

# Infra Red Drying CR Products

**FOR PROFESSIONAL USE ONLY**

## Discription

Akzo Nobel Car Refinishes guarantees optimal drying performance with the use of infra red equipment only when products are applied according to TDS recommendations and when the infra red equipment is used according to the manufacturers recommendations.

There is a variety of IR equipment available in the market with several wave lengths (short and medium wave). Therefore, this document is only valid as a general indication of what might be expected. Equipment with varying wave lengths will give varying drying performance. Follow the IR manufacturer recommendations at all times.

- *The size of the IR curing panel generally indicates the size of the heated area*
- *Long wave infra red equipment is not included in this document because of its limited effect on product drying speed and increased profitability for the bodyshop.*
- *When using IR units with pre-programmed settings, verify the manufacturers recommended settings for time and distance with those outlined in this document.*

The following recommendations must be respected for optimal drying performance:

- Always allow a 5 minute flash off time with all products before drying with IR equipment.
- Primers and polyester bodyfillers may only be cured at low power when using short wave IR units.
- There is an approximately 36°F (20°C) temperature difference between lighter and darker colors due to heat reflection (light colors) or heat absorption (dark colors). To compensate for this difference, we recommended using the shorter distance with lighter colors and longer distance with darker colors as indicated in the table.
- The panel surface should never exceed temperatures higher than 212°F (100°C).
- Cool the surface to ambient temperature after curing before handling or polishing.

### IR curing of plastic parts:

To reduce the risk of overheating plastic parts and to determine the correct (safe) distance between the IR unit and the part, we recommend mounting a tape measure to the IR unit. Place the IR unit at the largest indicated distance.

- Do not compensate for color.

### IR curing of waterborne products:

It is not recommended to cure waterborne products with IR equipment.

Polyester bodyfillers / putties	Short wave		Medium wave	
	Distance	Drying time (Low)	Distance	Drying time (Low)
	50-70 cm	4-5 minutes	40-60 cm	6-8 minutes

Primers	Short wave		Medium wave	
	Distance	Drying time (Low)	Distance	Drying time (Low)
	50-70 cm	7-9 minutes	40-60 cm	10-12 minutes

Primer / Surfacer	Short wave		Medium wave	
	Distance	Drying time (L+H)	Distance	Drying time (L+H)
	50-70 cm	4+8 minutes	40-60 cm	6+10 minutes
With the exception of:				
Priming Filler 680	50-70 cm	3+5 minutes	40-60 cm	3+8 minutes
Primer Surfacer EP II	50-70 cm	5+10 minutes	40-60 cm	5+12 minutes

# Infra Red Drying CR Products

FOR PROFESSIONAL USE ONLY

Single Stage Topcoats	Short wave		Medium wave	
	Distance	Drying time (L+H)	Distance	Drying time (L+H)
	50-70 cm	4+6 minutes	40-60 cm	4+8 minutes
With the exception of:				
Autocryl	50-70 cm	6+6 minutes	40-60 cm	4+8 minutes

Clearcoats	Short wave		Medium wave	
	Distance	Drying time (L+H)	Distance	Drying time (L+H)
	50-70 cm	4+8 minutes	40-60 cm	4+10 minutes
With the exception of:				
Autoclear	50-70 cm	4+6 minutes	40-60 cm	4+6 minutes
Autoclear Mix & Matt *	50-70 cm	2+6 minutes	40-60 cm	2+6 minutes
Autoclear Superior 250	50-70 cm	3+8 minutes	40-60 cm	3+8 minutes
Autoclear PC	50-70 cm	6+6 minutes	40-60 cm	6+6 minutes
Autoclear III	50-70 cm	4+6 minutes	40-60 cm	4+6 minutes

\* Allow for **15** minutes flash off before drying with IR equipment

**Akzo Nobel Car Refinish bv.**  
**Address: Rijksweg 31, PO Box 3, 2170 BA Sassenheim**  
**Tel: +31(0)71308-6944**

**FOR PROFESSIONAL USE ONLY**

**IMPORTANT NOTE** The information in this data sheet is not intended to be exhaustive and is based on the present state of our knowledge and on current laws: any person using the product for any purpose other than that specifically recommended in the technical data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at his own risk. It is always the responsibility of the user to take all necessary steps to fulfill the demands set out in the local rules and legislation. Always read the Material Data Sheet and the Technical Data Sheet for this product if available. All advice we give or any statement made about the product by us (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing otherwise, we do not accept any liability whatsoever for the performance of the product or for any loss or damage arising out of the use of the product. All products supplied and technical advices given are subject to our standard terms and conditions of sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is subject to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to verify that this data sheet is current prior to using the product.

Coatings brand names mentioned in this data sheet are trademarks of or are licensed to Akzo Nobel.

**Head Office**

Akzo Nobel Car Refinishes B.V., PO Box 3 2170 BA Sassenheim, The Netherlands. [www.sikkenscr.com](http://www.sikkenscr.com)

**Disclaimer (Equipment)**

Although we have made reasonable efforts to include accurate and up to date information in this document, we make no warranties or representations to the accuracy or completeness of (the content of) this document. Furthermore Akzo Nobel Car Refinishes BV, its subsidiaries, affiliates or employees shall in no event be liable for any damages of any kind or nature whatsoever, including, without limitation, direct, indirect, special, consequential or incidental damages resulting from or in connection with the use of (the content of) this document or resulting from or in connection with the use of any materials, information, qualifications or recommendations in this document