

# Belzona 9631

FN10194



## INSTRUCTIONS FOR USE

### 1. TO ENSURE AN EFFECTIVE MOLECULAR WELD

FOR BEST RESULTS APPLY TO CLEAN, FIRM AND WELL ROUGHENED SURFACES.

#### i) Metallic Surfaces

- 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). Where necessary, use a flame to sweat out oil from deeply impregnated surfaces.
- Roughen surfaces by grinding or deeply scoring.
- Stabilise cracks by drilling the extremities. Long cracks should be drilled, tapped and bolted every 3 - 4 inches (75-100mm).
- Vee-out cracks using a rotary file.
- Degrease again, using the alcohol wipes supplied to avoid spreading contamination.

#### ii) Flexible Surfaces (e.g. Plastic surfaces such as PVC and fiberglass)

- Undercut fine edges with a sharp knife and scuff the surface with a rotary wire brush, hacksaw blade or suitable roughing tool.
- Brush away loose contamination.
- Degrease surface using alcohol wipes.

#### WHERE BELZONA® 9631 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.

### 2. PREPARING FOR USE

- Do not open foil sachet until ready to use as reaction commences on exposure to moisture in the atmosphere.
- Using gloved hands, open the foil pouch, remove **Belzona® 9631** roll and immediately immerse in clean water at 5 - 40°C for 20 seconds to activate **Belzona® 9631**.

#### NOTES:

##### 1. Working Life

After immersion in water, **Belzona® 9631** must be used within the times shown below.

Temperature	41°F(5°C)	50°F(10°C)	68°F(20°C)	104°F(40°C)
Use all material within	12 min.	6 min.	3 min.	1.5 min.

### 3. APPLYING BELZONA® 9631

#### FOR BEST RESULTS

##### Do not apply when:

- The temperature is below 41°F (5°C).
- Snow is present.
- The working environment is likely to be contaminated by oil/grease from adjacent equipment or smoke from kerosene heaters or tobacco smoking.

#### a) APPLICATION OF BELZONA® 9631

Immediately wrap **Belzona® 9631** around the damaged area ensuring **Belzona® 9631** extends at least 25mm either side of the damaged area. If necessary, apply in a spiral fashion with a 50% overlap. Apply **Belzona® 9631** with tension to prevent any trapped air and to ensure good contact to the substrate. Ensure a minimum of 9 layers of **Belzona® 9631** are applied over the damaged area.

#### b) APPLICATION OF ADDITIONAL WRAPS

In the event additional wraps of **Belzona® 9631** are required, repeat Steps 2 - 3a. Apply additional wraps immediately onto **Belzona® 9631**.

#### c) APPLICATION OF RELEASE FILM

Immediately after applying **Belzona® 9631**, wrap the release film over the repair area in a spiral fashion. Apply tension to compress **Belzona® 9631**. Secure taut at both ends by the application of adhesive tape. Make small punctures in the release film to enable carbon dioxide to escape during cure.

### 4. COMPLETION OF THE MOLECULAR REACTION

**Belzona® 9631** will be hard in 60-90 minutes at 68°F (20°C) but curing will take longer in dry climates or cold temperatures.

## HEALTH & SAFETY INFORMATION

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

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