

## Bake Cycle Chart

Information for determining proper dry times and re-coat windows when using a bake cycle with your painting program.

Guide for:  
Bake Cycle

Recommended info:

EX-2C Topcoat TDS  
Clear 100 TDS  
SuperCat II TDS

### Additional Information:

Speeding up Cool Down

Adding a swamp cooler.

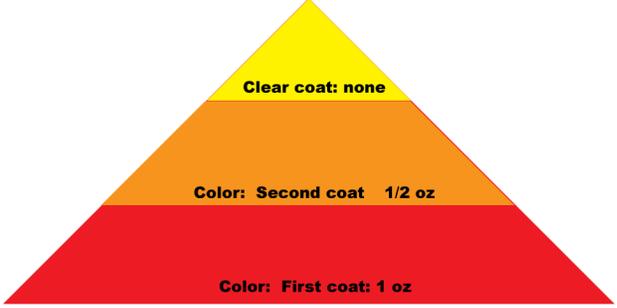
This is NOT an air conditioner.

Air conditioners remove moisture from the air when cooling; Swamp coolers add moisture during cooling.

By doing this not only are you cooling the temp of the surface and tightening the film but you are adding that moisture to the Iso.

\*Please note that humidity and air flow will be factors in determining the best amount of time for this flash/purge process

QUESTIONS?  
PLEASE CONTACT US.  
1-800-661-9930  
info@endura.ca

Questions	Answers
Time between topcoat & clear and at what temp.	<p><b>Recommended bake temperature:</b> 140°F -160°F (this is a guideline and can be adapted based on conditions, however a lower temp will result in longer dry times and a higher temperature can result in solvent popping.)</p> <p><b>Time:</b> Bake cycle of 45-60 minutes</p> <p><b>When to turn the heat on:</b> After painting is complete it is recommended to purge the booth of solvent for approximately 15 min*. This will also allow a flash time for the fast solvents to evaporate. After the initial flash then a bake cycle can be started, most of the new booths come with a built in flash/purge cycle. (if no SuperCat II is used in the mixture works but will not be cured enough for taping.)</p>
Using SuperCat II	<p><b>Recommended bake temperature:</b> 140°F -160°F</p> <p>The use of super cat 2 allows the color to be taped on and is dry enough to allow for another color application. When dealing with super cat in a booth use the "pyramid" thought pattern. More on the first layer, less as the layers move up toward the clear. (Amounts below are per gallon)</p> 
Time between clear coat & handling time and at what temp.	<p><b>Recommended bake temperature:</b> 140°F -160°F (this is a guideline and can be adapted based on conditions, however a lower temp will result in longer dry times and a higher temperature can result in solvent popping)</p> <p><b>Time:</b> Bake cycle of 45-60 minutes</p> <p><b>When to turn the heat on:</b> After painting is complete it is recommended to purge the booth of solvent for approximately 15 min*. This will also allow a flash time for the fast solvents to evaporate. After the initial flash then a bake cycle can be started, most of the new booths come with a built in flash/purge cycle.</p>
Cool down times	<p>The unit <b>MUST</b> cool down and return to ambient temperature (70°F being ideal)</p> <p>If proper cool down procedures are not followed, the following issues can occur:</p> <ol style="list-style-type: none"> <li>1. Poor flow of subsequent coats, as solvents are released too quickly</li> <li>2. Shrinking issues as the two coating layers are at different temperatures</li> <li>3. If product is applied to quickly, de-lamination can occur.</li> </ol>