

Theoretical Gel Time Matrix for Polyurethane Elastomers				
<b>Theory: Based on a set point at a set temperature, the gel time decreases by half for each 10°C increase in temperature. Conversely, the gel time doubles for each 10°C decrease in temperature.</b>				
<b>Materials are considered "gelled" when a wooden probe is touched to the surface of the mixed material then pulled away and no material adheres to the end of the probe. Typically the material can be moved or buried five minutes after gel time (sometimes before). Final cure hardness is reached after twenty fours.</b>				
Please review the below and make accommodations for your particular application. If you would like assistance please contact Uraseal, Inc.				
The below is for reference only - Times will vary based on length and intensity of mix, container temperature, and air temperature.				
Examples:				
	Material Temperature			
Material	Temp. °C	Temp. °F	Gel Time	
	55	131	0 min. 18 sec.	Not recommended
	45	113	0 min. 37 sec.	Not recommended
	35	95	1 min. 15 sec.	
CK, CT, EP, ES Kits 132 gram mass	25	77	2 min. 30 sec.	QC Standard [includes 1 minute mix time]
	15	59	5 min. 00 sec.	
	5	41	10 min. 00 sec.	
	-5	23	20 min. 00 sec.	Not recommended
	-15	5	30 min. 00 sec.	Not recommended
	Material Temperature			
Material	Temp. °C	Temp. °F	Gel Time	
	55	131	1 min. 15 sec.	Not recommended
	45	113	2 min. 30 sec.	
	35	95	5 min. 00 sec.	
Pedestal Foam 220 gram mass	25	77	10 min. 00 sec.	QC Standard [includes 1 minute mix time]
	15	59	20 min. 00 sec.	
	5	41	40 min. 00 sec.	
	-5	23	80 min. 00 sec.	Not recommended
	-15	5	30 min. 00 sec.	Not recommended
	Material Temperature			
Material	Temp. °C	Temp. °F	Gel Time	
	55	131	7 min. 30 sec.	Not recommended
	45	113	15 min. 00 sec.	Not recommended
	35	95	30 min. 00 sec.	
Load Coil	25	77	60 min. 00 sec.	QC Standard [includes 1 minute mix time]
	15	59	120 min. 00 sec.	
	5	41	240 min. 00 sec.	
	-5	23	480 min. 00 sec.	Not recommended

