



INFRARED DRYING RECOMMENDATIONS



GENERAL

Infrared cure equipment can increase productivity of a refinishing operation when used in combination with Axalta® products. The heat created by the equipment accelerates cure rate reducing the wait times from the coating application procedure to the next procedure in refinishing the part. The reduced wait time benefits the shop in overall efficiency.

Infrared equipment is used immediately after paint application of the finish. The intense heat generated with exposure to the lamps helps reduce dry time and it accelerates cure of the paint. Care must be taken in operating IR lamps to prevent damaging parts. Care must also be taken to avoid finish quality problems such as blistering and solvent popping. The information provided below will help the shop be more successful when using the equipment.

INFRARED SAFETY TIPS

- Follow equipment manufacturer's directions.
- Use caution around the equipment – fixtures and bulbs become very hot.
- Do not use infrared equipment in spray booths where flammable paint or solvents are sprayed.
- Refer to the manufacturer's instructions to select extension cords to use with the equipment. Manufacturers will recommend only heavy (#14 wire, minimum) industrial extension cords.
- Make sure the electric circuit being used is adequate for the equipment wattage and amperage. Consult an electrician.
- If the circuit breaker trips more than twice, do not continue to reset and use the circuit. The load (equipment wattage) must be reduced, or the circuit must be upgraded. Consult an electrician.

RECOMMENDATIONS

The refinisher must determine the level of sophistication needed to optimize drying and curing with infrared equipment. Refinishers using infrared equipment routinely should invest in a durable piece of equipment with enough options to make it easy to work with. For refinishers using infrared equipment only as a backup or in emergencies, a less expensive version is suitable.

Most customers would probably benefit from a good quality quartz-tube type infrared heater. A multiple-tube heater head is desirable for even application of the infrared energy.

Some customers may have a "heat lamp" fixture that has incandescent bulbs in it. We suggest upgrading it with R-40 or G-30 infrared bulbs. Be careful not to exceed the wattage limit of the fixture.

HELPFUL EQUIPMENT FEATURES

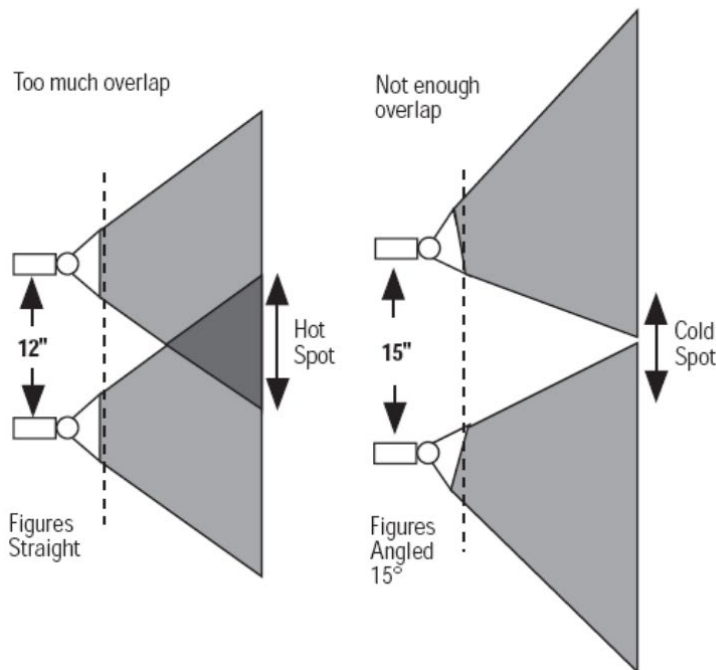
- Timers for automatic shutoff
- Lockable, heavy-duty casters
- Balanced weight design for all height settings
- Easily adjustable fixtures
- Adjustable power setting or voltage
- Adequate cord length so that an extension cord is not necessary



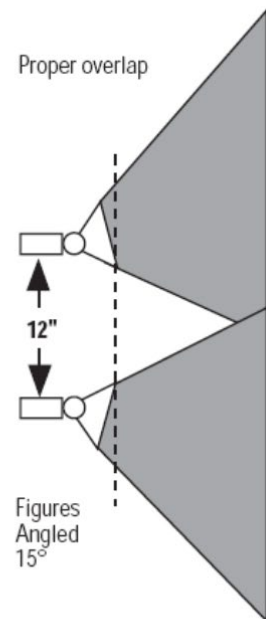
DRY TIMES

- Follow the paint product recommendations for film builds, flash times between coats, air pressure, etc.
- Follow the lamp distance recommendation closely. If lamps are placed too close to the job, overheating will occur resulting in blistering of the film. The minimum distance of the lamp to the vehicle is specified by the equipment manufacturer.
- Apply the infrared heat as soon as possible after spraying the paint to minimize the chance of skinning over. This will help prevent solvent popping.
- Set up the heater at the recommended heater-to-substrate distance; turn on the heater by setting the timer to the recommended drying time.
- Adjust multiple-tube fixtures to properly “cover” the wet, painted area. See the illustration below for proper overlap.

Incorrect Setup



Correct Setup



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1.800.668.6945
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