

Belzona 1511

FN10036 (SUPER HT-METAL)



INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

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.

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 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 20mg/m².

WHERE BELZONA® 1511 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 containers onto the **Belzona®** Working Surface.

Mix the two components thoroughly to achieve a uniform material free of any streakiness.

NOTES:

1. **Belzona® 1511** should NOT be applied at temperatures below 65°F (18°C).

2. WORKING LIFE

From the commencement of mixing, **Belzona® 1511** must be used within the times shown below.

| Temperature | 68°F (20°C) | 86°F (30°C) |
|-------------------------|-------------|-------------|
| Use all material within | 40 min. | 25 min. |

3. MIXING SMALL QUANTITIES

6 parts Base to 1 part Solidifier by weight

4 parts Base to 1 part Solidifier by volume

4. VOLUME CAPACITY OF MIXED BELZONA® 1511

19.3 cu.in. (317 cm³) per 1kg. unit.

3. APPLYING BELZONA® 1511

FOR BEST RESULTS

Do not apply when:

- The temperature is below 65°F (18°C) or the relative humidity is above 85%.
- The substrate temperature is less than 5°F (3°C) above dewpoint.
- Rain, snow, fog or mist is present.
- There is moisture on the metal surface or is likely to be deposited by subsequent condensation.
- The working environment is likely to be contaminated by oil/grease from adjacent equipment or smoke from kerosene heaters or tobacco smoking.

- Apply the **Belzona® 1511** directly on to the prepared surface with the plastic applicator or spatula provided.
- Press down firmly to fill all cracks, remove entrapped air, and ensure maximum contact with the surface.
- Contour the **Belzona® 1511** to the correct profile with the plastic applicator.
- Ensure maximum thickness of ¼in. (6mm) is not exceeded, when being overcoated with **Belzona® 1500** Series coatings.

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

Either allow to cure for at least 24 hours above 65°F (18°C) before putting into service. The system is designed to post cure in service.

This procedure is suitable for applications where operating temperature is above 140°F (60°C) and will be achieved at a rate of less than 55°F (30°C) per hour.

Alternatively, allow to harden at ambient temperature as above. Post cure for at least 4 hours at the operating temperature of the equipment or for at least 6 hours at 248°F (120°C). Temperature should not be increased at more than 55°F (30°C) per hour.

This procedure should be adopted for any application where immediate exposure to a hot aggressive environment or high mechanical loading will occur.

NOTE:

Surface temperature should be above 65°F (18°C) throughout the curing process.

5. OVERCOATING WITH BELZONA® 1300 OR 1500 SERIES COATINGS

Allow the **Belzona® 1511** to cure for at least 6 hours at temperatures above 65°F (18°C).

Grit blast to produce a frosted appearance, free of all gloss. A profile of 1.5 mils (40 microns) should be aimed for. Remove debris and degrease with **Belzona® 9111** or any other effective cleaner which does not leave a residue e.g. MEK.

Apply **Belzona® 1300 or 1500** Series coating as described in the relevant Instructions For Use Leaflet.

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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ISO 9001:2008
Q 09335
ISO 14001:2004
EMS 509612

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