

PRODUCT SPECIFICATION SHEET

BELZONA 1111

FN10132



GENERAL INFORMATION

Product Description:

A two component paste grade system for repairing and rebuilding machinery and equipment. Based on a silicon steel alloy blended with high molecular weight reactive polymers and oligomers. When cured, the material is durable yet fully machinable. Also used as a high strength structural adhesive for bonding or for creation of irregular load bearing shims with good electrical insulation characteristics. For use in Original Equipment Manufacture or repair situations.

Application Areas:

When mixed and applied as detailed in the Belzona Instructions for Use (IFU), the system is ideally suited for application to the following:

- | | | |
|--------------------|-----------------|----------------|
| - Shafts | - Keyways | - Pipes |
| - Hydraulic rams | - Engine blocks | - Tanks |
| - Bearing housings | - Casings | - Flange faces |

APPLICATION INFORMATION

Working Life

Will vary according to temperature. At 77°F (25°C) the usable life of mixed material is 15 minutes.

Cure Time

Cure times will vary depending on the ambient conditions and will be reduced for thicker sections and extended for thinner applications. Consult the Belzona IFU for specific details.

Volume Capacity

24.3 in³ (398 cm³)/kg.

Base Component

Appearance	Paste
Color	Dark gray
Gel strength at 77°F (25°C)	>150 g/cm HF
Density	2.70 - 2.90 g/cm ³

Solidifier Component

Appearance	Paste
Color	Light gray
Gel strength at 77°F (25°C)	40 - 150 g/cm QV
Density	1.64 - 1.70 g/cm ³

Mixed Properties

Mixing Ratio by Weight (Base : Solidifier)	5 : 1
Mixing Ratio by Volume (Base : Solidifier)	3 : 1
Mixed Form	Paste
Peak Exotherm Temperature	203 - 232°F (95 - 111°C)
Time to Peak Exotherm	33 - 41 mins.
Slump Resistance	nil at 0.5 inch (1.27 cm)
Mixed Density	2.41-2.61 g/cm ³

The above application information serves as introductory guide only. For full application details including the recommended application procedure/technique, refer to the Belzona IFU which is enclosed with each packaged product.

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ABRASION

Taber

The Taber abrasion resistance determined in accordance with ASTM D4060 with 1 kg load is typically:

H10 Wheels (Wet)	852 mm ³ loss per 1000 cycles
CS17 Wheels (Dry)	24 mm ³ loss per 1000 cycles

ADHESION

Tensile Shear

When tested in accordance with ASTM D1002, using degreased strips, grit blasted to a 3-4 mil profile, typical values will be:

Mild steel	2,790 psi (19.2 MPa)
Brass	1,650 psi (11.4 MPa)
Copper	2,060 psi (14.2 MPa)
Stainless steel	2,960 psi (20.4 MPa)
Aluminium	1,950 psi (13.4 MPa)

Pull Off Adhesion

When tested in accordance with ASTM D 4541/ ISO 4624, the pull off strength from grit blasted steel will be typically:

3240 psi (22.3 MPa)	68°F (20°C) cure
2980 psi (20.5 MPa)	212°F (100°C) cure

CHEMICAL RESISTANCE

Once fully cured, the material will demonstrate excellent resistance to most commonly found inorganic acids and alkalis at concentrations up to 20%.

The material is also resistant to hydro-carbons, mineral oils, lubricating oils and many other commonly found chemicals.

* For a more detailed description of chemical resistance properties, refer to relevant Chemical Resistance chart.

COMPRESSIVE PROPERTIES

When determined in accordance with ASTM D695 (1.0in/25.4mm thick test pieces), typical values will be:

Compressive Strength (Maximum)	Cure temperature
12525 psi (86.4 MPa)	68°F (20°C)
16645 psi (114.8 MPa)	212°F (100°C)

Compressive Strength (Yield)	Cure temperature
9620 psi (66.3 MPa)	68°F (20°C)
10955 psi (75.6 MPa)	212°F (100°C)

Compressive Modulus	Cure temperature
1.77 x 10 ⁵ psi (1217 MPa)	68°F (20°C)
1.75 x 10 ⁵ psi (1205 MPa)	212°F (100°C)

When determined using a modified version of ASTM D695, at thickness more representative of in service application, typical values will be:

Thickness	Compressive Strength (Yield)	Cure Temperature
0.24 in (6.0 mm)	13095 psi (90.3 MPa) 16450 psi (113.4 MPa)	68°F (20°C) 212°F (100°C)
0.12 in (3.0 mm)	14855 psi (102.5 MPa) 18980 psi (130.9 MPa)	68°F (20°C) 212°F (100°C)

Bonded to grit blasted mild steel (single side)

Thickness	Compressive Strength (Yield)	Cure Temperature
0.12 in (3.0 mm)	19910 psi (137.3 MPa) 23840 psi (164.4 MPa)	68°F (20°C) 212°F (100°C)

CORROSION PROTECTION

Corrosion Resistance

Will show no visible signs of corrosion after 5,000 hours exposure in the ASTM B117 salt spray cabinet.

FLEXURAL PROPERTIES

When determined in accordance with ASTM D790, typical values will be:

Flexural Strength	Cure temperature
9,600 psi (66.2 MPa)	68°F (20°C)
14,300 psi (98.6 MPa)	212°F (100°C)

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HARDNESS

Shore D

When determined in accordance with ASTM D2240, typical value will be:
84

Barcol

When determined in accordance with ASTM D2583, typical values will be:

85	Cure temperature
92	68°F (20°C)
	212°F (100°C)

HEAT RESISTANCE

Heat Distortion Temperature (HDT)

Tested to ASTM D648 (264 psi fiber stress), typical values obtained will be:

127°F (53°C)	Cure temperature
195°F (91°C)	68°F (20°C)
	212°F (100°C)

Heat Resistance

For many typical applications, the product is thermally stable up to 392°F (200°C) dry and 200°F (93°C) wet, and down to -40°F (-40°C)

IMPACT RESISTANCE

Impact Strength

The impact strength (reverse notched) when tested to ASTM D256 is typically:

0.69 ft.lb./in., 37 J/m	Cure temperature
0.73 ft.lb./in., 39 J/m	68°F (20°C)
	212°F (100°C)

SHELF LIFE

Separate base and solidifier components shall have a shelf life of at least 5 years when stored between 32°F (0°C) and 86°F (30°C).

APPROVALS/ACCEPTANCES

The material has received recognition from organizations worldwide including:

AMERICAN BUREAU OF SHIPPING
U.S.D.A.
RUSSIAN REGISTER OF SHIPPING
KOREAN REGISTER OF SHIPPING
CHINA CLASSIFICATION SOCIETY
UK WRAS
BUREAU VERITAS

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WARRANTY

Belzona guarantees this product will meet the performance claims stated herein when material is stored and used as instructed in the Belzona Information For Use leaflet. Belzona further guarantees that all its products are carefully manufactured to ensure the highest quality possible and tested strictly in accordance with universally recognised standards (ASTM, ANSI, BS, DIN, ISO etc.). Since Belzona has no control over the use of the product described herein, no warranty for any application can be given.

AVAILABILITY AND COST

Belzona 1111 is available from a network of Belzona Distributors throughout the world for prompt delivery to the application site. For information, consult the Belzona Distributor in your area.

HEALTH AND SAFETY

Prior to using this material, please consult the relevant Material Safety Data Sheets.

MANUFACTURER

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TECHNICAL SERVICE

Complete technical assistance is available and includes fully trained Technical Consultants, technical service personnel and fully staffed research, development and quality control laboratories.

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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