

### CORCHEM® 247 CHEMICAL RESISTANT COAL TAR EPOXY FORCED CURE PROCEDURE

**AMBIENT CURING TIME** This curing schedule is predicated upon application conditions where the mixed product, substrate, and ambient air temperatures are the same:

Temperature	50°F	70°F	90°F
Minimum Recoat Time	8 Hours	6 Hours	4 Hours
Maximum Recoat Time	48 Hours	24 Hours	12 Hours
Immersion – Final Cure	10 Days	7 Days	5 Days

Curing times are significantly shorter for higher temperatures or lower thickness and are longer for lower temperatures or higher thickness. Curing times are affected by the method of application; thickness of applied film; the quantity of thinner (if used); the amount of ventilation and air circulation; relative humidity; etc. *Refer to RECOAT AND REPAIR Section for extended recoat instructions, if subjected to extended exposure to sunlight, or if coating reaches complete cure and hardness.*

**NOTICE!** Heat curing will increase drying speed and improve resistance properties. See instructions and heat cure times below.

#### FORCED CURING TIMES

Air dry with continuous ventilation for 1 hour minimum and until flash off/curing time necessary to prevent blistering and defects is achieved, then gradually raise the temperature until the coated surfaces reach 125°F to 150°F for a period of 15 minutes. **CAUTION!** Over-baking between coats will result in loss of adhesion. Allow the coated surfaces to cool and then repeat each of the above application procedures until the desired total dry film thickness is obtained.

After the final coat has been applied, allow the minimum flash off/curing time necessary to prevent blistering and defects, then:

1. Gradually raise the temperature not more than 50°F every 30 minutes until the substrate reaches 150°F to 175°F and bake for 1-hour, then;
2. Gradually increase the temperature not more than 50°F every 30 minutes until the substrate reaches 200°F to 225°F and bake for 2-hours.

**CAUTION!** Do not exceed maximum temperature to avoid damage to coating.

PUBLISHED TECHNICAL DATA AND INSTRUCTIONS ARE SUBJECT TO CHANGE WITHOUT NOTICE.  
CONTACT YOUR CORCHEM® REPRESENTATIVE FOR CURRENT TECHNICAL DATA AND INSTRUCTIONS.

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Document ID: C247-2-IB-(Forced-Cure)-11072018-08017  
Revision: 1

