

# CRYL-A-FLEX MIXING CHART

## CRYL-A-CURE MIX GUIDE

Product	Substrate / Material Temperature (°F)	Cryl-A-Cure (BPO) Volume ounces per 1 Gallon of resin or 1 quart of Cryl-A-Cove
Cryl-A-Prime P-101	40	8.5
	50	6.5
	60	5.0
	70	4.0
	80	3.0
	90	2.0
Cryl-A-Glaze G-201	40	11.0
	50	8.5
	60	6.5
	70	4.5
	80	3.5
	90	2.0
Cryl-A-Top T-301 Cryl-A-Top T-303	40	4.0
	50	3.5
	60	3.0
	70	2.5
	80	2.0
	90	2.0
Cryl-A-Cove Per 1 quart. Mix with 2 quarts of Q-28 or 1.5 quarts Q-11.	40	2
	50	1.5
	60	1.25
	70	1
	80	0.75
	90	0.5

## CRYL-A-BOND MIX GUIDE

### CRYL-A-BOND:

- Add 16 ounces (1 pint) of Cryl-A-Bond additive to 1 gallon of Cryl-A-Prime P-101.
- Add the appropriate amount of Cryl-A-Cure activator powder and mix for 45 seconds.

**IMPORTANT:** *The maximum re-coat time for Cryl-A-Bond additive is 16 hours. If the next coat is not applied within 16 hours the primer must be mechanically sanded and wiped with Cryl-A-Clean solvent. Failure to observe this could result in inadequate inter-coat adhesion.*

### CRYL-A-BOND MT:

- Add 1 gallon of Cryl-A-Prime P-101 resin to a clean and dry mixing pail.
- Add 0.5 volume ounces of Cryl-A-Bond MT & mix thoroughly for 30 seconds.
- Add 1 volume ounce of LTC Additive & mix thoroughly for 30 seconds.
- Add required amount of Cryl-A-Cure to pail and mix for 45 seconds.

# CRYL-A-FLEX MIXING CHART CONTINUED

## CRYL-A-FLEX SL SYSTEMS

Resin / Substrate Temperature (°F)	G-201 Resin (quarts)	SL Filler Blend 1 bag ( 40 lb)	Pigment - if required (volume ounce)	Cryl-A-Cure (volume ounce)
40	7	1	4	19.5
50	7	1	4	15
60	7	1	4	11.5
70	7	1	4	8
80	7	1	4	6.5
90	7	1	4	4

## LTC ADDITIVE FOR LOW TEMPERATURE APPLICATION

If the air / substrate temperature is below 40°F, use the following amounts of LTC (Low Temperature Cure) additive. The usage level is the same for all resins.

**Note:** The material must be conditioned to the application temperature. See above for the appropriate amount of Cryl-A-Cure. Always add LTC additive to resin first, pre-mix for 15 seconds then add Cryl-A-Cure and mix for 1 minute. The use of LTC additive and high levels of Cryl-A-Cure can cause yellowing.

Air / Substrate Temperature (°F)	Ounces of LTC Additive 1 gallon of resin
32	0.5
15	1.5
0	3.0

## CRYL-A-COLOR MIX

- 8 fluid ounces per gallon of resin or 4 fluid ounces per batch of SL Filler Blend.

**Please contact your local Dur-A-Flex Technical Services Manager with any questions.**