

POWERCRETE J-FAST CURE 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.

TIME REPORTED IN MINUTES UNLESS SPECIFIED.

Testing TEMPERATURE	Application Procedure	GEL Time	Re-coat Time Window (In minutes from application time of previous coating pass)	DRY Time	65 SHORE "D" Time	75 SHORE "D" Time
40 °F (4 °C)	Hand	200	180th - - - - - 300th	400	3 Days	6 Days
	Spray	180	170th - - - - - 270th	370	6 hrs D55	48 hrs D75
50 °F (10 °C)	Hand	150	140th - - - - - 250th	350	15 hrs D 55	25 hrs/ D 80
	Spray	120	110th - - - - - 200th	300	15 hrs D 65	20 hrs / D 75
60 °F (16 °C)	Hand	85	77th - - - - - 100th	180	240 D 55	>16 hrs
	Spray	75	68th - - - - - 95th	130	320	>15 hrs
70 °F (21 °C)	Hand	60	55th - - - - - 95th	130	300	360
	Spray	50	45th - - - - - 90th	120	182	300
80 °F (27 °C)	Hand	31	26th - - - - - 80th	110	165	261
	Spray	26	22nd - - - - - 76th	106	148	250
90 °F (32 °C)	Hand	27	23rd - - - - - 40th	70	150	180
	Spray	20	16th - - - - - 35th	50	90	103
100 °F (38 °C)	Hand	22	19th - - - - - 36th	56	85	140
	Spray	15	12th - - - - - 30th	45	65	85
110 °F (43 °C)	Hand	18	15th - - - 24th	34	65	110
	Spray	13	10th - - - - 17th	27	37	45
120 °F (49 °C)	Hand	14	12th - - - 15th	23	33	56
	Spray	12	10th - - 15th	20	23	30
130 °F (54 °C)	Hand	12	10th - - 14th	21	30	40
	Spray	10	8th - - 12th	15	20	28
140 °F (60 °C)	Hand	11	9th - - 11th	15	27	35
	Spray	8	6th - 10th	13	16	26
150 °F (66 °C)	Hand	7	5th-10th	13	14	18
	Spray	6	5th-6th	7	8	10

NOTE: 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.