Belzona 8111

(MOULDABLE WOOD)

BELZONA®
Repair • Protect • Improve

INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

APPLY ONLY TO CLEAN, FIRM, DRY SURFACES.

a) Cut away loose, rotted woodwork with a sharp knife or chisel, back to a solid substrate.

b) Abrade all surfaces to remove old paint, powdery deposits, etc.

c) Remove all grease, oil and dirt by washing with a detergent solution or wiping with **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.

WHERE BELZONA® 8111 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.

Porous surfaces should be sealed initially by coating with a suitable lacquer.

2. COMBINING THE REACTIVE COMPONENTS

Pour the required volume of **Belzona® 8111** Reactive Liquid into a suitable mixing container.

Add a small quantity of **Belzona® 8111** Fibrous Wood.

Mix thoroughly. Add more Fibrous Wood as required to achieve the ideal consistency. Complete mixing within 2 - 3 minutes.

NOTES:
1. WORKING LIFE
From the commencement of mixing, **Belzona® 8111** 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	20 min.	12 min.	8 min.

2. MIXING RATIO
There is no specific mixing ratio for **Belzona® 8111.** However, a mix of 3 parts by weight of Reactive Liquid to 2 parts by weight of Fibrous Wood will give a smooth paste, while a mix of 3 parts by weight of Reactive Liquid to 1 part by weight of Fibrous Wood will give a casting consistency.

3. APPLYING BELZONA® 8111

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 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.

1. REBUILDING
a) Apply to the prepared surface using the spatula or plastic applicator provided. Press well down to remove entrapped air.

b) Leave sufficiently proud of the surface to allow for subsequent machining, or contour to shape by pressing a polyethylene sheet onto the uncured **Belzona® 8111.** This also prevents tackiness on the exposed surface.

2. CASTING
a) Brush a thin layer of **Belzona® 8111** over the mold surfaces which have been previously been coated with **Belzona® 9411.**

b) Fill the mold by pouring the remainder of the **Belzona® 8111.** Vibrate the mold to remove occluded air.

CLEANING
Mixing and application tools should be cleaned immediately after use with **Belzona® 9111,** or any other effective solvent e.g. 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.

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4. COMPLETION OF THE MOLECULAR REACTION

Allow **Belzona® 8111** to solidify as below before subjecting it to the conditions indicated:

	Machining and/or light loading	Full mechanical loading
41°F/ 5°C	40 min.	60 min.
50°F/10°C	30 min.	40 min.
59°F/15°C	20 min.	30 min.
68°F/20°C	15 min.	20 min.
77°F/25°C	10 min.	15 min.
86°F/30°C	5 min.	10 min.

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

5. COLOR MATCHING

When fully cured, **Belzona® 8111** can be painted over or stained as with any other wood. However, best results will be obtained if wood stainers are incorporated with the **Belzona® 8111** Reactive Liquid before addition of the **Belzona® 8111** Fibrous Wood. When mixing in any stainers, no more than 2% by volume should be added. Greater additions will affect the cure time and subsequent physical properties.

6. VOLUME CAPACITY

At a mixing ratio of 3 parts Reactive Liquid to 2 parts Fibrous Wood the volume capacity of **Belzona® 8111** is 710 ccs. (43.3 cu³) per kg.

HEALTH & SAFETY INFORMATION

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

The technical data contained herein is based on the results of long term tests carried out in our laboratories and to the best of our knowledge is true and accurate on the date of publication. It is however subject to change without prior notice and the user should contact Belzona to verify the technical data is correct before specifying or ordering. No guarantee of accuracy is given or implied. We assume no responsibility for rates of coverage, performance or injury resulting from use. Liability, if any, is limited to the replacement of products. No other warranty or guarantee of any kind is made by Belzona, express or implied, whether statutory, by operation of law or otherwise, including merchantability or fitness for a particular purpose.

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