

KRYSTALKOTE™ / KRYSTALTRED™ KRYSTALMARINE™ / MARINETRED™

CURING TIME / TEMPERATURE / ACCELERATOR COMPARISON TABLE

STAGE	45°F	60°F	75°F	85°F
"POT LIFE" or "GEL" Time	12-13 hrs.	6-7 hrs.	3-4 hrs.	2-3 hrs.
"TACK DRY" Time	4 hrs.	2 hrs.	1 hr.	45 min.
"TACK FREE" Time	8 hrs.	4 hrs.	2 hrs.	1 hr.
"STACK" Time	28 hrs.	16 hours	8 hours	4 hrs.
"CURE" Time	280 hrs. (12 days)	140 hrs. (6 days)	72 hrs. (3 days)	40 hrs. (1½ days)

"POT LIFE" Time = **Average maximum** length of time a mixed coating will retain proper viscosity (before gelling) for spray, brush or roller application.

"TACK DRY" Time = **Average** length of time before coating will feel slightly sticky or tacky, but will not transfer any material to the finger when touched.
Ideal Elapse Time Between Consecutive Coats.

"TACK FREE" Time = **Average elapse** time before coating no longer sticky or tacky to the touch.

"STACK" Time = **Average elapse** time before coated objects can be safely stacked, handled or moved.

"CURE" Time = **Average minimum** length of time before a coating will successfully test to maximal, desired characteristics.

ACCELERATOR

ALWAYS THOROUGHLY MIX **ACCELERATOR** INTO **BASE** BEFORE ADDING CURING AGENT.

One (1) CC (ml) per gallon of **ACCELERATOR** will decrease **ALL TIMES** by approximately 50% (or move right one column). An additional CC per gallon will decrease all times by another 50%.

Twenty-Five (25) DROPS = **One (1) CC (ml)** for 1-gallon

Six (6) DROPS = **One-Quarter (¼) CC** for 1-quart

Three (3) DROPS = **One-Eighth (⅛) CC** for 1-pint

Fifty (50) DROPS or **Two (2) CC** of **ACCELERATOR** per gallon, is the recommended maximum that should be added to any of the above coatings. Never use only **ACCELERATOR** to move more than two columns to the right.