

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

\*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.

R-95 Hand Applied

