



Sprayglass SG23

System Catalyst Ratio

Table 1

Sprayglass System	Application Method	Standard Catalyst Ratio		
		10°C – 15°C	16°C – 20°C	21°C – 25°C+
200 & 400 Glass Flake coatings	Brush or Roller	1.5% - 2.0%	1.0% - 1.5%	1.0%
200 & 400 Glass Flake coatings	Airless Spray	1.25% - 1.5%	1.0% - 1.25%	1.0% - 1.25%
500 Glass Flake /SJ, 600 & 700 Laminates	Trowel	1.5% - 2.0%	1.0% - 1.5%	1.0%

CATALYST RATIOS

The Standard catalyst ratio is generally between 1% and 3%. The ratios shown in Table 1 above will provide the optimum balance between pot life and overcoating /cure times.

These ratios are for general guidance only and are subject to site conditions, production requirements and the experience of the individual applicator.

Use of less than 1% catalyst will not produce a full cure of the coating material. Inadequate mixing will lead to areas of unsatisfactory cure.

Table 2

Resin weight in kg	Amount of catalyst in cc to give percentage by volume					
	1.0%	1.25%	1.5%	2.0%	2.5%	3.0%
1	10	12.5	15	20	25	30
2	20	25	30	40	50	60
3	30	37.5	45	60	75	90
4	40	50	60	80	100	120
5	50	62.5	75	100	125	150
6	60	75	90	120	150	180
7	70	87.5	105	140	175	210
8	80	100	120	160	200	240
9	90	112.5	135	180	225	270
10	100	125	150	200	250	300
11	110	137.5	165	220	275	330
12	120	150	180	240	300	360
13	130	162.5	195	260	325	390
14	140	175	210	280	350	420
15	150	187.5	225	300	375	450
16	160	200	240	320	400	480
17	170	212.5	255	340	425	510
18	180	225	270	360	450	540
19	190	237.5	285	380	475	570
20	200	250	300	400	500	600
21	210	262.5	315	420	525	630
22	220	275	330	440	550	660
23	230	287.5	345	460	575	690
24	240	300	360	480	600	720
25	250	312.5	375	500	625	750