

# Infra Red Drying CR Products

**FOR PROFESSIONAL USE ONLY**

## Discription

To achieve optimal IR drying performance it is advised to apply the Sikkens products according to the relevant TDS and use of infra red equipment as recommended by manufacturers.

There is a variety of IR equipment available in the market with several wave lengths (short and medium wave). Equipment with varying wave lengths will give varying drying performance.

- *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.*

Therefore, the information in this document is a general indication of the curing times expected.

## Please respect the following:

- Always allow a 5 minute flash off time before drying with IR equipment.
- Cure primers & polyester bodyfillers at low power when using short wave IR units.
- The panel temperature should not exceed 100°C.
- Allow the surface to cool down before handling or polishing.

## IR curing of plastic parts:

To reduce the risk of deformation, place the IR unit at the largest indicated distance

## IR curing of waterborne products:

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

Bodyfillers / Polysurfacer	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

Fillers	Short wave		Medium wave	
	Distance	Drying time (L+H)	Distance	Drying time (L+H)
Autosurfacer HB	50-70 cm	4+8 minutes	40-60 cm	6+10 minutes
Autosurfacer Rapid	50-70 cm	5+10 minutes	40-60 cm	5+12 minutes
Colorbuild Plus				
Primer Surfacer EPII				
Autosurfacer WB	X	X	X	X

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Single Stage Topcoats	Short wave		Medium wave	
	Distance	Drying time (L+H)	Distance	Drying time (L+H)
Autocryl Plus LV	50-70 cm	4+6 minutes	40-60 cm	4+8 minutes

Clearcoats	Short wave		Medium wave	
	Distance	Drying time (L+H)	Distance	Drying time (L+H)
Autoclear Mix & Matt	50-70 cm	2+6 minutes	40-60 cm	2+6 minutes
Autoclear Rapid Air AS	50-70 cm	4+6 minutes	40-60 cm	4+6 minutes
Autoclear 2.0	50-70 cm	4+8 minutes	40-60 cm	4+10 minutes
Autoclear HSR Antiscratch				
Autoclear LV				
Autoclear LV Exclusive				
Autoclear LV Superior				
Autoclear WB 2.0				

\* Allow for **15** minutes flash off

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