MIXING INSTRUCTIONS

MIXING INSTRUCTIONS FOR MARINE & INDUSTRIAL COATINGS

Incorrect proportioning and insufficient mixing are the cause of 90% of the problems encountered with two component coatings. Please read these instructions before using our products.

Proportioning must be done by weight, NOT by volume.

MIXING epoxy coatings is a simple, straightforward job but if not done correctly, the resulting sticky mess or failed application will be an upsetting, expensive and labour intensive job to rectify.

Epoxy resins will set to some degree over a range of mix ratios but properties such as heat, water and abrasion resistance will be considerably reduced. Tensile strength and inter-coat adhesion will suffer and an excess of hardener will render the coating more likely to 'bloom or blush'

Poorly mixed coatings have a patchy appearance, soon lose their gloss and pick up dirt.

The only way to guarantee that your application will provide the best long term performance is to follow these instructions.

MIXING All tins of resin should be pre-mixed before any hardener is added to ensure the resin is homogeneous. Epoxy resins and hardeners must be thoroughly mixed in the correct ratios to ensure complete curing of the product.

All XYMERTEC resins and coatings are supplied with the correct amount of hardener, all of which must be added to the tin or tub of resin and mixed well immediately before use.

Do not try to accelerate or retard setting of the material by varying the amount of hardener as this will cause the coating not to set at all, or to partly cure and prematurely fail.

Thorough mixing is also critical to the correct curing of the product and although small packs can be easily mixed by hand, a spiral mixer used in a pneumatic or cordless drill is essential for mixing larger packs.

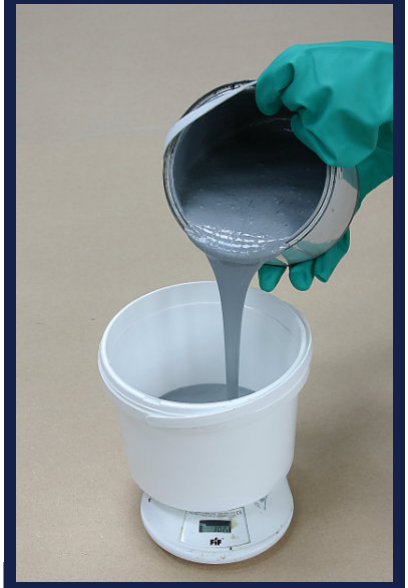
Ensure that the corners of small tins are well scraped with a flat stick in order to eliminate 'dead' spots of un-mixed material.
It is difficult, if not impossible to mix large cans of material with a power mixer without spillage, so after initially mixing the resin and hardener in the can pour it into another bucket and continue mixing. Using this method will ensure that the product is adequately mixed.

POT LIFE The pot life that is stated on the products data sheet will depend on the quantity and ambient temperature. The pot life of large quantities will be much shorter due to the rise in temperature caused by the curing reaction.

Pot life can be extended by pouring the mixed material into trays which will allow heat generated by the curing reaction to dissipate.

Do not mix more material than can be used within its pot life.
If a smaller amount is required than is in a pack, the components must be accurately weighed in the proportions shown below and on the product hardener label.

Digital kitchen scales are ideal for this purpose. Mechanical scales are not suitable for small quantities.



Digital kitchen scales can be used to weigh small quantities of our coatings.

Simply place an empty mixing pot on the scale, tare off the scale, pour out an approximate amount of resin. Calculate the amount of hardener required, tare off the scales again and accurately weigh in the hardener.

Proportioning by eye or by volume is not sufficiently accurate to achieve reliable results.

PLEASE REMEMBER that for good results you must proportion the components accurately by weight and mix thoroughly for several minutes.

Epoxy coatings must be mixed at a molecular level and an even colour is not an indication that the product has been sufficiently mixed.

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