°C)	24 hours

Mixed material reaching the limit of its usable life should never be blended with freshly mixed material.

DRYING TIMES
(1½ mils. dry film thickness - 38 microns)

Temperature	Touch Dry Time	Overcoating Time Min.	Max	Full Cure
50°F/10°C	17 min.	32 hours	7 days	10 days
68°F/20°C	8 min.	16 hours	5 days	7 days
86°F/30°C	3 min.	8 hours	3 days	5 days

RECOMMENDED FILM THICKNESS PER COAT:
Wet 3 mils. (76 microns)
Dry 1½ mils. (38 microns)

PRACTICAL COVERAGE RATE
The average practical coverage rate for two coats at 1½ mils. (38 microns) dry film thickness per coat (total 3 mils. (76 microns)) is 19.4 sq.ft. (1.8 m²) per kg.

TOTAL SOLIDS (Mixed)
By weight 84.0%
By volume 49.0%

MIXING RATIO
3.5: 1 v/v Base: Solidifier

CHEMICAL RESISTANCE
If the **Belzona® 6111** system is likely to come into contact with aggressive chemicals, **Belzona® 5111** (Ceramic Cladding) should be used to overcoat the **Belzona® 6111.**

APPLICATION CONDITIONS
Application should not be carried out below 50°F (10°C), when the relative humidity is above 90%, when there is moisture on the surface, or during rain, snow, fog or mist.

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

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