

Belzona 1311

FN10133

(CERAMIC R-METAL)



INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

APPLY ONLY TO BLAST CLEANED SURFACES

- 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).
- 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.
- 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
- 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 20mgs/m².

WHERE BELZONA® 1311 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® 1311** 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	35 min.	25 min.	15 min.

3. MIXING SMALL QUANTITIES

For mixing small quantities of **Belzona® 1311** use:

3 parts Base to 1 part Solidifier by volume
5 parts Base to 1 part Solidifier by weight

4. VOLUME CAPACITY OF MIXED BELZONA® 1311

25.3 cu.in. (415 cm³) per kg.

3. APPLYING BELZONA® 1311

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® 1311** 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) Contour the **Belzona® 1311** to the correct profile with the plastic applicator.

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® 1311** to solidify as below subjecting it to the conditions indicated.

Temperature	Movement or use involving no loading or immersion	Machining and/or light loading	Full mechanical or thermal loading	Immersion in chemicals
41°F/ 5°C	4 hours	6 hours	4 days	5 days
50°F/10°C	3 hours	4 hours	2 days	4 days
59°F/15°C	2½ hours	3 hours	1½ days	3 days
68°F/20°C	1¾ hours	2 hours	1 day	2 days
77°F/25°C	1 hour	1½ hours	20 hours	1½ days
86°F/30°C	¾ hour	1 hour	16 hours	1 day

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.

5. MACHINING OF SOLIDIFIED BELZONA® 1311

Belzona® 1311 is extremely difficult to machine down by turning, using conventional or carbide tipped tools. However, it can be machined using diamond tipped tool.

Alternatively it can be machined by grinding, but this should be carried out as soon as possible after the Solidified times shown.

6. APPLICATION OF A FURTHER LAYER OF BELZONA® 1311

Whenever possible the **Belzona® 1311** should be applied in a single layer to achieve the required thickness.

Best recommendation when overcoating with suitable Belzona products is to allow the **Belzona® 1311** to reach the 'Machining and/or light loading' level of cure. After this time, the surface must be roughened by abrading or grit blasting to achieve a frosted appearance with a minimum surface profile of 40 microns before overcoating.

Alternatively, for service not involving immersion with a cold-wall*, **Belzona® 1311** can be directly overcoated within 90 minutes at 50°F (10°C), within 60 minutes at 68°F (20°C), or within 30 minutes at 86°F (30°C).

*Please contact Belzona Technical Service directly for clarification, if necessary.

HEALTH & SAFETY INFORMATION

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

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