






**Polishers & Jewelers
Supply Corp.**
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DECORATIVE HARDENER CHART

INSTRUCTIONS: Select the surface to be filled and read what letter corresponds with that selection. Follow the chart below to choose the product that meets your working conditions.

SURFACES TO BE COATED:

- A. Flat Surface With Walls  D. Severe Curve and High Domes 
 B. Flat To Slight Curve Without Walls  E. Full Round Hoop, Bracelet 
 C. Slight to Moderate Curve  F. Open Mold Casting

RECOMMENDED SURFACES TO BE COATED	HARDENER	DESCRIPTION	WORKING TIME 100 grams MIX RATIO RESIN TO HARDENER	BAKE CURE 130°F (2-3 hrs.) 85°F - 95°F OVERNIGHT-12HRS
A, F	B-25	Low viscosity hardener ideally suited for castings and filling cavities.	4 Hours 2:1 By Weight	Bake Cure
A	B-31	A low viscosity hardener offering a long working time and excellent air release which can be used for filling cavities and coloring emblematic jewelry.	2-3 Hours 2:1 By Weight	Bake Cure
C, D, E,	B-31/C 7.5	Medium viscosity, most widely used hardener which can be used to coat a wide range of pieces. Best results achieved when heat cured immediately after application-up to 130°F. Made thicker with drops.	2-3 Hours 2:1 By Weight	Bake Cure
D, E	B-31C	High viscosity hardener designed for irregular and extremely curved surfaces. Made thicker with drops.	2-3 Hours 2:1 By Weight	Bake Cure
A	B-32	Similar to B-31 with a slightly higher viscosity.. Available in different thicknesses.	2-3 Hours 2:1 By Weight	Bake Cure
A, B, C	B-34	Medium viscosity, slightly thixotropic hardener specifically designed to hold particles and swirls in suspension when filling flat cavities. Made thicker with drops.	2-3 Hours 2:1 By Weight	Bake Cure
A, B, C	B-35	Medium viscosity, slightly thixotropic hardener used to suspend particles and swirls in cavities and slightly curved surfaces.	2-3 Hours 2:1 By Weight	Bake Cure
A	B-125	Medium viscosity hardener with excellent color stability. Ideally suited for high dome or clear castings. Used with white or Clear #1003 resin for improved UV resistance.	90 Minutes 2:1 By Weight	Bake Cure
A	B-126	Medium viscosity hardener with excellent color stability. Used with Clear #1011 resin in coating applications requiring the best UV resistance available.	1-2 Hours 2:1 By Weight	Bake Cure