

Belzona 8111

FN10161 (MOULDABLE WOOD)



INSTRUCTIONS FOR USE

1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

APPLY ONLY TO CLEAN, FIRM, DRY SURFACES.

- Cut away loose, rotted woodwork with a sharp knife or chisel, back to a solid substrate.
- Abrade all surfaces to remove old paint, powdery deposits, etc.
- Remove all grease, oil and dirt by washing with a detergent solution or wiping with **Belzona® 9111** (Cleaner/Degreaser) or any other effective cleaner which does not leave a residue e.g. methyl ethyl ketone (MEK). Use a flame to sweat out oil from deeply impregnated surfaces.

WHERE BELZONA® 8111 SHOULD NOT ADHERE

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

Porous surfaces should be sealed initially by coating with a suitable lacquer.

2. COMBINING THE REACTIVE COMPONENTS

Pour the required volume of **Belzona® 8111** Reactive Liquid into a suitable mixing container.

Add a small quantity of **Belzona® 8111** Fibrous Wood.

Mix thoroughly. Add more Fibrous Wood as required to achieve the ideal consistency. Complete mixing within 2 - 3 minutes.

NOTES:

1. WORKING LIFE

From the commencement of mixing, **Belzona® 8111** must be used within the times shown below:

Temperature	41°F (5°C)	59°F (15°C)	77°F (25°C)
Use all material within	20 min.	12 min.	8 min.

2. MIXING RATIO

There is no specific mixing ratio for **Belzona® 8111**. However, a mix of 3 parts by weight of Reactive Liquid to 2 parts by weight of Fibrous Wood will give a smooth paste, while a mix of 3 parts by weight of Reactive Liquid to 1 part by weight of Fibrous Wood will give a casting consistency.

3. APPLYING BELZONA® 8111

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.

1. REBUILDING

- Apply to the prepared surface using the spatula or plastic applicator provided. Press well down to remove entrapped air.
- Leave sufficiently proud of the surface to allow for subsequent machining, or contour to shape by pressing a polyethylene sheet onto the uncured **Belzona® 8111**. This also prevents tackiness on the exposed surface.

2. CASTING

- Brush a thin layer of **Belzona® 8111** over the mold surfaces which have been previously been coated with **Belzona® 9411**.
- Fill the mold by pouring the remainder of the **Belzona® 8111**. Vibrate the mold to remove occluded air.

CLEANING

Mixing and application tools should be cleaned immediately after use with **Belzona® 9111**, or any other effective solvent e.g. MEK. Brushes, injection guns, spray equipment and any 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® 8111** to solidify as below before subjecting it to the conditions indicated:

	Machining and/or light loading	Full mechanical loading
41°F/ 5°C	40 min.	60 min.
50°F/10°C	30 min.	40 min.
59°F/15°C	20 min.	30 min.
68°F/20°C	15 min.	20 min.
77°F/25°C	10 min.	15 min.
86°F/30°C	5 min.	10 min.

These times are for a thickness of approximately 0.25 in. (6mm); they will be reduced for thicker sections and extended for thinner sections.

5. COLOR MATCHING

When fully cured, **Belzona® 8111** can be painted over or stained as with any other wood. However, best results will be obtained if wood stainers are incorporated with the **Belzona® 8111** Reactive Liquid before addition of the **Belzona® 8111** Fibrous Wood. When mixing in any stainers, no more than 2% by volume should be added. Greater additions will affect the cure time and subsequent physical properties.

6. VOLUME CAPACITY

At a mixing ratio of 3 parts Reactive Liquid to 2 parts Fibrous Wood the volume capacity of **Belzona® 8111** is 746 ccs. (45.5 cu³) per kg.

HEALTH & SAFETY INFORMATION

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

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ISO 9001:2008
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ISO 14001:2004
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