



POWERCRETE DD 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 Unit in min. except indicated	Re-coat Time Window (In minutes from application time of previous coating pass)	Dry Time	65 Shore "D" Reading	75 Shore "D" Reading
WARNING: UNDER 40° F (4° C) COATING MIXTURE IS FROZEN AND NO CHEMICAL REACTION WILL OCCUR						
40 °F (4 °C)	Hand	210	200 th -----465 th	12 hr.	160 hr.	180 hr.
	Spray	170	160 th -----385 th	10 hr.	130 hr.	165 hr.
50 °F (10 °C)	Hand	135	125 th -----308 th	8 hr.	144 hr.	168 hr.
	Spray	100	90 th -----260 th	7 hr.	120 hr.	144 hr.
60 °F (16 °C)	Hand	90	90 th -----225 th	6 hr.	38 hr.	48 hr.
	Spray	50	45 th -----175 th	5 hr.	31 hr.	42 hr.
70 °F (21 °C)	Hand	80	70 th -----145 th	3hr. 30 min	17 hr.	22 hr.
	Spray	42	37 th -----111 th	3 hr.	13 hr.	16 hr.
80 °F (27 °C)	Hand	61	56 th -----121 st	3 hr.	9 hr.	12 hr.
	Spray	39	36 th -----95 th	2hr.30 min	7 hr.45 min.	10 hr.
90 °F (32 °C)	Hand	35	32 nd -----93 rd	2hr. 30 min	8 hr.	10 hr.
	Spray	32	29 th -----76 th	2 hr.	7 hr.	8 hr.40 min.
100 °F (38 °C)	Hand	32	29 th -----61 st	1hr. 50 min	6 hr.	7 hr.30 min.
	Spray	28	25 th -----62 nd	1hr. 35 min	5 hr.40 min.	7 hr.30 min.
110 °F (43 °C)	Hand	23	20 th -----42 nd	1 hr.	3 hr.15 min.	4 hr.30 min.
	Spray	26	23 rd -----36 th	45 min	2 hr.45 min.	3 hr.30 min.
120 °F (49 °C)	Hand	22	19 th -----34 th	45 min	2 hr.15 min.	3 hr.15 min.
	Spray	20	17 th -----30 th	40 min	1 hr.35 min.	2 hr.
130 °F (54 °C)	Hand	18	16 th -----25 th	35 min	1 hr.20 min.	2 hr.
	Spray	17	15 th -----20 th	30 min	46 min.	1 hr.
140 °F (60 °C)	Hand	16	14 th -----25 th	35 min	1 hr.	1 hr.30 min.
	Spray	16	14 th -----15 th	25 min	42 min.	48 min.
150 °F (66 °C)	Hand	13	11 th -----15 th	23 min	45 min.	1 hr.
	Spray	13	11 th -----14 th	18 min	32 min.	40 min.

* Coating hardness to be at 75 Shore D reading prior to handling. Coating temperatures lower than 77° F (25° C) will give a false hardness reading. Using a grinder with grinding disk, a cured coating will give out dust particles, while an uncured coating will melt like gum.