**Intumescent Drying Chart**

**RECOATING TIMES**

(IN HOURS)

This Intumescent Drying Chart is based on the humidity (R/H) and temperature, and indicates the estimated hours required for Contego Intumescent, Original and High Solids, to dry before top coating.

- **Thin coat**
  - (0.3mm / 300µ / 12mils wft)
- **Medium coat**
  - (0.6mm / 600µ / 24mils wft)
- **Thick coat**
  - (0.89mm / 889µ / 35mils wft)

### DRYING TIMES

<table>
<thead>
<tr>
<th>R/H</th>
<th>Spray</th>
<th>Still Air</th>
<th>Air Flow</th>
<th>Still Air</th>
<th>Air Flow</th>
<th>Still Air</th>
<th>Air Flow</th>
</tr>
</thead>
<tbody>
<tr>
<td>30%*</td>
<td>Thin</td>
<td>4.50 hrs</td>
<td>2.25 hrs</td>
<td>3.75 hrs</td>
<td>1.50 hrs</td>
<td>2.25 hrs</td>
<td>1.50 hrs</td>
</tr>
<tr>
<td></td>
<td>Medium</td>
<td>6.25 hrs</td>
<td>3.75 hrs</td>
<td>5.25 hrs</td>
<td>3.00 hrs</td>
<td>4.50 hrs</td>
<td>2.25 hrs</td>
</tr>
<tr>
<td></td>
<td>Thick</td>
<td>9.00 hrs</td>
<td>4.50 hrs</td>
<td>6.00 hrs</td>
<td>3.75 hrs</td>
<td>6.00 hrs</td>
<td>3.00 hrs</td>
</tr>
<tr>
<td>50%</td>
<td>Thin</td>
<td>5.60 hrs</td>
<td>3.00 hrs</td>
<td>4.50 hrs</td>
<td>2.25 hrs</td>
<td>3.00 hrs</td>
<td>1.50 hrs</td>
</tr>
<tr>
<td></td>
<td>Medium</td>
<td>9.00 hrs</td>
<td>4.50 hrs</td>
<td>6.25 hrs</td>
<td>3.75 hrs</td>
<td>6.00 hrs</td>
<td>3.00 hrs</td>
</tr>
<tr>
<td></td>
<td>Thick</td>
<td>12.00 hrs</td>
<td>6.00 hrs</td>
<td>9.00 hrs</td>
<td>4.50 hrs</td>
<td>7.50 hrs</td>
<td>3.75 hrs</td>
</tr>
<tr>
<td>70%</td>
<td>Thin</td>
<td>11.25 hrs</td>
<td>6.00 hrs</td>
<td>9.00 hrs</td>
<td>4.50 hrs</td>
<td>6.00 hrs</td>
<td>3.00 hrs</td>
</tr>
<tr>
<td></td>
<td>Medium</td>
<td>15.00 hrs</td>
<td>9.00 hrs</td>
<td>15.00 hrs</td>
<td>6.25 hrs</td>
<td>12.00 hrs</td>
<td>5.25 hrs</td>
</tr>
<tr>
<td></td>
<td>Thick</td>
<td>18.00 hrs</td>
<td>12.00 hrs</td>
<td>18.00 hrs</td>
<td>9.00 hrs</td>
<td>15.00 hrs</td>
<td>6.00 hrs</td>
</tr>
</tbody>
</table>

* RH 30% or less can cause a surface film to build, trapping moisture inside. In these cases, thinner coats are recommended.

- Brushing or rolling adds about 20% to drying time (compared to spraying).
- Drying times are doubled at 5°C (41°F) or at over 75% relative humidity.
- Final drying time before topsealing is a minimum of 16 hours.
- These figures are based on constant conditions, fluctuations will change the required drying time. If overnight condensation causes wetting, a further full drying period should be allowed.

**FINAL THICKNESS CHECK**

- Take dry film thickness (DFT) readings as soon as the coating is sufficiently hard to allow a reading to be made without indenting the surface.
- DFT’s may be taken using equipment such as an electronic electromagnetic type Positector 6000 or an Elcometer 345 or manual gauge. (See Thickness Measurement Videos at http://ContegoInternational.com/resources/videos)
- Ensure that the DFT of the primer is deducted from the reading of the base coat.
- Do NOT apply a top coat until the readings are in accordance with the specified thicknesses.

**WARNING!** High humidity and low air movement or low steel temperatures can result in condensation on the steelwork causing prolonged drying times and possibly poor base coat adhesion.

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