



IR Drying Technology and Product Curing Guide

Field Settings

Disclaimer: Machine set up recommendations are meant as a starting point. Technicians must complete final adjustments based on products selected and local conditions.

REVO Short wave electric IR



Faster Repairs. Better Results.

Model Name		REVO Speed			
		Temp	Speed	Distance	Notes:
Body Filler		140°F (60°C)	26"/min	18"	
Surfacer		190°F (88°C)	20"/min	18"	
Sealer		145°F (63°C)	28"/min	18"	
Basecoat	ABP™	140°F (60°C)	28"/min	~18"	
Clear	P190-6950	210°F (99°C)	15"/min	~18"	Flash before cure Flash before cure
	P190-6930	210°F (99°C)	15"/min	~18"	
	P190-6920	225°F (107°C)	15"/min	~18"	

Additional Notes:

- Adjustments needed based on substrate, color, etc.
- Machine is preprogrammed, select which product you are curing on the touch screen, set the distance by using the sonar icon on the screen, sonar indicator on the screen will turn green at proper distance. Only one pass is required to fully cure.

Model Name		REVO Rapid			
		Temp	Speed	Distance	Notes:
Body Filler		140°F (60°C)	3 minutes	2'	
Surfacer		185°F (85°C)	8 minutes	2'	
Sealer		145°F (63°C)	4 minutes	2'	
Basecoat		140°F (60°C)	4 minutes	2'	
Clear		200°F (93°C)	8 minutes	2'	

Additional Notes:

- Automatically regulates temperature, no adjustments needed.
- Machine is preprogrammed. Select the product applied and push start and the machine will automatically monitor and adjust temperature.

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Model Name: REVO Spot				
	Temp	Speed	Distance	Notes:
Body Filler	140°F (60°C)	3 minutes	2'	
Surfacer	185°F (85°C)	8 minutes	2'	
Sealer	145°F (63°C)	4 minutes	2'	
Basecoat	140°F (60°C)	4 minutes	2'	
Clear	200°F (93°C)	8 minutes	2'	

Additional Notes:

- Automatically adjust temperature
- Machine has two knobs. One to adjust temperature and one to adjust time in minutes. There is a decal on the machine which tells you the parameters that should be used for each type of product your are curing.



Model Name: REVO Handheld				
	Temp	Speed	Distance	Notes:
Body Filler	140°F (60°C)	2 minutes	2-4 inches	
Surfacer	190°F (88°C)	2-3 mins	2-4 inches	
Sealer	140°F (60°C)	2-3 mins	2-4 inches	
Basecoat	140°F (60°C)	2-3 mins	2-4 inches	
Clear	200°F (93°C)	3-4 mins	2-4 inches	

Additional Notes:

- Adjustments needed based on substrate, color, etc.
- Temperature should be monitored with an infrared thermometer. Handheld unit is only meant for sport repairs. When using for spot repairs each coat of the repair process should be individually dried.



Additional Overall Notes:

- Almost every clear will run at the same temperature as long as it is mixed with medium or slow hardener and reducer.
- However there are two differences, AQUABASE® Plus P190-6930 will run at the same temperature but it likes a 5 minute flash after the final coat before curing with REVO. If you put heat on it right away it will occasionally die back a little bit. After a 5 minute flash it works perfectly and maintains clarity. *Aquabase* Plus P190-6920 can be cured at a higher temperature and is almost immediately buffable.



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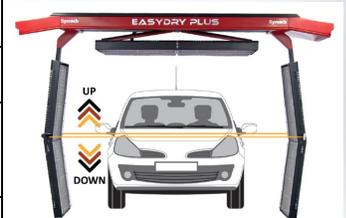
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Symach Gas catalytic IR



Model Name Easydry (Arch located in Spraytron Booth)

		Temp	Speed	Distance	Notes:
Body Filler					
Surfacer					
Sealer	P565-3145	176°F (80°C)	40"/min	~20"	
Basecoat (Dropcoat)	ABP	131°F (55°C)	44"/min	~20"	
		122°F (50°C)	64"/min	~20"	
Clear	P190-6950	176°F (80°C)	80cm/min	~20"	1st pass
	P190-6950	230°F (110°C)	60cm/min	~20"	2nd pass



Additional Notes:

- Allow 5 minutes flash between coats. Fans in Spraytron decrease after 1 minute reducing airflow over panels.
- Pulling the trigger on the spray gun or plugging in hand-held venture will keep booth airflow movement higher to improve flash between coats (this is an adjustable setting).

