



BELZONA® 2141

INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

- a) Remove all loose surface contamination and degrease with **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.
- e) Immediately, apply a thin, even coat of **Belzona® 2941** onto the surface. A brush should be used as a stipple.

The **Belzona®** Conditioner must be touch dry before overcoating with **Belzona® 2141**. This will depend on the prevailing temperature, relative humidity and substrate. At 68°F (20°C) and 50% relative humidity, the touch dry state will be achieved after the times given when applied to a steel surface.

Conditioner	Touch Dry	Max. Overcoating
Belzona® 2941	4 hours	24 hours

Under no circumstances should application of **Belzona® 2141** take place after the maximum overcoating time.

When using **Belzona® 2141** to overcoat a surface which has been treated with a **Belzona® 1000 Series** product (except **Belzona® 1221** (Super E-Metal)), the **Belzona® 1000 Series** product must first be allowed to fully cure, the surface prepared as outlined in section 1.

Application of **Belzona® 2141** over **Belzona® 1221** can be carried out up to 4 hours after the application of **Belzona® 1221** without the need of any surface treatment other than removal of contamination. When overcoating **Belzona® 1221** after this time, the surface should be abraded, followed by conditioning as in Section 1(e).

WHERE BELZONA® 2141 SHOULD NOT ADHERE

Brush on **Belzona® 9411** (Release Agent) and allow to dry for 15 - 20 minutes before proceeding to step 2.

2. COMBINING THE REACTIVE COMPONENTS

Both Base and Solidifier components must remain sealed until the application stage.

- a) Transfer the entire contents of the Base into the Solidifier container.
- b) Immediately mix together for at least two minutes and use all material within the times shown in the table below:-

Temperature	59°F (15°C)	77°F (25°C)	86°F (30°C)
Use all material within	25 min	13 min	10 min

VOLUME CAPACITY OF MIXED BELZONA® 2141

682 cm³ per 750g unit.

3. APPLYING BELZONA® 2141

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 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.

Apply the **Belzona® 2141** to the conditioned surface with a stiff bristled brush or the plastic applicator provided, to give a coverage rate of 6.6 sq.ft. (0.61 m²) at 40 mil (1 mm) thickness.

CLEANING

Mixing tools should be cleaned immediately after use with **Belzona® 9111** or any other effective solvent e.g. MEK. Brushes, injection guns and 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® 2141** to solidify as below before subjecting it to the conditions indicated:

	Movement or use involving no loading or immersion	Full mechanical or thermal loading	Immersion in chemicals
41°F/ 5°C	6 hours	3 days	5 days
50°F/10°C	4 hours	2 days	3½ days
59°F/15°C	3 hours	2 days	3 days
68°F/20°C	2 hours	1 day	2½ days
77°F/25°C	1½ hours	1 day	2 days
86°F/30°C	1 hour	1 day	1½ days

5. STORAGE

Store in a dry environment between 41°F (5°C) and 77°F (25°C).

Inadvertent storage of **Belzona® 2100** Base below 41°F (5°C) or **Belzona® 2141** Solidifier below 15°C may result in partial solidification. If this occurs, the material can be restored to its normal form by resealing the container and warming to between 104°F (40°C) and 122°F (50°C) for 3 hours in a well ventilated, dry area.

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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