

# Belzona 1212

FN 10174



## INSTRUCTIONS FOR USE

### 1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

**Belzona® 1212** is tolerant of surface preparation and can be applied directly to wet and oily surfaces, however it is recommended that the best possible surface preparation is carried out. As a minimum, the substrate must always be firm and free from loose corroded material, mill scale, dust, and any other loose debris."

#### 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 in<sup>3</sup> / 212 cm<sup>3</sup> 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.

## POTABLE WATER

To comply with UK WRAS, the product should be cured as follows before contacting potable water.

Temperature	Cure time	Temperature	Cure time
5°C	3¼ days	20°C	24 hours
10°C	2½ days	30°C	16 hours

## 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 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.

Nothing in the foregoing statement shall exclude or limit any liability of Belzona to the extent such liability cannot by law be excluded or limited.

Copyright © 2017 Belzona International Limited. Belzona® is a registered trademark.

*Belzona products are  
manufactured under an  
ISO 9001 Registered  
Quality Management System*

