

**Powercrete J**  
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 mixture onto the substrate.
3. Set the mixtures in oven/refrigerator to maintain the temperature of testing.
4. Touch with finger to check gel and dry time every two minutes.
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.

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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
<b>Warning: Under 40°F (4°C) coating mixture is frozen and NO chemical reaction will occur</b>						
40°F (4°C)	Hand	180 min	170 <sup>th</sup> - 360 <sup>th</sup>	9 hr	96 hr	120 hr
	Spray	130 min	120 <sup>th</sup> - 305 <sup>th</sup>	8 hr	80 hr	97 hr
50°F (10°C)	Hand	110 min	100 <sup>th</sup> - 235 <sup>th</sup>	6 hr	75 hr	95 hr
	Spray	50 min	40 <sup>th</sup> - 175 <sup>th</sup>	5 hr	60 hr	72 hr
60°F (16°C)	Hand	62 min	57 <sup>th</sup> - 150 <sup>th</sup>	4 hr	20 hr	28 hr
	Spray	39 min	34 <sup>th</sup> - 125 <sup>th</sup>	3 hr 30 min	16 hr	19 hr
70°F (21°C)	Hand	52 min	47 <sup>th</sup> - 116 <sup>th</sup>	3 hr	8 hr	10 hr
	Spray	31 min	16 <sup>th</sup> - 83 <sup>rd</sup>	2 hr 15 min	6 hr 15 min	7 hr 20 min
80°F (27°C)	Hand	30 min	25 <sup>th</sup> - 75 <sup>th</sup>	2 hr	4 hr 45 min	5 hr 30 min
	Spray	29 min	24 <sup>th</sup> - 67 <sup>th</sup>	1 hr 45 min	4 hr 10 min	5 hr 10 min
90°F (32°C)	Hand	25 min	20 <sup>th</sup> - 58 <sup>th</sup>	1 hr 30 min	2 hr 50 min	4 hr 20 min
	Spray	21 min	16 <sup>th</sup> - 41 <sup>st</sup>	1 hr	2 hr	3 hr 15 min
100°F (38°C)	Hand	18 min	15 <sup>th</sup> - 37 <sup>th</sup>	55 min	2 hr	2 hr 50 min
	Spray	17 min	14 <sup>th</sup> - 31 <sup>st</sup>	45 min	1 hr 31 min	2 hr
110°F (43°C)	Hand	16 min	13 <sup>th</sup> - 31 <sup>st</sup>	45 min	1 hr 40 min	2 hr 15 min
	Spray	16 min	13 <sup>th</sup> - 28 <sup>th</sup>	40 min	1 hr 15 min	1 hr 30 min
120°F (49°C)	Hand	15 min	12 <sup>th</sup> - 28 <sup>th</sup>	40 min	1 hr 20 min	1 hr 45 min
	Spray	13 min	10 <sup>th</sup> - 24 <sup>th</sup>	35 min	58 min	1 hr 15 min
130°F (54°C)	Hand	14 min	11 <sup>th</sup> - 25 <sup>th</sup>	35 min	56 min	1 hr 20 min
	Spray	12 min	9 <sup>th</sup> - 18 <sup>th</sup>	25 min	36 min	49 min
140°F (60°C)	Hand	13 min	10 <sup>th</sup> - 18 <sup>th</sup>	25 min	40 min	1 hr
	Spray	10 min	8 <sup>th</sup> - 15 <sup>th</sup>	20 min	32 min	40 min
150°F (66°C)	Hand	10 min	8 <sup>th</sup> - 15 <sup>th</sup>	20 min	38 min	55 min
	Spray	9 min	7 <sup>th</sup> - 10 <sup>th</sup>	13 min	19 min	24 min

\*\* Coating temperatures lower than 77°F (25°C) will give a false hardness reading. When a grinder is being used, a cured coating will give out dust particles, while an uncured coating will melt like gum. Shore D Hardness of 65 = able for transportation. Shore D Hardness of 75 = able for back fill