

Belzona 1141

FN10016 (CONDUCTIVE METAL)



INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

APPLY ONLY TO CLEAN, FIRM, DRY AND WELL ROUGHENED 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). Use a flame to sweat out oil from deeply impregnated surfaces.
- Roughen surfaces by blast cleaning, deeply scoring or grinding. This surface preparation should ensure complete removal of all paint and oxide films for electrical contact with substrate.
- Finally degrease again. Use clean rags to avoid spreading contamination.

WHERE BELZONA® 1141 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® 1141** 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	60 min.	40 min.	25 min.

3. MIXING SMALL QUANTITIES

For mixing small quantities of **Belzona® 1141** use:
3.0 parts Base to 1 part Solidifier by volume
4.3 parts Base to 1 part Solidifier by weight

4. VOLUME CAPACITY OF MIXED BELZONA® 1141

51 cu.in. (833 cm³) per 1.5 kg unit.

3. APPLYING BELZONA® 1141

FOR BEST RESULTS

Do not apply when:

- The temperature is below 41°F (5°C) or the relative humidity is above 90%.
- 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.

FOR REBUILDING

- Apply the **Belzona® 1141** 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® 1141** to the correct profile with the plastic applicator or alternatively allow to cure and then machine down.

FOR BONDING

- a) Apply a thin smear of **Belzona® 1141** to both bonding surfaces.
- b) Press together to exude excess **Belzona® 1141** and scrape away.

FOR REPAIRING

- a) Spread the **Belzona® 1141** on to the **Belzona® 9341** (Reinforcement Tape).
- b) Apply the bandage to the area to be repaired with the coated side adjacent to the substrate.
- c) Apply a final coat of **Belzona® 1141** on top of the **Belzona® 9341**.

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

Allow **Belzona® 1141** 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 electrical, mechanical or thermal loading	Immersion in chemicals
50°F/10°C	10 hours	1 day	3 days	12 days
59°F/15°C	5 hours	12 hours	2 days	7 days
68°F/20°C	2½ hours	4 hours	1 day	4 days
77°F/25°C	2 hours	3 hours	16 hours	2½ days
86°F/30°C	1 hour	2½ hour	12 hours	1½ day

These times are for a thickness of approximately 0.25 in (6 mm); they will be reduced for thicker sections and extended for thinner sections.

5. APPLICATION OF A FURTHER LAYER OF BELZONA® 1141

When a further layer of **Belzona® 1141** is required, this should be applied as soon as possible after the first layer. Once **Belzona® 1141** has become dimensionally stable then the surface must be roughened otherwise intercoat adhesion will be impaired.

HEALTH & SAFETY INFORMATION

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

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