Model Name Kombitron

		Temp	Speed	Distance	Notes:
Body Filler	N/A				
Surfacer	N/A				
Sealer	N/A				
Basecoat	N/A				
Clear	P190-6930	219°F (104°C)	40cm/min	~20"	Bumpers off of car
	P190-6950	219°F (104°C)	40cm/min	~20"	
	P190-6950	230°F (110°C)	36cm/min	~20"	



Additional Notes:

- Minimal air movement to remove solvent from cabin.
- Factory default setting is 1 minute cool down after cure.
- Kombitron arch is set to urn a full pass out and a full pass back. Travel distance is 260 inches or 660 cm.

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Symach Gas catalytic IR

Model Name: Flydry

	Temp	Speed	Distance	Notes:
Body Filler				
Surfacer				
Sealer				
Basecoat				
Clear P190-6920	220°F (104°C)	22cm/min	40-50 cm	1 Pass



Additional Notes:

- The robot automatically manages the drying treatment for distance, color, paint thickness and climate.
- The automatic adjustment and control of the treatment are based on a built-in laser that constantly reads the quality of the drying process.



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GreenTech Gas Catalytic IR



Model Name E6

		Temp	Speed	Distance	Notes:
Body Filler	N/A				
Surfacer	P565-5405	230°F (110°C)	70cm/min	60cm	1st and 2nd pass
Sealer	P565-3145	248°F (120°C)	120cm/min	60cm	1 pass
Basecoat	ABP	113°F (45°C)	145cm/min	60cm	1 pass
Clear	P190-6950	194°F (90°C)	120cm/min	60cm	1st pass
		266°F (130°C)	110cm/min	60cm	2nd pass
		266°F (130°C)	100cm/min	60cm	3rd pass



Additional Notes:

- Use paper or aluminum foil to protect mirrors.
- 30-60 second pauses can/should be used for curing clears on bumpers and flat edges of vehicles/panels that the robot doesn't directly pass over.
- For surfacer, can use sealer setting to flash off between coats.

Model Name E7

		Temp	Speed	Distance	Notes:
Body Filler		176°F (80°C)	100cm/min	50cm	1 pass
Surfacer		176°F (80°C)	80cm/min	50cm	1st and 2nd pass
Sealer		140°F (60°C)	160cm/min	50cm	1 pass
Basecoat		104°F (40°C)	155cm/min	50cm	1 pass
Clear		212°F (100°C)	105cm/min	50cm	1st pass
		212°F (100°C)	130cm/min	50cm	2nd pass
		212°F (100°C)	125cm/min	50cm	3rd pass



Additional Notes:

- No settings on the software to monitor temp so this is done with an external temp gun during the set up phase.
- 30-60 second pauses can/should be used for curing clears on bumpers and flat edges of vehicles/panels that the robot doesn't directly pass over.
- For surfacer, can use sealer setting to flash off between coats.

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GreenTech Gas Catalytic IR

Model Name: E1 (handheld)				
	Temp	Speed	Distance	Notes:
Body Filler	176°F (80°C)		5-10cm	
Surfacer	176°F (80°C)		5-10cm	
Sealer	158°F (70°C)		5-10cm	
Basecoat	122°F (50°C)		5-10cm	
Clear	212°F (100°C)		5-10cm	



- During curing time the process after the panel reaches the products desired temp. Hold the temp for 2 minutes except for clears where it is 4-7 minutes.
- Slow and smooth circular movement to ensure full/complete curing of the whole product area.
- For surfacer can use sealer settings to flash off between coats.

Additional Overall Notes:

- The E7 is not listed for use in hazardous environments so sprayed product (base/primer) would only be possible in a 3oz. cup in certain jurisdictions, and clearcoat would presumably have to be applied in a prepdeck / CTOF and then moved elsewhere to be dried. The figures are given from testing in Europe where this product can be installed in a booth, in the US E7 is only really used for drying filler and roller primer.

