



BELZONA® 1341 (SUPERMETALGLIDE)



Certified to
ANSI/NSF 61

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.

- 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.

ii) SURFACES ALREADY REBUILT WITH BELZONA® 1111 (SUPER METAL)

- a) If overcoating takes place within 2 hours, no further surface preparation is required.
- b) After this maximum overcoating time has elapsed roughen the **Belzona® 1111**, preferably by brush blasting before applying **Belzona® 1341**.

2. COMBINING THE REACTIVE COMPONENTS

- a) Stir the contents of the Base container thoroughly to reincorporate any settlement.
- b) Transfer the entire contents of the Solidifier can into the Base module.
- c) Mix thoroughly together to achieve a uniform material free of any streakiness.

NOTES:

1. MIXING LARGE UNITS

When mixing 5 kg. units of **Belzona® 1341**, use a mechanical mixer, ensuring that material on the side and at the corners of the container is fully incorporated. Avoid incorporation of excessive amounts of air into the mixed material.

2. 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).

3. WORKING LIFE

From the commencement of mixing, **Belzona® 1341** must be used within the times shown below.

Temperature	50°F (10°C)	59°F (15°C)	77°F (25°C)	86°F (30°C)
Use all material within	70 min.	50 min.	25 min.	16 min.

4. MIXING SMALL QUANTITIES

For mixing small quantities of **Belzona® 1341** use:
3 parts Base to 2 parts Solidifier by volume
2 parts Base to 1 part Solidifier by weight

5. VOLUME CAPACITY OF MIXED BELZONA® 1341

31.73 cu.in. (520 cm³) per 750g unit
212 cu.in. (3.475 liters) per 5 kg unit

3. APPLYING BELZONA® 1341

FOR BEST RESULTS

Do not apply when:

- i) The temperature is below 50°F (10°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) FIRST COAT

Apply the **Belzona® 1341** directly on to the prepared surface with a stiff bristled brush or with the plastic applicator provided. To achieve the correct film thickness of 10 mil (250 microns), a practical coverage rate of 19.5 sq. ft (1.8 m²) per 750g unit or 130 sq. ft (12 m²) per 5 kg unit should be obtained.

b) SECOND COAT

As soon as possible after application of the first coat, apply a further coat of **Belzona® 1341** as in (a) above. This time will be approximately 4 hours at 68°F (20°C). The first coat must not be left longer than 24 hours before overcoating, irrespective of temperature. Should this occur, then the surface should be brush blasted or abraded before commencing application.

SPRAY APPLICATION

On suitable areas, **Belzona® 1341** may be applied by heated airless spray. Typical set up would be 63:1 airless spray unit with either in-line heater or trace heated lines capable of raising product temperature to at least 122°F (50°C). Solvent must **NOT** be added. Please contact Belzona direct for more specific information.

DIFFERENTIATION BETWEEN LAYERS

Belzona® 1341 is available in blue and gray, to facilitate application and to prevent misses. In service the colour of the applied product may change.

CLEANING

Mixing tools should be cleaned immediately after use with **Belzona® 9111** or any other effective solvent e.g. Methyl ethyl ketone (MEK). Brushes, 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

Allow **Belzona® 1341** to solidify as below subjecting it to the conditions indicated.

Temperature	Movement or use involving no loading or immersion	Light loading	Full mechanical/thermal loading or water immersion	Chemical contact
50°F/10°C	24 hours	48 hours	14 days	21 days
59°F/15°C	12 hours	24 hours	7 days	10 days
68°F/20°C	8 hours	16 hours	3 days	7 days
77°F/25°C	7 hours	14 hours	2½ days	6 days
86°F/30°C	6 hours	12 hours	2 days	5 days

5. FINAL SOLIDIFICATION OF BELZONA® 1341

When time is important and equipment usage is pressing, then by installing forced air heaters and taking steps to contain this heat around the equipment being reclaimed, final solidification time can be as little as 24 hours. Application of heat should not be carried out until the **Belzona® 1341** has initially gelled (typically 4 hours at 68°F (20°C) and the material temperature should not exceed 122°F (50°C).

Due allowance must be made for "warming up". If there is any doubt regarding final solidification then **BE SAFE - MAKE MORE TIME.**



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BELZONA® 1341 IS APPROVED FOR CONTACT WITH POTABLE WATER SUBJECT TO THE FOLLOWING RESTRICTIONS:

For use on distribution line pumps of ³ 4 inch diameter with a minimum daily output of 4800 gallons per square foot of coated pump surface.

For use on tanks of >100,000 gallons.

HEALTH & SAFETY INFORMATION

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

All descriptions are based on the results of long term tests carried out in our laboratories and are believed to be true and accurate. No condition or warranty is given covering the results from the use of our products in any particular case, whether the purpose is disclosed or not, and we cannot accept liability if the desired results are not obtained.

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Belzona® 1341NSF - Instructions For Use - (Page 2)

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