

Belzona Repair Procedures for AURES

Date: 1/14/99
Prepared By: JTM
Approved By: _____

Observe Safety Precautions IAW P-5100.1, OSHA Instructions and
Manufacturers Labels

1. **Surface Prep.** The area to be filled shall meet the minimum rejectable requirements of Table 4-2 as listed in SW394-AG-MMA-010, chapter 4. All defects shall be measured for an accurate depth and listed on the shop traveler as to the type of defect, depth, and exact location. Defects may have to be enlarged depending on geometry for greater adhesion.
For Casting Flaws, any edge that feathers into a machine area shall have the perimeter ground to provide a definitive edge to the shape of the defect. For Pits or Gas Holes, they will be Center Drilled to an approved depth to allow a sufficient amount of Belzona to enter the defect. These processes will be done to allow for greater adhesion.
For any other defect, the surface shall be roughed using a Dremel and a small grinding stone at a slow speed. This process should leave the surface finish looking like it was sanded with coarse sandpaper. Under no circumstances shall the Belzona be applied to a smooth shiny surface.
2. **Cleaning.** The area to be repaired shall be doused with Belzona Cleaner and allowed to air dry. For areas that are exposed to grease or oil, the area will have a low temperature flame applied to supply a localized heat to draw out any petroleum-based material. Any contaminants that are present will be visible as they cook out of the defect. The area will then be doused again, then heated to see if there are any further contaminants in the defect. After one final dousing, the defect is ready to have the Belzona applied.
3. **Mixing.** All mixing ratios shall be IAW the manufactures specifications. Under no circumstances shall the ratio of the mix be altered. The components of the product will be mixed until there is a smooth consistency and color with no stripes or swirls.
4. **Applying.** The mixture shall be applied to the defect in a thin smooth coat and worked into the defect to insure filling all the voids. A second coat will be applied immediately on top of the first coat and worked in to remove any air pockets that may form. The Belzona should be worked to a uniform height of at least 1/16" above the finish part surface. A straight edge will be used, and pulled firmly across the Belzona to give an approximate shape to the repair.
The repaired area will be allowed to harden IAW the manufacturers label and sanded to a suitable finish using medium grit sandpaper.

Missile Launch
Simulators

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Approval