



Working Process: Infrared Drying

Why choose infrared drying?

- ✓ Higher shop output with excellent through-drying
- ✓ Time savings
- ✓ Lower energy consumption
- ✓ Greater economy

How to use Infrared drying?

- ✓ The distance between the panel and infrared depends on the equipment used. Refer to the manufacturer's instructions.
- ✓ Observe safety rules and regulations.

This guide for drying time is based on: (Infrared distance 2 ft. / 60 cm)

Standex Products	Medium wave		Short wave		
	Flash off time without IR	100% Power	Flash off time without IR	50% Power (flash off power)	100% Power
Standex Polyester Stoppers and 2K Fillers	5 min 5 min	5 – 7 min 15 min 10 – 12 min	5 min 5 min	2 – 3 min 10 min 2 min PLUS	10 – 14 min
Standohyd Basecoat: Dark colors Light colors		3 min 4 – 6 min		2 min 3 – 4 min	
Standocryl® 2K Paints: Dark colors Light colors	5 min 5 min	12 min 14 min	5 min 5 min	12 min 2 min PLUS	*1 8 – 12 min
Standocryl 2K Clears: Dark colors Light colors	5 min 5 min	13 – 16 min 15 – 18 min	5 min 5 min	13 – 16 min 3 min PLUS	*1 10 – 12 min

*1 = if too hot solvent pop can occur

Important Technical Remarks:

- Drying times may vary from unit due to different models and different heating elements.
- If Infrared drying is used, each film should be individually dried to prevent peeling and solvent popping.
- Actual film thickness will affect dry times with thicker films requiring additional times.

Important Legislative Remarks:

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