

# Infra Red Drying CR Products

**FOR PROFESSIONAL USE ONLY**

## Description

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

Please respect the following:

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

## Plastic parts:

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

Bodyfillers / Polysurfacers	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 Fillers	Short wave		Medium wave	
	Distance	Drying time (L+H)	Distance	Drying time (L+H)
Priming Filler 680	50-70 cm	3+5 minutes	40-60 cm	3+8 minutes
Multi Use Filler Xcel	50-70 cm	5+10 minutes	40-60 cm	6+10 minutes
Colorbuild Plus	50-70 cm	5+10 minutes	40-60 cm	5+12 minutes
Primer Surfacer EP				
Autosurfacers Optima (No flash before curing needed)	50-70 cm	5 minutes (High power)	NA	NA
Single Stage Topcoats	Short wave		Medium wave	
	Distance	Drying time (L+H)	Distance	Drying time (L+H)
Autocryl Plus	50-70 cm	4+6 minutes	40-60 cm	4+8 minutes
Autocryl Plus LV	50-70 cm	4+6 minutes	40-60 cm	4+8 minutes

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Clearcoats	Short wave		Medium wave	
	Drying time (L+H)	Distance	Drying time (L+H)	Distance
Autoclear Mix & Matt *	50-70 cm	2+6 minutes	40-60 cm	2+6 minutes
Autoclear Rapid	50-70 cm	4+6 minutes	40-60 cm	4+6 minutes
Autoclear LV Superior	50-70 cm	4+8 minutes	40-60 cm	4+8 minutes
Autoclear 2.0 (Red) Fast/Slow				
Autoclear Expert HS				
Autoclear Xcel				

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

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**FOR PROFESSIONAL USE WITH SUITABLE HS&E EQUIPMENT**

**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.

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