

# Henry® Pumadeq™ Catalyst Liquid Mixing Ratios

Pumadeq Catalyst is a dibenzoyl peroxide catalyst powder (BPO) used to initiate curing of Pumadeq System polyurethane methyl methacrylate (PUMA) liquid resins. Refer to product specific technical data sheet (TDS) and other published Pumadeq System Tech-Talk Bulletins to verify installation requirements.

## Measuring and mixing Pumadeq Catalyst

Pumadeq Catalyst quantities are based on an average of Pumadeq resin, ambient and substrate temperatures. Temperature conditions may vary throughout the day; adjust catalyst accordingly. Mix resin and catalyst with a clean, electric, slow speed (300-400 rpm), high torque drill and spiral (Jiffy) mixing paddle to achieve uniform distribution.

1. Pre-mix Pumadeq System resin for 1 minute minimum.
2. Add Pumadeq Catalyst to resin and mix to achieve a streak free appearance; 1 minute minimum.
3. Clean mixing paddle and use new pails frequently.

## Pumadeq Catalyst mixing charts

Add Pumadeq Catalyst in accordance with this tech-talk bulletin. Workability of activated Pumadeq System resins are dependent upon catalyst volume, mixing time, substrate/ambient air temperatures and application speed. Do not mix new material with old/uncured resin. Decant newly mixed resin into smaller containers or onto substrate and spread to prolong working time. Pumadeq System products have a low flashpoint. Remove ignition sources; do not smoke in vicinity.

Pumadeq Catalyst volume conversions		
20 oz. = 1 lb.	80 oz. = 5 lbs. / 1 gal. pail (4 lbs. catalyst)	200 oz. = 13 lbs. / 3.5 gal. pail (10 lb. catalyst)
Pumadeq Primer 20, Pumadeq Flex 30SL, Pumadeq 31MV, Pumadeq 32TX and Pumadeq Grip 40		
Substrate temperature**	Pumadeq Catalyst volume per 1-gallon Pumadeq System resin	Pot life in minutes
20 °F (-7 °C)	Contact Henry	Contact Henry
40 °F (4 °C)	10 oz.	15
50 °F (10 °C)	8 oz.	10-15
60 °F (15 °C)	6 oz.	10
70 °F (21 °C)	4 oz.	5-10
80 °F (26 °C)	3 oz.	5
90 °F (32 °C)	2 oz.	Contact Henry
Henry Deqcoat™ 50*		
Substrate temperature**	Pumadeq Catalyst volume per 1-gallon Pumadeq System resin	Pot life in minutes
20 °F (-7 °C)	Contact Henry	Contact Henry
40 °F (4 °C)	7 oz.	15
50 °F (10 °C)	5 oz.	10-15
60 °F (15 °C)	4 oz.	10
70 °F (21 °C)	3 oz.	5-10
80 °F (26 °C)	2.5 oz.	5
90 °F (32 °C)	2 oz.	5

\* Including more catalyst than recommended will cause yellowing.

\*\* Substrate must be a minimum of 5 °F above the dew point temperature and rising.

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