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.

c) Stabilize cracks by drilling the extremities. Long cracks should be drilled, tapped and bolted every 3-4 inches (77-103 mm).

d) Vee-out all cracks using a rotary file.

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

WHERE BELZONA® 1121 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

Stir the contents of the Solidifier container thoroughly to reincorporate any separation. 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® 1121 must be used within the times shown below.

<table>
<thead>
<tr>
<th>Temperature</th>
<th>41°F (5°C)</th>
<th>59°F (15°C)</th>
<th>77°F (25°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Use all material within</td>
<td>90 min.</td>
<td>60 min.</td>
<td>35 min.</td>
</tr>
</tbody>
</table>

3. MIXING SMALL QUANTITIES

For mixing small quantities of Belzona® 1121 use:

1.0 parts Base to 1 part Solidifier by volume

1.2 parts Base to 1 part Solidifier by weight

4. VOLUME CAPACITY OF MIXED BELZONA® 1121

23.5 cu.in. (385 cm³) per kg.

3. APPLYING BELZONA® 1121

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® 1121 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) Over cracks, gaps and holes, stipple in Belzona® 9341 (Reinforcement Tape).

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d) Contour the Belzona® 1121 to the correct profile with the plastic applicator or alternatively allow to cure and then machine down.

e) When Belzona® 1121 is being used as an irregular shim, offer the two mating surfaces together as soon as Belzona® 1121 has been applied. Remove excess with the spatula.

5. APPLICATION OF A FURTHER LAYER OF BELZONA® 1121

When a further layer of Belzona® 1121 is required, this should be applied no longer than 1½ days after application of the first layer when the ambient temperature is 59-77°F (15-25°C).

At higher temperatures, this time will be reduced; at lower temperatures it will be extended.

After the maximum overcoating time has elapsed, the solidified Belzona® 1121 must be roughened before applying further Belzona® 1121.

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® 1121 to solidify as below subjecting it to the conditions indicated.

<table>
<thead>
<tr>
<th>Temperature</th>
<th>Movement or use involving no loading or immersion</th>
<th>Machining and/or light loading</th>
<th>Full mechanical or thermal loading</th>
<th>Immersion in chemicals</th>
</tr>
</thead>
<tbody>
<tr>
<td>41°F/5°C</td>
<td>28 hours</td>
<td>4 days</td>
<td>10 days</td>
<td>24 days</td>
</tr>
<tr>
<td>50°F/10°C</td>
<td>15 hours</td>
<td>3 days</td>
<td>5 days</td>
<td>12 days</td>
</tr>
<tr>
<td>59°F/15°C</td>
<td>9 hours</td>
<td>27 hours</td>
<td>3 days</td>
<td>7 days</td>
</tr>
<tr>
<td>68°F/20°C</td>
<td>4½ hours</td>
<td>16 hours</td>
<td>1½ day</td>
<td>4 days</td>
</tr>
<tr>
<td>77°F/25°C</td>
<td>2½ hours</td>
<td>9 hours</td>
<td>1 day</td>
<td>2½ days</td>
</tr>
<tr>
<td>86°F/30°C</td>
<td>1½ hours</td>
<td>5 hours</td>
<td>16 hours</td>
<td>1½ day</td>
</tr>
</tbody>
</table>

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.

HEALTH & SAFETY INFORMATION

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

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