



# Lining Accelerator Instructions for use

**IMPORTANT: PLEASE READ AND FOLLOW THE BELOW INFORMATION FULLY BEFORE USE**

- The below table is to be used as a **guide only** and all governing conditions should be factored prior to mixing.
- Exact calculation and mix of percentages for each component is required based on specific conditions at that time.
- Ensure all possible varying factors that may increase or decrease working and cure times are factored in accordingly prior to mixing, including resin temperature, ambient temperature, pipe temperature, mix volumes etc.
- Failure to do so may result in irreversible errors. It is strongly recommended to test the product first and become familiar with the characteristics before use in live applications. S1E Limited cannot be held responsible for the miscalculation, mixing or application errors of this product.

The below chart shows tested curing times, temperatures and mix percentages of Lining Accelerator used with S1E Polyester Unfilled Resin and Lining Catalyst.

If you are using this accelerator with another brand of resin and or catalyst, you must perform your own tests to ensure the correct percentages are mixed for the working and installation times required based on ambient temperature & all other governing conditions are taken into account as previously stated.

**NB:** The below table is to be used as a guide only.

Test No.	Ambient Temp plus/ minus 0.5 °C	Accelerator %	Catalyst %	Time Mixed	Gel Time	Gel Mins	Cured Time	Cure Mins	
1	13 °C	3%	3%	9.20	10.21	61.00	10.39	79.00	1hr 19
2	13 °C	4%	4%	9.35	10.32	57.00	10.50	75.00	1hr 15
3	14 °C	5%	5%	14.00	14.57	57.00	15.00	63.00	1hr 03
4	14 °C	2%	2%	7.45	10.55	190.00	12.15	270.00	4hr 30
5	14 °C	1%	3%	8.50	12.35	225.00	14.40	350.00	5hr 50
6	16 °C	2%	3%	12.40	14.20	100.00	15.00	140.00	2hr 20
7	18 °C	2%	4%	8.50	9.30	40	9.41	51	
8	18 °C	2%	5%	9.55	10.25	30	10.36	41	
9	20 °C	2%	1%	9.10	12.40	210	15.15	365.00	6hrs 5
10	20 °C	2%	2%	14.00	15.00	60	15.31	91	1hr 31
11	20 °C	2%	3%	12.45	13.40	45.00	14.00	75.00	1hr 15
12	20 °C	2%	4%	14.05	14.35	30.00	14.50	45.00	