

Belzona 6111

FN10108 (LIQUID ANODE)



INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE BOND

Thoroughly clean steel contaminated by chemicals using a high pressure water wash. Steel contaminated by oil, grease, etc., must first be thoroughly washed down with **Belzona® 9111** (Cleaner/Degreaser), **Belzona® 9121** (Universal Thinner) or any other effective cleaner which does not leave a residue, e.g. methyl ethyl ketone (MEK).

Blast clean the steel to be treated with **Belzona® 6111** to ensure intimate contact between the steel and the **Belzona® 6111**.

The minimum standards of cleanliness are:-

ISO 8501-1 Sa 2½ - very thorough blast cleaning
American Standard - near white finish SSPC-SP-10
Swedish Standard - Sa 2½ SIS 05 5900

The selection of abrasive grit is dependent upon the condition of the steel and recovery conditions. Abrasives can be either metallic or non-metallic and when cleaning to the required standard, a profile depth of 2 - 3 mil (50 - 75 microns) should be obtained.

2. COMBINING THE REACTIVE COMPONENTS

Belzona® 6111 is a two component material - Base and Solidifier. Immediately after blast cleaning the steel surface, prepare the **Belzona® 6111** for application by first stirring the Base component to achieve an even consistency. Slowly add the entire contents of the Solidifier can, stirring all the time until complete mixing is achieved.

3. APPLYING BELZONA® 6111

APPLICATION OF FIRST COAT

(For spray details see below)

Apply the first coat of **Belzona® 6111** within two hours of blast cleaning, with a clean, good quality, short bristled brush, ensuring that all edges, crevices and bolt heads are evenly coated. In order to achieve the required dry film thickness, do not exceed the average practical coverage rate shown overleaf.

APPLICATION OF SECOND COAT

Apply the second coat of **Belzona® 6111** within the recommended overcoat time (see "Technical Data", overleaf). Once again, to achieve the required dry film thickness do not exceed the average practical coverage rate shown overleaf.

NOTES:

1. CLEANING EQUIPMENT

Clean all application equipment IMMEDIATELY after use with **Belzona® 9121**. It is not satisfactory to simply soak equipment in **Belzona® 9121** as **Belzona® 6111** continues to harden chemically even when immersed.

2. SPRAYING

A typical spray set-up for **Belzona® 6111** using a Pressure Feed spray gun is:-

DeVilbiss JGA 502-1, No 54 air cap, EX-Fluid Needle and tip.

Atomizing pressure 40 - 50 p.s.i. (2.8 - 3.5 kg/sq.cm.)

Pot pressure 10-20 p.s.i. (0.7 - 1.4 kg./sq.m.) with air supply 9.7 cu.ft./min.(0.27 cu.meter/min.).

Adequate ventilation and exhaust facilities must be provided at all times.

3. STORAGE

Belzona® 6111 and **Belzona® 9121** are flammable in the liquid state. They should, therefore, be stored in a cool place away from naked lights.

4. THINNING

In hot, dry atmospheres, strong winds or for certain low pressure spray equipment, the **Belzona® 6111** can be diluted with up to 5% **Belzona® 9121**.

4. TECHNICAL DATA

USABLE LIFE

Once mixed, Belzona® 6111 has a usable life which will vary with temperature as indicated below:-

Temperature	Usable Life
50°F (10°C)	72 hours
68°F (20°C)	48 hours
86°F (30°C)	24 hours

Mixed material reaching the limit of its usable life should never be blended with freshly mixed material.

DRYING TIMES

(1½ mils. dry film thickness - 38 microns)

Temperature	Touch Dry Time	Overcoating Time		Full Cure
		Min.	Max	
50°F/10°C	17 min.	32 hours	7 days	10 days
68°F/20°C	8 min.	16 hours	5 days	7 days
86°F/30°C	3 min.	8 hours	3 days	5 days

RECOMMENDED FILM THICKNESS PER COAT:

Wet 3 mils. (76 microns)

Dry 1½ mils. (38 microns)

PRACTICAL COVERAGE RATE

The average practical coverage rate for two coats at 1½ mils. (38 microns) dry film thickness per coat (total 3 mils. (76 microns)) is 19.4 sq.ft. (1.8 m²) per kg.

TOTAL SOLIDS (Mixed)

By weight 84.0%

By volume 49.0%

MIXING RATIO

3.5 parts Base to 1 part Solidifier by volume

12.5 parts Base to 1 part Solidifier by weight

CHEMICAL RESISTANCE

If the Belzona® 6111 system is likely to come into contact with aggressive chemicals, Belzona® 5111 (Ceramic Cladding) should be used to overcoat the Belzona® 6111.

APPLICATION CONDITIONS

Application should not be carried out below 50°F (10°C), when the relative humidity is above 90%, when there is moisture on the surface, or during rain, snow, fog or mist.

HEALTH & SAFETY INFORMATION

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

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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