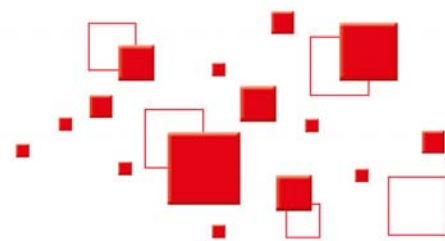


## Infrared drying

### Infrared drying parameters for R-M products

#### D 4



#### Process description

Recommended infrared drying parameters in automotive refinishing

#### Safety instructions

It cannot be ruled out that these products contain particles < 0.1 µm.

The products are suitable for professional use only.

For the use of these products please adhere to the actual safety recommendations and the personal protective equipment.

|                                    | Duration | IR-intensity<br>(short wave)<br>Increase temperature by | Max. surface temperature |
|------------------------------------|----------|---|--------------------------|
| <b>Undercoat materials</b>         |          |   |                          |
| STOP putties                       | 4 min.   | 20°C / min.   | 80°C                     |
| STOP FILLER II                     | 10 min.  | 20°C / min.   | 90°C                     |
| AKROFILL                           | 3 min.   | 15°C / min.   | 65°C                     |
|                                    | 7 min.   | 20°C / min.   | 100°C                    |
| Fillers                            | 4 min.   | 15°C / min.   | 60°C                     |
|                                    | 5 min.   | 20°C / min.   | 80°C                     |
| DIRECTFILLER                       | 4 min.   | 15°C / min.   | 60°C                     |
|                                    | 6 min.   | 20°C / min.   | 80°C                     |
| PERFECTFILLER with<br>SPEEDFLASH   | 6 min.   | 20°C / min.   | 80°C                     |
| PERFECTFILLER with<br>SPEEDFLASH S | 4 min.   | 20°C / min.   | 80°C                     |

The data contained in this publication are based on our current knowledge and experience. In view of the many factors that may affect processing and application of our products, these data do not relieve processors from carrying out their own investigations and tests; neither do these data imply any guarantee of certain properties, nor the suitability of the products for a specific purpose. Any descriptions, drawings, photographs, data, proportions, weights etc. given herein are for general information purpose only; they may change without prior information and do not constitute the agreed contractual quality of the products (product specification). The latest version supersedes all previous versions. You can obtain the latest version from our website at [www.mppaint.com](http://www.mppaint.com) or directly from your sales partner. It is the responsibility of the recipient of our products to ensure that any proprietary rights and existing laws and legislation are observed.

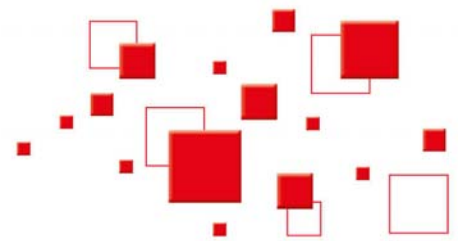
R-M Automotive Refinish Paints, Z.I. du Merret F-60676 Clermont de l'Oise Cedex, Tel. (+33) (0) 3 44 77 77 77, 11/2017



## Infrared drying

### Infrared drying parameters for R-M products

#### D 4



|  | Duration         | IR-intensity<br>(short wave)<br>Increase temperature by | Max. surface temperature |
|--|------------------|---|--------------------------|
| <b>Basecoats &amp; topcoats</b>        |                  |   |                          |
| ONYX HD                                | 4 min.           | 15°C / min.   | 60°C                     |
| DIAMONT                                | 4 min.           | 15°C / min.   | 60°C                     |
| UNO HD / UNO HD CP /<br>UNO HD CP PLUS | 4 min.<br>4 min. | 15°C / min.<br>20°C / min.                              | 60°C<br>90°C             |
| <b>R-M standard clear</b>              |                  |   |                          |
|  | 4 min.<br>4 min. | 15°C / min.<br>20°C / min.                              | 60°C<br>90°C             |
| EASYCLEAR C 2510 /<br>EVERCLEAR C 2550 | 10 min.          | 15°C / min.   | 100°C                    |
| GLOSSCLEAR C 2560                      | 10 min.          | 25°C / min.   | 115°C                    |
| RAPIDCLEAR C 2570                      | 10 min.          | 25°C / min.   | 70°C                     |