

# Technical Bulletins

## Catalyst Addition Rates



Varying site conditions can affect the cure profile of polyester, vinyl ester and MMA resin systems.

Below is a catalyst addition table which can be used as a guide with regard to catalyst additional rates & site temperatures.

Ambient Temperature ° C	Catalyst addition rate % of resin	Catalyst addition rate mills per litre
0 – 10	5	50
10 - 15	4	40
15 - 20	3.5	35
20 – 25	3	30
25 - 30	2	20
35 +	1.5	15

All rates indicated above are calculations only, actual rates will depend on site conditions and specific surface finishes, allnex would always recommend a site trial be carried out to ensure cure profiles, material pot life and handling characteristics are established prior to the full installation.

For further advice or information do not hesitate to contact the allnex technical team.

Free Ph: 0508 88 22 88  
E-mail: [cs.constructionnz@allnex.com](mailto:cs.constructionnz@allnex.com)  
Website: [www.allnexconstruction.com](http://www.allnexconstruction.com)

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### Allnex Construction Products, a Division of Allnex New Zealand Ltd

Auckland - 14 Industry Road Penrose phone: 095836544. Hamilton - 18 Somerset Street Frankton phone: 07-847-8658  
Wellington - 19A Jamaica Drive Grenada North phone: 04-240-0305. Christchurch - 112 Carlyle Street Sydenham phone: 03-366-6802  
Customer Service: 0508-882-288 [cs.constructionnz@allnex.com](mailto:cs.constructionnz@allnex.com)  
[www.allnexconstruction.com](http://www.allnexconstruction.com)



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