

MIXING RATIOS FOR ACRYLIC & POLYESTER ADHESIVES

Recommended Hardener Quantities for Flowing and Knifegrade Acrylic & Polyester Adhesives

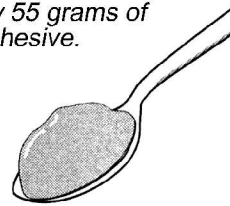
FLOWING ADHESIVE

Use this chart to convert grams to millimeters or approximate ounces (whichever you prefer).

Transparent	Colored
240g	370g
180g	260g
120g	180g
60g	100g
30g	40g
200ml (7 oz.)	
150ml (5 oz.)	
100ml (3.5 oz.)	
50ml (2 oz.)	
25ml (1 oz.)	

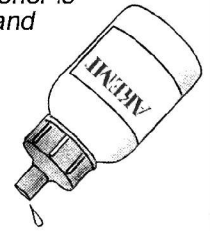
KNIFEGRAD ADHESIVE

1 heaping tablespoon equals approximately 55 grams of knifegrade adhesive.

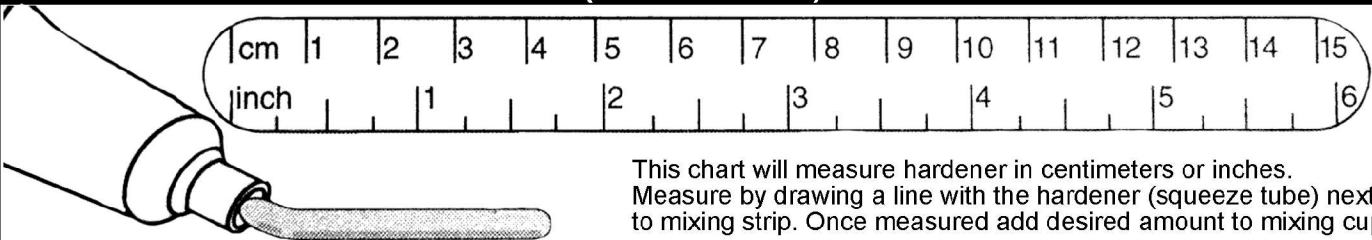


LIQUID HARDENER

Liquid hardener is measured and dispensed in drops.



BPO (WHITE TUBE) HARDENER



This chart will measure hardener in centimeters or inches. Measure by drawing a line with the hardener (squeeze tube) next to mixing strip. Once measured add desired amount to mixing cup.

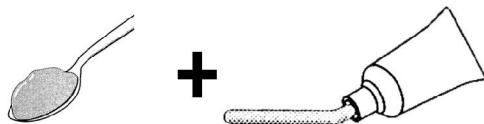
MIXING FLOWING ADHESIVE WITH BPO (White Tube) HARDENER



MIXING TRANSPARENT FLOWING ADHESIVE WITH BPO HARDENER							
TEMPERATURE		COLD ← → HOT					
AMOUNT OF RESIN		4% HARDENER		3% HARDENER		2% HARDENER	
ML	OUNCES	CM	INCHES	CM	INCHES	CM	INCHES
25ml	1 oz	6cm	2 1/4"	3cm	1 3/16"	2.5cm	1"
50ml	2 oz	13cm	5"	10cm	3 7/8"	6cm	2 1/2"
100ml	3.5 oz	30cm	11 5/8"	21cm	8 1/4"	13cm	5"
150ml	5 oz	50cm	19 1/2"	30cm	11 3/4"	21cm	8 1/4"
200ml	7 oz	60cm	23 1/2"	50cm	19 3/4"	30cm	11 5/8"

MIXING MARBLE FILLER COLORED FLOWING ADHESIVE WITH BPO HARDENER							
TEMPERATURE		COLD ← → HOT					
AMOUNT OF RESIN		4% HARDENER		3% HARDENER		2% HARDENER	
ML	OUNCES	CM	INCHES	CM	INCHES	CM	INCHES
25ml	1 oz	8cm	3 1/8"	6cm	2 3/8"	3cm	1 3/16"
50ml	2 oz	22cm	8 1/4"	19cm	7 1/2"	10cm	3 7/8"
100ml	3.5 oz	50cm	19 1/2"	30cm	11 3/4"	21cm	8 1/4"
150ml	5 oz	62cm	24 1/4"	52cm	20 1/2"	30cm	11 5/8"
200ml	7 oz	100cm	39 1/4"	70cm	27 5/8"	50cm	19 1/2"

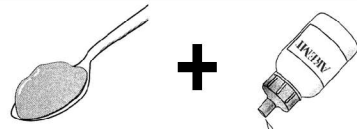
MIXING KNIFEGRAD MARBLE FILLER ADHESIVE WITH BPO HARDENER



MIXING 100 S SERIES KNIFEGRAD ADHESIVE WITH BPO HARDENER

AMOUNT OF RESIN	2% HARDENER
55 grams / 1 Tblsp.	5cm / 1 3/4"

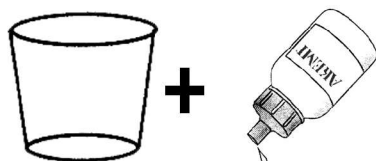
MIXING KNIFEGRAD ADHESIVE WITH LIQUID HARDENER



MIXING TRANSPARENT L-SPECIAL WATERCLEAR KNIFEGRAD ADHESIVE WITH LIQUID HARDENER

TEMPERATURE	COLD ← → HOT	
AMOUNT OF RESIN	2% HARDENER	1% HARDENER
GRAMS/TABLESPOONS	IN DROPS	IN DROPS
Approx. 35 grams	20 drops	10 drops

MIXING FLOWING ADHESIVE WITH LIQUID HARDENER



MIXING MARBLE FILLER 1000 TRANSPARENT FLOWING WATERCLEAR ADHESIVE WITH LIQUID HARDENER

TEMPERATURE		COLD ← → HOT	
AMOUNT OF RESIN		2% HARDENER	1% HARDENER
ML	OUNCES	IN DROPS	IN DROPS
25ml	1 oz	22 drops	12 drops
50ml	2 oz	48 drops	24 drops
100ml	3.5 oz	87 drops	48 drops
150ml	5 oz	124 drops	70 drops
200ml	7 oz	160 drops	87 drops

SPECIAL HINTS

- Clean & roughen surfaces to be bonded.
- Hardener portions higher than 4% reduce adhesion and deteriorate surface drying.
- Hardener portions less than 1% and low temperatures (under 5°C/41°F) will considerably delay hardening.
- Clean and protect hands in order to protect against contamination. We suggest Nitrile gloves.
- Polyester coloring paste should only be used with Polyester adhesives.
- Add no more than 5% of coloring paste to adhesive.