

Curing times

FIS SB Temperature in anchoring base [°C]	Maximum processing time FIS SB t_{work} [min.]	Maximum processing time FIS SB High Speed t_{work} [min.]	Minimum curing time FIS SB		Minimum curing time FIS SB High Speed	
			t_{cure} [hrs.]	[min.]	t_{cure} [hrs.]	[min.]
> -20 – -15	-	60	-	-	24	-
> -15 – -10	60	30	36	-	8	-
> -10 – -5	30	15	24	-	-	180
> -5 – 0	20	10	8	-	-	120
> +0 – +5	13	5	4	-	-	60
> +5 – +10	9	3	-	120	-	45
> +10 – +20	5	2	-	60	-	30
> +20 – +30	4	1	-	45	-	15
> +30 – +40	2	-	-	30	-	-

1) Minimum cartridge temperature +5°C