

Table B5: Working and curing time				
Temperature in base material			Maximum working time	Minimum curing time ¹⁾
T			t _{work}	t _{cure}
+ 0 °C	to	+ 4 °C	90 min	144 h
+ 5 °C	to	+ 9 °C	80 min	48 h
+ 10 °C	to	+ 14 °C	60 min	28 h
+ 15 °C	to	+ 19 °C	40 min	18 h
+ 20 °C	to	+ 24 °C	30 min	12 h
+ 25 °C	to	+ 34 °C	12 min	9 h
+ 35 °C	to	+ 39 °C	8 min	6 h
+ 40 °C			8 min	4 h
Cartridge temperature			+5°C to +40°C	
1) The minimum curing time is only valid for dry base material. In wet base material the curing time must be doubled.				
Injection system XWE for concrete				Annex B 5
Intended Use Working time and curing time				