

CATLYST USAGE CHART				
Deck/Resin temp	29-35°C	21-28°C	13-20°C	6-12°C
Percentage Catalyst	1% Catalyst	2% Catalyst	3% Catalyst	4% Catalyst
Table of Percentages in Millilitres, Per Weight of Resin used				
Amount of Resin	Catalyst Usage			
1 Kilo	10 ml	20 ml	30 ml	40 ml
2 Kilo	20 ml	40 ml	60 ml	80 ml
3 Kilo	30 ml	60 ml	90 ml	120 ml
4 Kilo	40 ml	80 ml	120 ml	160 ml
5 Kilo	50 ml	100 ml	150 ml	200 ml
6 Kilo	60 ml	120 ml	180 ml	240 ml
7 Kilo	70 ml	140 ml	210 ml	280 ml
8 Kilo	80 ml	160 ml	240 ml	320 ml
9 Kilo	90 ml	180 ml	270 ml	360 ml
10 Kilo	100 ml	200 ml	300 ml	400 ml
11 Kilo	110 ml	220 ml	330 ml	440 ml
12 Kilo	120 ml	240 ml	360 ml	480 ml
13 Kilo	130 ml	260 ml	390 ml	520 ml
14 Kilo	140 ml	280 ml	420 ml	560 ml
15 Kilo	150 ml	300 ml	450 ml	600 ml
16 Kilo	160 ml	320 ml	480 ml	640 ml
17 Kilo	170 ml	340 ml	510 ml	680 ml
18 Kilo	180 ml	360 ml	540 ml	720 ml
19 Kilo	190 ml	380 ml	570 ml	760 ml
20 Kilo	200 ml	400 ml	600 ml	800 ml

### Catalyst Addition

There are a number of important rules of thumb to follow when deciding how much catalyst to add:

- Never use less than 1% even in the summer, just mix less resin at a time.
- Never use more than 4%, the gel time will not reduce any further beyond 4%.
- Never underestimate the effect of temperature, Resins will not cure at or below freezing and will always cure much quicker in direct sunlight.
- When topcoating late in the day, add more catalyst to allow for the lack of sunlight.
- In Winter use fast catalyst, in Summer use standard catalyst, in very hot conditions use LPT (Long Process Time) catalyst.
- Remember: Any catalysed resin left in the bucket will exotherm. Heat is generated as the resin cures, so it should be kept well away from other stored materials. Water can be poured over the resin to suppress the heat gain.
- Always mix the catalyst into the resin thoroughly before using the resin (i.e. a good couple of minutes for a 10 litre bucket.) Failure to do this can result in 'streaking' on the laminate, where streaks of uncured resin will remain visible and ultimately lead to a failure in the laminate.
- Fast cures can result in an inadequate bond.