

Powercrete® R-95

Gel, re-coat and curing time chart

This chart provides approximate gel, re-coat and curing time based on conditions and procedures outlined below:

1. Keep Part A at 77 °F (25 °C) for hand application and 140 °F (60 °C) for spray application, keep Part B at 77 °F (25 °C) and warm/cool the high density polyethylene sheet to be used as substrate to the designated temperature
2. Mix Part A and Part B thoroughly and pour the mixture on the substrate;
3. Set the mixtures in oven/refrigerator to maintain the temperature of testing;
4. Touch with finger to check gel time and dry time;
5. Cool down/warm up the coating mixture to room temperature 77 °F (25 °C) and measure the hardness with a Durometer type "D" that has stabilized after 3 seconds and remains a constant reading of Shore 65 or Shore 75.

Testing temperature		Application procedure	Gel Time	Re-coat time	Dry Time Unit	65 Shore "D"	75 Shore "D"
<60 °F	<16 °C	Hand	-	-	-	-	-
		Spray	-	-	-	-	-
60 °F	16 °C	Hand	80 minutes	75 - 120 minutes	3 hours	-	5 - 6 days
		Spray	75 minutes	70 - 100 minutes	2 hours and 25 minutes	20 hours	24 hours
65 °F	18 °C	Hand	60 minutes	55 - 90 minutes	2 hours and 50 minutes	6 hours	10 hours
		Spray	44 minutes	40 - 80 minutes	2 hours and 17 minutes	5 hours and 7 minutes	9 hours and 17 minutes
70 °F	21 °C	Hand	57 minutes	52 - 75 minutes	4 hours	6 hours	9 hours
		Spray	39 minutes	34 - 60 minutes	1 hour and 40 minutes	4 hours and 5 minutes	8 hours
80 °F	27 °C	Hand	37 minutes	32 - 50 minutes	1 hour and 35 minutes	4 hours	5 hours and 30 minutes
		Spray	31 minutes	29 - 45 minutes	1 hour and 17 minutes	2 hours and 17 minutes	5 hours
90 °F	32 °C	Hand	26 minutes	22 - 40 minutes	1 hour	2 hours and 17 minutes	2 hours and 25 minutes
		Spray	21 minutes	17 - 35 minutes	56 minutes	2 hours and 17 minutes	2 hours
100 °F	38 °C	Hand	23 minutes	20 - 32 minutes	40 minutes	1 hour and 35 minutes	1 hour and 30 minutes
		Spray	19 minutes	16 - 28 minutes	40 minutes	1 hour and 10 minutes	1 hour and 10 minutes
110 °F	43 °C	Hand	19 minutes	16 - 22 minutes	31 minutes	1 hour	1 hour and 15 minutes
		Spray	14 minutes	12 - 21 minutes	30 minutes	53 minutes	1 hour
120 °F	49 °C	Hand	14 minutes	12 - 20 minutes	29 minutes	50 minutes	37 minutes
		Spray	10 minutes	9 - 15 minutes	20 minutes	34 minutes	35 minutes
130 °F	54 °C	Hand	11 minutes	9 - 14 minutes	18 minutes	32 minutes	32 minutes
		Spray	9 minutes	7 - 10 minutes	15 minutes	22 minutes	30 minutes
140 °F	60 °C	Hand	10 minutes	8 - 10 minutes	13 minutes	18 minutes	21 minutes
		Spray	8 minutes	6 - 8 minutes	10 minutes	11 minutes	11 minutes
150 °F	66 °C	Hand	7 minutes	5 - 10 minutes	12 minutes	14 minutes	16 minutes
		Spray	6 minutes	4 - 7 minutes	9 minutes	10 minutes	11 minutes