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 with low chloride content.
   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 or contamination of the surface takes place.

SALT CONTAMINATED SURFACES
Note: Salt Contaminated Surfaces
The soluble salt contamination of the prepared substrate, immediately prior to application, shall be less than 20mg/m² (2μg/cm²). Metal surfaces that have been immersed for any periods in salt solutions e.g. sea water, should be blasted to the required standard, left for 24 hours to allow the ingrain salts to sweat to the surface, then washed prior to a further brush blast to remove these. This process may need to be repeated several times to ensure complete removal of the salts. Salt removal aids are commercially available that will assist and speed salt removal. Contact Belzona for best recommendation.

PIT FILLING
All welds should be prepared to NACE SP0178 Grade C or better. Deep pitting and rough welds should be smoothed out with Belzona® 1511 mixed, applied and overcoated in accordance with the relevant IFU.

2. COMBINING THE REACTIVE COMPONENTS

Transfer the entire contents of the Solidifier container into the Base container, 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 50°F (10°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® 1391T must be used within the times shown below:

<table>
<thead>
<tr>
<th>Temperature</th>
<th>50°F (10°C)</th>
<th>68°F (20°C)</th>
<th>86°F (30°C)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Use all material within</td>
<td>90 min.</td>
<td>45 min.</td>
<td>22 min.</td>
</tr>
</tbody>
</table>

3. MIXING SMALL QUANTITIES
For mixing small quantities of Belzona® 1391T use:
8.5 parts Base to 1 part Solidifier by weight
4 parts Base to 1 part Solidifier by volume

4. VOLUME CAPACITY OF MIXED BELZONA® 1391T
32.6 cu.in. (535 cm³) per kg.

3. APPLYING BELZONA® 1391T

FOR BEST RESULTS
Do not apply when:
   i) The temperature is below 50°F (10°C), above 104°F (40°C) or the relative humidity is above 85%.
   ii) The substrate temperature is less than 5°F (3°C) above dewpoint.
   iii) Rain, snow, fog or mist is present.
   iv) There is moisture on the metal surface or is likely to be deposited by subsequent condensation.
   v) The working environment is likely to be contaminated by oil/grease from adjacent equipment or smoke from kerosene heaters or tobacco smoking.

3.1 COVERAGE RATES

<table>
<thead>
<tr>
<th>Recommended number of coats</th>
<th>2</th>
</tr>
</thead>
<tbody>
<tr>
<td>Target thickness 1st coat</td>
<td>18 mils (450 microns)</td>
</tr>
<tr>
<td>Target thickness 2nd coat</td>
<td>18 mils (450 microns)</td>
</tr>
<tr>
<td>Minimum total DFT</td>
<td>24 mils (600 microns)</td>
</tr>
<tr>
<td>Maximum DFT (2 coats)</td>
<td>48 mils (1200 microns)</td>
</tr>
<tr>
<td>Maximum system DFT in stripe coat or repair areas</td>
<td>70 mils (1750 microns)</td>
</tr>
<tr>
<td>Theoretical coverage rate 1st coat</td>
<td>12.7 sq.ft (1.18 m²)/kg</td>
</tr>
<tr>
<td>Theoretical coverage rate 2nd coat</td>
<td>12.7 sq.ft (1.18 m²)/kg</td>
</tr>
<tr>
<td>Theoretical coverage rate to achieve minimum recommended system thickness</td>
<td>9.6 sq.ft (0.89 m²)/kg</td>
</tr>
</tbody>
</table>

3.2 PRACTICAL COVERAGE RATES
Appropriate loss factors must be applied to the above coverage rates. In practice, many factors influence the actual coverage rate achieved. On rough surfaces such as pitted steel the practical coverage rate will be reduced. Application at low temperatures will also reduce practical coverage rates further.

