



Premium quality pipe relining  
materials and equipment

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## CURING TABLE FOR PIPE CORE EPOXY RESINS

These charts are estimates only and must be checked on site, ground temperature and other factors may change these.

RESIN TYPE	MIXING RATIO	TEMPERATURE	TIME
1504	4:1 Weight	75 Degrees 65 Degrees	Not recommended 40mins
3008	4:1 Weight	75 Degrees 65 Degrees	30 Mins 60 Mins
4514	4:1 Weight	75 Degrees 65 Degrees	45 Mins 90 Mins
6024	4:1 Weight	75 Degrees 65 Degrees	60 Mins 120 Mins
T0530	100:30 Weight	75 Degrees 65 Degrees	4 Hours 8 Hours

The values mentioned are for curing time. The time for temperature rise, as well as cooling period are not taken into account. Other conditions must be taken into account including ground water, pipe material, ground or external temperatures.