



DRYING TIMES



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 CON-RFB 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)

R/H	Spray	10°C / 50°F		20°C / 68°F		30°C / 86°F	
		Still Air	Air Flow	Still Air	Air Flow	Still Air	Air Flow
30%*	Thin	4.50 hrs	2.25 hrs	3.75 hrs	1.50 hrs	2.25 hrs	1.50 hrs
	Medium	6.25 hrs	3.75 hrs	5.25 hrs	3.00 hrs	4.50 hrs	2.25 hrs
	Thick	9.00 hrs	4.50 hrs	6.00 hrs	3.75 hrs	6.00 hrs	3.00 hrs
50%	Thin	5.60 hrs	3.00 hrs	4.50 hrs	2.25 hrs	3.00 hrs	1.50 hrs
	Medium	9.00 hrs	4.50 hrs	6.25 hrs	3.75 hrs	6.00 hrs	3.00 hrs
	Thick	12.0 hrs	6.00 hrs	9.00 hrs	4.50 hrs	7.50 hrs	3.75 hrs
70%	Thin	11.25 hrs	6.00 hrs	9.00 hrs	4.50 hrs	6.00 hrs	3.00 hrs
	Medium	15.0 hrs	9.00 hrs	15.0 hrs	6.25 hrs	12.0 hrs	5.25 hrs
	Thick	18.0 hrs	12.0 hrs	18.0 hrs	9.00 hrs	15.0 hrs	6.00 hrs

* 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.

These guidelines are based on our extensive experience worldwide. However, final responsibility rests with the applicator to be SURE each coat is THOROUGHLY dry before applying additional coats.

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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CON-RFB (HS) is Truly Non-Toxic!

