



# CURING CHART

## General Recommendations for XLNC sensor units

### To change factory settings.

1. Scroll the up or down button until desired material is displayed.
2. Press enter button to display parameter settings.
3. Press and hold the enter key until the top left number starts to flash, use the up & down buttons to set new value.
4. Press the enter button to save new value and move to next number.
5. Change each number as desired and save each new value by pressing enter.
6. Do not press off button until all numbers have been saved and are no longer flashing.

### Body Filler

	Time(min)	Temp. Rise	Max. Temp
Flash	3	25	125
Cure	5	25	150

### Fine Putty

	Time(min)	Temp. Rise	Max. Temp
Flash	3	25	125
Cure	5	25	150

### Primer

	Time(min)	Temp. Rise	Max. Temp
Flash	3	25	140
Cure	5	25	170

### Waterbase

	Time(min)	Temp. Rise	Max. Temp
Flash	3	25	140
Cure	0		

### Single Stage

	Time(min)	Temp. Rise	Max. Temp
Flash	3	25	140
Cure	6	25	200

### Base/Clear

	Time(min)	Temp. Rise	Max. Temp
Flash	3	25	140
Cure	9	25	190

### IRT Curing Tips

\*Before starting, be sure to align the **XLNC** noncontact temperature sensor over the repair area. Avoid wheel wells and windows.

\*For units equipped with **LASER POINTER**, be sure all laser points are aligned over the repair area. Avoid wheel wells and windows.

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.

Cure times listed are averages taken from several paint suppliers. If the repair is not cured enough, increase cure time by 1 or 2 minutes

If overheating or blistering occurs, reduce curing temp and increase time.

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.

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

Questions? Call us toll free at 1-866-IRT-HEAT (478-4328)