

Gel, Re-Coat and Curing Time Chart

Testing Temperature	Application Procedure	Gel Time	Re-coat Time Window (In minutes from application time of previous coating pass)	Dry Time	65 Shore "D" Reading	75 Shore "D" Reading
40 °F (4 °C)	Hand	210 min	200 th -----465 th	12 hr	160 hr	180 hr
	Spray	170 min	160 th -----385 th	10 hr	130 hr	165 hr
50 °F (10 °C)	Hand	135 min	125 th -----308 th	8 hr	144 hr	168 hr
	Spray	100 min	90 th -----260 th	7 hr	120 hr	144 hr
60 °F (16 °C)	Hand	90 min	90 th -----225 th	6 hr	38 hr	48 hr
	Spray	50 min	45 th -----175 th	5 hr	31 hr	42 hr
70 °F (21 °C)	Hand	80 min	70 th -----145 th	3hr 30 min	17 hr	22 hr
	Spray	42 min	37 th -----111 th	3 hr	13 hr	16 hr
80 °F (27 °C)	Hand	61 min	56 th -----121 st	3 hr	9 hr	12 hr
	Spray	39 min	36 th -----95 th	2hr 30 min	7 hr 45 min	10 hr
90 °F (32 °C)	Hand	35 min	32 nd -----93 rd	2hr 30 min	8 hr	10 hr
	Spray	32 min	29 th -----76 th	2 hr	7 hr	8 hr 40 min
100 °F (38 °C)	Hand	32 min	29 th -----61 st	1hr 50 min	6 hr	7 hr 30 min
	Spray	28 min	25 th -----62 nd	1hr 35 min	5 hr 40 min	7 hr 30 min
110 °F (43 °C)	Hand	23 min	20 th -----42 nd	1 hr	3 hr 15 min	4 hr 30 min
	Spray	26 min	23 rd -----36 th	45 min	2 hr 45 min	3 hr 30 min
120 °F (49 °C)	Hand	22 min	19 th -----34 th	45 min	2 hr 15 min	3 hr 15 min
	Spray	20 min	17 th ---- 30 th	40 min	1 hr 35 min	2 hr
130 °F (54 °C)	Hand	18 min	16 th ----25 th	35 min	1 hr 20 min	2 hr
	Spray	17 min	15 th ---- 20 th	30 min	46 min	1 hr
140 °F (60 °C)	Hand	16 min	14 th ---- 25 th	35 min	1 hr	1 hr 30 min
	Spray	16 min	14 th ----15 th	25 min	42 min	48 min
150 °F (66 °C)	Hand	13 min	11 th ---- 15 th	23 min	45 min	1 hr
	Spray	13 min	11 th ----14 th	18 min	32 min	40 min

WARNING: UNDER 40° F (4° C) COATING MIXTURE IS FROZEN AND NO CHEMICAL REACTION WILL OCCUR

This chart provides an approximate gel and curing times based on conditions outlined above



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