

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 Window (In minutes from application time of previous coating pass)	Dry Time	65 Shore “D” Reading	75 Shore “D” Reading
<60 °F (16 °C)	Hand Spray	MATERIAL IS TOO VISCOUS, FROZEN LIKE, HARD TO DIFFERTIATE GELING AND DRYING.				
60 °F (16 °C)	Hand Spray	80 75	75 th -----120 th 70-----100 th	180 135		5 – 6 days Next day
65 °F (18 °C)	Hand Spray	60 44	55-----90 th 40-----80 th	150 130		600 min 300
70 °F (21 °C)	Hand Spray	57 39	52-----75 th 34-----60 th	140 100		540 min 480
80 °F (27 °C)	Hand Spray	37 31	32-----50 th 29-----45 th	95 77		330 min 300
90 °F (32 °C)	Hand Spray	26 21	22 -----40 th 17-----35 th	60 56		135 120
100 °F (38 °C)	Hand Spray	23 19	20-----32 nd 16-----28 th	40 40		90 70
110 °F (43 °C)	Hand Spray	19 14	16---22 nd 12---21 st	31 30		75 60
120 °F (49 °C)	Hand Spray	14 10	12---20 th 9---15 th	29 20		37 35
130 °F (54 °C)	Hand Spray	11 9	9---14 th 7---10 th	18 15		32 30
140 °F (60 °C)	Hand Spray	10 8	8--10 th 6---8 th	13 10		21 11
150 °F (66 °C)	Hand Spray	7	5--10 th	12		16

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

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