3.3 APPLICATION
a) Apply the Belzona® 1391T directly onto the prepared surface with a stiff bristled brush or with the plastic applicator provided.

b) As soon as possible after application of the first coat, apply a further coat of Belzona® 1391T as in (a) above.
3.4 OVERCOAT TIMES
The Belzona® 1391T can be overcoated as soon as it is firm enough to do so. At 68°F (20°C) it will be possible to walk on the coating after 6-8 hours, but if access can be gained without walking on the first coat, overcoating can take place after as little as 3-4 hours. The maximum overcoat time is dependent on both temperature and humidity as set out below. After this time the surface must be grit blasted to achieve a frosted appearance with a minimum surface profile of 40 microns.

<table>
<thead>
<tr>
<th>Temperature</th>
<th>&lt;50% Relative Humidity</th>
<th>&gt;50% Relative Humidity</th>
</tr>
</thead>
<tbody>
<tr>
<td>Up to 68°F (20°C)</td>
<td>24 hours</td>
<td>24 hours</td>
</tr>
<tr>
<td>Up to 86°F (30°C)</td>
<td>24 hours</td>
<td>18 hours</td>
</tr>
<tr>
<td>Up to 104°F (40°C)</td>
<td>12 hours</td>
<td>8 hours</td>
</tr>
</tbody>
</table>

3.5 REPAIRS
Within the overcoat window, any misses, pinholes or mechanical damage can be repaired by application of a further coat direct to the Belzona® 1391T surface. Outside of the overcoat window the surface of the Belzona® 1391T must be grit blasted or abraded to produce a frosted appearance free of all gloss before coating. A profile of 1.5 mils (40 microns) should be aimed for.

3.6 INSPECTION
a) Immediately after application of each unit, visually inspect for pinholes and misses. Where detected, these should be immediately brushed out.

b) Once the application is complete and the coating is dimensionally stable, carry out a thorough visual inspection to confirm freedom from pinholes and misses, and to identify any possible mechanical damage.

c) Spark testing in accordance with NACE SP0188 c.3. Has been achieved.

3.7 COLOR
Belzona® 1391T is available in different colors 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.

3.8 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
The coating should be allowed to cure as follows:

<table>
<thead>
<tr>
<th>Ambient temperature</th>
<th>Time until inspection</th>
<th>Time until full service</th>
<th>Time until post-cure (if required)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry</td>
<td>Wet</td>
<td></td>
<td></td>
</tr>
<tr>
<td>50°F (10°C)</td>
<td>72 hrs</td>
<td>post-cure required</td>
<td>72 hrs</td>
</tr>
<tr>
<td>68°F (20°C)</td>
<td>24 hrs</td>
<td>28 days</td>
<td>24 hrs</td>
</tr>
<tr>
<td>86°F (30°C)</td>
<td>12 hrs</td>
<td>10 days</td>
<td>12 hrs</td>
</tr>
<tr>
<td>104°F (40°C)</td>
<td>5 hrs</td>
<td>24 hrs</td>
<td>5 hrs</td>
</tr>
</tbody>
</table>

Post-cure will generally be unnecessary as, in most circumstances, the coating will cure sufficiently at ambient temperature with full cure achieved in service. However, post-cure may be necessary (see table above) or desirable to facilitate faster cure and quicker return to service (see below).

POST-CURE
If post-cure is necessary or desirable, the coating should be heated to between 122°F (50°C) and 212°F (100°C) for a minimum of 1 hour.

The coating should be allowed to cure as detailed in the above table prior to a dry (e.g. hot air) or wet (e.g. steam and liquid media) post-cure. Wet post-cure can typically be achieved during return to service, provided that the temperature ramp rate does not exceed 54°F (30°C) per hour.

If immediate exposure to aggressive media is to occur prior to achieving a ‘full service’ cure, post-cure is recommended. Please contact your Belzona representative to discuss specific requirements.

Coated equipment can be transported after the material has achieved the ‘inspection’ level of cure.

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

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