

# ALT Catalyst Guidelines



## Technical Data Sheet

The following table provides recommendations regarding catalyst additions to ALT PMMA resins. Catalyst may lose potency and/or effectiveness with improper storage or age, so applications using less than 2% catalyst addition is not recommended. The primary influence on resin curing is substrate temperature. However temperatures of the resin, substrate, air, as well as air movement, wind chill, and the applied resin layer thickness should be taken into account. Therefore, catalyst additions adjusted accordingly if the temperature difference between resin, air and substrate is 20 degrees greater or more. Refer to individual ALT product data sheets for additional information, requirements and recommended product specific application temperatures.

### ALT PMMA Resin Catalyst Recommendations



Normal recommended product application temperature range.



Outside normal recommended product application temperature range, USE WITH CAUTION.

ALT Product Name	Ambient Temperature °F (°C) / ALT Catalyst (% ratio to weight)												
<b>Standard Grade Resins</b>	14 (-10)	23 (-5)	37.4 (3)	41 (5)	50 (10)	59 (15)	68 (20)	77 (25)	86 (30)	95 (35)	104 (40)	113 (45)	122 (50)
ALT Primer 110	-	6	6	6	4	4	2	2	2	2	1	1	1
ALT Primer 122	-	-	6	6	4	4	2	2	2	2	1	1	1
ALT Primer 222	-	6	6	6	4	4	2	2	2	2	1	1	1
ALT Primer 276	-	-	6	6	4	4	2	2	2	2	1	1	1
ALT Primer 276K	-	-	6	6	4	4	2	2	2	2	1	1	1
ALT Primer 298	-	-	6	6	4	4	2	2	2	2	1	1	1
ALT R290 Paste	-	-	6	6	4	4	2	2	2	2	2	2	2
ALT R295 Matrix	-	6	6	6	4	4	2	2	2	2	2	2	2
ALT R230/R230 Thixo	-	-	4	4	4	2	2	2	2	2	1	1	1
ALT R236	-	-	2x3	2x3	2x3	2x3	2x2	2x2	2x2	2x2	2x1	2x1	2x1
ALT R260/R260 Thixo	-	-	-	4	4	4	2	2	2	2	1	1	1
ALT R354 (red)	-	-	-	4	4	4	2	2	2	2	1	1	1
ALT R359 (green)	-	-	-	4	4	4	2	2	2	2	1	1	1
ALT RS233 Mortar (See Note 1)	-	-	6	6	4	4	2	2	2	2	1	1	1
ALT RS527 Mortar (See Note 2)	-	-	6	6	4	4	2	2	2	2	1	1	1
ALT R268 Textured Coating	-	4	4	4	4	3	3	2	2	1	1	-	-
ALT RS291 Textured Finish	-	4	4	4	4	3	3	2	2	1	1	-	-
ALT Finish 288	-	-	4	4	4	2	2	2	2	2	1	1	1
ALT Finish 220 Clear	-	-	4	4	4	2	2	2	2	2	1	1	1
<b>Winter Grade Resins</b>	14 (-10)	23 (-5)	37.4 (3)	41 (5)	50 (10)	59 (15)	68 (20)	77 (25)	86 (30)	95 (35)	104 (40)	113 (45)	122 (50)
ALT R230/R230 Thixo	6	6	4	4	4	2	2	2	2	1	1	1	1
ALT RS233 Mortar	6	6	6	4	4	2	2	2	2	2	1	1	1

**General Notes:**

Optimal curing requires the catalyst to be completely dissolved. To properly solve ALT Catalyst in ALT PMMA resins, add catalyst to the resin and stir as follows:

- Resin temperature >50°F (10°C): Stir 2-minutes minimum
- Resin temperature <50°F (10°C): Stir 4-minutes minimum

See individual ALT product data sheets, SDS sheets, guide specifications and details for complete information regarding the suitability, application and handling of ALT PMMA resins.

**Specific Notes:**

- 1 ALT RS233 Mortar produced by combining ALT R210 resin and ALT S223 Filler. Catalyst addition is based on ALT R210 resin component weight only.
- 2 ALT RS527 Mortar produced by combining ALT R304 resin and ALT S223 Filler. Catalyst addition is based on ALT R304 resin component weight only.

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