

**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 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	MATERIAL IS TOO VISCOUS, FROZEN LIKE, HARD TO DIFFERENTIATE GELING AND DRYING.				48 hrs	
	Spray					35 hrs	
50 °F (10 °C)	Hand	120	115th-----180th	360	26 hrs	35 hrs	
	Spray	100	95th-----160th	320	24 hrs	30 hrs	
60 °F (18 °C)	Hand	60	57th-----120th	240	21 hrs	25 hrs	
	Spray	60	55th-----110th	220	19 hrs	23 hrs	
70 °F (21 °C)	Hand	49	45th-----60th	120	290	341 min	
	Spray	40	36th-----45th	90	260	311	
80 °F (27 °C)	Hand	42	38th-----50th	70	240	280	
	Spray	35	31st-----55th	65	195	220	
90 °F (32 °C)	Hand	30	26th-----44th	54	110	150	
	Spray	25	21st-----33rd	43	90	105	
100 °F (38 °C)	Hand	27	24th-----41 <sup>st</sup>	51	70	86	
	Spray	20	17th-----25th	35	54	59	
110 °F (43 °C)	Hand	20	17th-----23 <sup>rd</sup>	33	40	42	
	Spray	19	16th-----20 <sup>th</sup>	30	38	40	
120 °F (49 °C)	Hand	17	15th-----17th	22	29	32	
	Spray	16	14th-----16th	20	25	30	
130 °F (54 °C)	Hand	12	10th-----12th	14	15	20	
	Spray	9	7th-----9th	11	12	14	
140 °F (60 °C)	Hand	9	8th-----10th	12	14	18	
	Spray	7	6th-----8th	10	11	13	
150 °F (66 °C)	Hand	7	6th-----7th	8	9	11	
	Spray	<6	4th-----5th	6	6+	7	

\* At 77° F (25° C) coating requires 7 days to reach fully cured. Coating temperatures lower than 77° F (25° C) will give a false hardness reading. Use a grinder with grinding disk, a cured coating will give out dust particles, while an uncured coating will melt like gum.