



CURING CHART

General Recommendations for non-sensor units

Distance from panel					
Unit type	201	202	204	300	400
Distance	31 - 39"	31 - 39"	39 - 47"	22" - 24"	24"

flash or half

power



cure or full

power



Body Filler

	Power level	Time(min)	Power level	Time(min)
200 / 500 model	*	2	**	4
300 model	*	3	**	5
400 / 5000 model	3	3	6	3

Fine Putty

	Power level	Time(min)	Power level	Time(min)
200 / 500 model	*	2	**	4
300 model	*	3	**	5
400 / 5000 model	3	3	6	3

Primer

	Power level	Time(min)	Power level	Time(min)
200 / 500 model	*	3	**	5
300 model	*	3	**	6
400 / 5000 model	3	3	7	4

Base Coat

	Power level	Time(min)	Power level	Time(min)
200 / 500 model	*	3	**	5
300 model	*	3	**	6
400 / 5000 model	3	3	7	4

Top Coat

	Power level	Time(min)	Power level	Time(min)
200 / 500 model	*	3	**	7
300 model	*	3	**	8
400 / 5000 model	3	3	7	7

Clear Coat

	Power level	Time(min)	Power level	Time(min)
200 / 500 model	*	3	**	7
300 model	*	3	**	8
400 / 5000 model	3	3	7	7

IRT Curing Tips

Follow the paint application recommendations for film-builds, **flash times between coats**, air pressure, etc.

Never try to cure different materials at the same time, cure each separately.

Be careful not to over cure bondos and fillers, do not exceed 160F.

Do not apply paint or primer over uncured materials, and expect the IR to have good results. This may cause solvent popping.

If overheating or blistering occurs, reduce curing times and maintain distance.

Bright colours reflect the IR, resulting in longer curing times.

Dark colours absorb the IR, resulting in shorter curing times.

When curing areas around plastic parts, such as a mirror or light, cover the plastic part with 2 - 3 layers of masking paper for protection.

* Not applicable, set time on low power timer (200) QR top row of parameter display (300).

** Not applicable, set time on high power timer (200) QR bottom row of parameter display (300).

This chart is meant as a guide of recommendations only, please consult with your paint supplier before using IRT to cure.