



HOW TO PROPERLY THIN AND ACCELERATE IMRON 3.5HG

TO ACHIEVE BETTER DRY TIMES YOU MIGHT HAVE TO ADD THINNER AND/OR ACCELERATOR TO IMRON DEPENDING ON THE TEMPERATURES. THIS CHART IS BASED ON A TEMPERATURE OF 70F , YOU WILL HAVE TO DECREASE THE DRY TIMES FOR COOLER TEMPERATURES AND INCREASE THEM FOR WARMER.

TEMP 70F TIME :HOURS	NO ACCELERATOR	2 OZ 389S	1 OZ VHY691	2 OZ VG805	1 OZ 8989S
DRY TO TOUCH	4-8	1	1	1.5	30 MIN
DRY TO RECOAT	5	1.5	1	3	45 MIN
DRY TO HANDLE	7	2	1.5	4.5	1
PACK/SHIP	24	16	8	8-10	8
FULL CURE	7 DAYS	6 DAYS	6 DAYS	6 DAYS	6 DAYS
POT LIFE	2-3	2-3	1.5	2.5	1
			REDUCES POT LIFE A LOT	TO INCREASE POT LIFE COMBINE 1 OZ 389S AND 1 OZ 8989S	

THINNER:

THIN NO MORE THAN 0-3% WITH 68083 IF HOT/WINDY USE Y32401