



BELZONA® 3921 (GSC Surface Conditioner)

INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

a) MANUALLY PREPARED STEELWORK

All loose adherent and flaking rust should be removed by scraping and wire brushing, wherever possible with the aid of mechanical equipment, until a firm edge is obtained. Where the steel to be treated is contaminated by chemicals, it must first be thoroughly cleaned. In the case of water soluble materials, e.g. metal salts, this can be done by repeated washing by water jet. In the case of oils, grease or other solvent soluble contaminants, the steel should be washed repeatedly with **Belzona® 9111** or other suitable cleaner such as MEK, and must be allowed to completely evaporate prior to application of the **Belzona® 3921**.

b) GRIT BLASTED STEELWORK

Steel contaminated by chemicals should first be thoroughly cleaned using a high pressure water jet whilst steel contaminated by oil, grease etc. must first be thoroughly washed down with **Belzona® 9111** or other suitable cleaner such as MEK. 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

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.

c) GLASS, SLATE, LEAD, COPPER, ALUMINIUM and other NON-POROUS SURFACE EXCEPT PLEXIGLAS and other PLASTICS.

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).

2. COMBINING THE REACTIVE COMPONENTS

Stir the contents of the Base container thoroughly to reincorporate any settlement. Shake the Solidifier container. Pour the contents over the Base in the mixing unit. Mix thoroughly together to achieve a uniform material free of any streakiness.

WORKING LIFE

Use mixed material within 48 hours, as after this time it will begin to solidify.

MIXING SMALL QUANTITIES

For mixing small quantities of **Belzona® 3921** use:
5 parts Base to 2 parts Solidifier by volume.

3. APPLYING BELZONA® 3921

FOR BEST RESULTS

Do not apply when:

- i) Rain, snow, fog or mist is present.
- ii) The temperature is below 41°F (5°C) or the relative humidity is above 80%.
- iii) A combination of high relative humidity and low temperature occurs.
- iv) Any of the above conditions is likely to occur within 45 minutes.

Brush the **Belzona® 3921** well into the surface, not exceeding the recommended coverage rate.

Clean brushes immediately after use with a suitable solvent such as **Belzona® 9121**, MEK, acetone or cellulose thinners.

THINNING

Thinning may be necessary in warm, dry or windy conditions.

Belzona® 3921 may be thinned by adding 10% by volume of **Belzona® 9121**. Standard coverage rates apply, regardless of whether or not thinning takes place.

Substrate	Coverage rate
Iron / Steel	5.6 m ² / kg.
Galvanised Steel	6.5 m ² / kg.
Non-ferrous metals	7.4 m ² / kg.
Slate	4.6 m ² / kg.
Glass	7.4 m ² / kg.

Belzona® 3921 may be spray applied only to grit blasted steelwork.

A typical spray set-up for **Belzona® 3921** using a Pressure Feed spray gun is:-

DeVibloss JGA 502-1, No 54 air cap,
Atomising pressure 40-50 p.s.i. (2.8-3.5 kg/cm²)
Pot pressure 10-20 p.s.i. (0.7-1.4 kg/m²)
with air supply 9.7 cu.ft./min (0.27 m³/min).

CLEANING

Clean all application equipment immediately after use with **Belzona® 9121**. It is not satisfactory to simply soak equipment in **Belzona® 9121** as **Belzona® 3921** continues to harden chemically even when immersed.

OVERCOATING

Belzona® 3921 may be overcoated after leaving for at least 4 hours, but no longer than 48 hours. If left longer than 48 hours a further coat of **Belzona® 3921** should be applied and left for the previously recommended times.

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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