

Belzona 1212

FN 10174



INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

Belzona® 1212 is tolerant of surface preparation; however, it is recommended that the best possible surface preparation is carried out. As a minimum, the substrate surface must always be clean and firm. Roughen surfaces by blast cleaning, deeply scoring or grinding.

Minimum Recommended Preparation:

Power tool clean to achieve a minimum SSPC-SP11 bare metal power tool cleaned surface (ISO 8501-1 St3, SIS 05 5900 St3).

2. COMBINING THE REACTIVE COMPONENTS

Transfer the required amount of material onto a **Belzona® Working Surface** or similar. Mix thoroughly together with a plastic spatula to achieve a uniform material free of any streakiness.

1. MIXING SMALL QUANTITIES

For mixing small quantities of **Belzona® 1212** use:

- 1 part Base to 1 part Solidifier by volume
- 5 parts Base to 6 parts Solidifier by weight

2. MIXING AT LOW TEMPERATURES

To ease mixing when the material temperature is below 50°F/10°C, warm the containers to between 68°F/20°C and 104°F/40°C.

3. WORKING LIFE

From the commencement of mixing, **Belzona® 1212** must be used within the times shown below:

Temperature	Working Life
41°F/5°C	20 minutes
50°F/10°C	16 minutes
68°F/20°C	9 minutes
86°F/30°C	6 minutes
104°F/40°C	4 minutes

4. VOLUME CAPACITY OF MIXED BELZONA® 1212

12.9 in³ / 212 cm³ per 450g unit

3. APPLYING BELZONA® 1212

- Apply the mixed **Belzona® 1212** directly on to the prepared surface with a suitable application tool.
- Press down firmly to fill all cracks, remove entrapped air, and ensure maximum contact with the surface.

- Over cracks, gaps and holes, stipple in **Belzona® 9341** (Reinforcement Tape).
- Contour the **Belzona® 1212** to the correct profile with an applicator or allow the **Belzona® 1212** to cure and then machine down if required.

CLEANING

Mixing and application tools should be cleaned immediately after use with **Belzona® 9111**, **Belzona® 9121**, or any other effective solvent e.g. Methyl ethyl ketone (MEK) or acetone.

4. COMPLETION OF THE MOLECULAR REACTION

Allow **Belzona® 1212** to solidify as below before subjecting it to the conditions indicated.

Temperature	Machinable	Light Loading	Full Loading
41°F/5°C	2½ hours	5 hours	16 hours
50°F/10°C	2 hours	4 hours	12 hours
68°F/20°C	40 minutes	90 minutes	8 hours
86°F/30°C	30 minutes	60 minutes	5 hours
104°F/40°C	20 minutes	30 minutes	2½ hours

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

POST CURE

The mechanical properties, heat resistance and chemical resistance of **Belzona® 1212** may be improved by post curing.

Once the **Belzona® 1212**, has reached the 'Machinable' level of cure, it can be post-cured at a temperature between 50°C/122°F and 100°C/212°F for 1-2 hours using forced air heaters, heat lamps, etc.

5. APPLICATION OF A FURTHER LAYER OF BELZONA® 1212

Where this is required it should be applied as soon as possible after the first layer. Typically, at 20°C/68°F a second layer can be applied up to 8 hours later without additional preparation.

If the above overcoating time is exceeded the surface of **Belzona® 1212** must be roughened by abrading or flash blasting before applying further **Belzona® 1212**.

HEALTH & SAFETY INFORMATION

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

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

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