



BELZONA® 1251 (HA - METAL)

INSTRUCTIONS FOR USE

Belzona® 1251 is designed to be applied to hot surfaces 158-302°F (70-150°C). All surface preparation and application procedures should be carried out after due review of health and safety.

1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

Belzona® 1251 is tolerant of surface preparation, however, it is recommended that the best possible surface preparation is carried out. As a minimum, substrate surface must always be clean and firm.

RECOMMENDED PROCEDURE

- Brush away loose contamination and remove any oil and grease with a cleaner that will not leave a residue and is suitable for use on hot surfaces and in the application environment.
- Roughen surfaces by blast cleaning, deeply scoring or grinding.

2. APPLYING BELZONA® 1251

- Belzona® 1251** is a single component product and so no mixing or measuring is required. Cure will not commence until the product is heated, hence the useable life is effectively unlimited, providing the material is stored as described in Section 4.
- Belzona® 1251** is designed to be applied to hot surfaces 158-302°F (70-150°C) so that cure will take place in service.
- Apply the **Belzona® 1251** directly on to the prepared surface with a plastic applicator or spatula.
- Press down firmly to fill all cracks, remove entrapped air, and ensure maximum contact with the surface.
- Due to flow out of **Belzona® 1251** on heating, the maximum recommended thickness for vertical applications is 1/8in. (3mm). For horizontal applications the maximum recommended thickness is 1/4in. (6mm).
- Avoid application of **Belzona® 1251** onto areas where it is not required.
- After application, proceed to step 3 in order to ensure the **Belzona® 1251** is fully cured.

NOTES:

1. **VOLUME CAPACITY OF BELZONA® 1251**
24.6 cu.in. (403 ccs) per 1kg.

2. CLEANING

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

3. COMPLETION OF THE MOLECULAR REACTION

Cure **Belzona® 1251** using the recommended schedules below:

Cure temperature	Light loading	Full thermal or mechanical loading	Optimum heat resistance
158°F (70°C)	1¼ hours	5 hours	7 days
185°F (85°C)	25 min.	2 hours	5 days
212°F (100°C)	15 min.	1 hour	3 days
239°F (115°C)	15 min.	1 hour	1 day

IMPORTANT: Additional time must be allowed for the component and repair to heat through. This time will be dependent on the size of the component and thickness of the Belzona® repair.

For a 1/4in. (6mm) deep repair it is suggested that an extra 15-30 minutes heating will be required to heat the repair through.

NOTE: If the **Belzona® 1251** is not completely hard after heating, or remains glossy, then more cure time is required. If in doubt, heat for longer.

If substrate temperature is below 158°F (70°C), additional curing as follows must be carried out. The use of a temperature controlled oven is recommended, but hot air blowers, such as electric paint strippers can be used for small repairs, if the following guidelines are observed.

- Surface thermometers (Mercury/Alcohol bulb thermometers are not suitable) must be used to monitor substrate temperatures being achieved. It is not sufficient to measure air temperature.
- To avoid local overheating keep the heater moving over the surface and indirect heating of the Belzona® by heating the surrounding metal is preferred.

- c) Maintain temperature between 158-302°F (70-150°C).
- d) Do not exceed 356°F (180°C).

4. STORAGE

Due to the heat cure mechanism of this material when not in use avoid storing the product above ambient temperatures and, if possible, keep refrigerated. Shelf life at 68°F (20°C) will be at least 18 months.

5. OVERCOATING

Application of subsequent layers of **Belzona® 1251** can be carried out up to 3 days after the previous application without need of any surface treatment other than removal of contamination.

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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