

MIXING RATIOS and CURE TIMES

UNIREP 1	Mixing ratio	Base	:	Härter	Cure times *	10 °C	20 °C	30 °C
	By volume	1	:	1	Usable life	5 Min	3 Min	2 Min
					Initial set	15 Min	10 Min	6 Min
	By weight	4	:	3	Max. overcoating	40 Min	30 Min	20 Min
					Machining	45 Min	30 Min	60 Min 1
UNIREP 2	Mixing ratio	Base	:	Härter	Cure times *	10 °C	20 °C	30 °C
	By volume	2	:	1	Usable life	60 Min	40 Min	25 Min
					Initial set.	8 Std.	4 Std.	3 Std. 6
	By weight	5	:	1	Max overcoating	12 Std.	8 Std.	Std. 6
					machining	16 Std.	8 Std.	Std.
UNIREP 3	Mixing ratio	Base	:	Härter	Cure times *	10 °C	20 °C	30 °C
	By volume	3	:	1	Usable life	35 Min	25 Min	15 Min
					Initial set max.	90 Min	60 Min	40 Min 1
	By weight	5	:	1	Max overcoating	2 1/2 Std.	1 3/4 Std.	Std.
					machining	3 Std.	2 Std.	1 1/4 Std.
UNIREP 9	Mixing ratio	Base	:	Härter	Cure times *	10 °C	20 °C	30 °C
	By volume	1	:	1	Usable life	90 Min	60 Min	30 Min
					Initial set	6 Std.	4 Std.	2 Std. 6
	By weight	1,15	:	1	Max overcoating	15 Std.	10 Std.	Std. 8
					machining	18 Std.	12 Std.	Std.
UNIREP 12	Mixing ratio	Base	:	Härter	Cure times *	10 °C	20 °C	30 °C
	By volume	3	:	1	Usable life	35 Min	25 Min	15 Min
					Initial set	5 Std.	3 Std.	2 Std. 3
	By weight	8	:	1	Max overcoating	6 Std.	4 Std.	Std
					machining	8 Std.	12Std.	4 Std.
UNIREP 13	Mixing ratio	Base	:	Härter	Cure times *	10 °C	20 °C	30 °C
	By volume	3	:	1	Usable life	35 Min	25 Min	15 Min
					Initial set	90 Min	60 Min	40 Min
	By weight	5	:	1	Max overcoating	2 Std.	1 Std.	45 Min
					machining	3 Std.	2 Std.	1 1/4 Std
UNIREP 20	Mixing ratio	Base	:	Härter	Cure times *	10 °C	20 °C	30 °C
	By volume	3	:	1	Usable life	120 Min	60 Min	40 Min
					initial set	8 Std.	3 Std.	90 Min
	By weight	4	:	1	Max overcoating machining	2 Std.	1 Std.	45 Min
					full cure**	16 Std.	8 Std.	5 Std.