

Mixing Hardener

PERSONAL PROTECTION

Please familiarise yourself with the Material Safety Data Sheets before starting. Personal Protection should be worn at all times, safety goggles, gloves, apron and overalls. If you have any queries please contact us on 028 41753738.

OVERVIEW

Thorough mixing of catalyst into resins and gelcoat is very important. The addition of the correct amount ensures the best results.

The table below gives the correct ratios of catalyst to resin and gelcoat by weight. 1% is considered a slow mix, 2% is ideal, 3% is a fast mix. Additions outside these bands in not recommended for proper curing. The addition of more than 4% may result in a failure to cure. The pot life of these mixes is also determined by temperature. The higher the temperature the faster the cure. As a general guide 2% addition at 20°C gives 15-20 minutes pot life. The resin cures quicker if left in a large quantity such as in the mixing bucket or in castings.

CATALYST MIXING RATIO

1gm of catalyst = 1cc

	500g	1kg	2kg	5kg	10kg	15kg
1%	5cc	10cc	20cc	50cc	100cc	150cc
1.5%	8cc	15cc	30cc	75cc	150cc	225cc
2%	10cc	20cc	40cc	100cc	200cc	300cc
3%	15cc	30cc	60cc	150cc	300cc	450cc

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