

CURING CYCLE TIMES

ACRYLIC URETHANE CLEAR

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	All cure times include 10 minutes to allow surface of vehicle to reach 140° F.		Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with 	
		Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)	Spray Booth Convection Direct Fire Cure (165° F)		
Autoclear III w/ standard hardener, standard activator	10 hours	45 minutes	40 minutes	25 minutes	Refer to paint manufacturer's tech sheets.

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with AKZO NOBEL SIKKENS at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

For additional information, contact:
GLOBAL FINISHING SOLUTIONS TECHNICAL CENTER
1-800-300-1546
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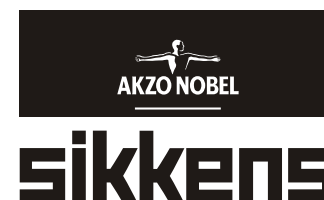
SmartCure™

Performance Data

Accelerated Paint Cure System

CURING CYCLE TIMES

ACRYLIC URETHANE CLEAR



Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	All cure times include 10 minutes to allow surface of vehicle to reach 140° F.		Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with 	
		Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)	Spray Booth Convection Direct Fire Cure (165° F)		
Autoclear III w/ production hardener, production activator	4 hours	25 minutes	20 minutes	15 minutes	Refer to paint manufacturer's tech sheets.

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with AKZO NOBEL SIKKENS at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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CURING CYCLE TIMES

ACRYLIC URETHANE CLEAR

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	All cure times include 10 minutes to allow surface of vehicle to reach 140° F.		Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with 	
		Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)	Spray Booth Convection Direct Fire Cure (165° F)		
Autoclear III w/ production hardener, standard activator	5 hours	30 minutes	25 minutes	15 minutes	Refer to paint manufacturer's tech sheets.

Note: Autoclear III with standard hardener and production reducer has the same drying times as stated.

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with AKZO NOBEL SIKKENS at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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SmartCureTM

Performance Data

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CURING CYCLE TIMES

CHROMA SYSTEMS CLEAR



Automotive Finishes

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	Spray Booth Convection Indirect Fired Cure (Heat Exchanger) (140° F)	Spray Booth Convection Direct Fired Cure (140° F)	Global Finishing Ultra or Expert 2000 or Concept II / Cure TM Spray Booth with SmartCureTM	
V7500 S ChromaClear® Multi-Use V7585 S Overall Activator Reducer	16 hours	30 minutes	30 minutes	20 minutes	Refer to paint manufacturer's tech sheets.
V7500 S ChromaClear® Multi-Use V7585 S Overall Activator Reducer 189 S Accelerator	4 hours	30 minutes	30 minutes	10 minutes	

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with DuPont at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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Accelerated Paint Cure System



Automotive Finishes

CURING CYCLE TIMES

CHROMA SYSTEMS CLEAR

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	Spray Booth Convection Indirect Fired Cure (Heat Exchanger) (140° F)	Spray Booth Convection Direct Fired Cure (140° F)	Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with SmartCure™	
72200 S ChromaPremier™ Productive Clear 12305 S ChromaPremier™ Activator 12385 S ChromaPremier™ Slow Reducer	16 hours	30 minutes	30 minutes	20 minutes	Refer to paint manufacturer's tech sheets.
72200 S ChromaPremier™ Productive Clear 12305 S ChromaPremier™ Activator 12385 S ChromaPremier™ Slow Reducer 389 S Accelerator	4 hours	30 minutes	30 minutes	10 minutes	

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with DuPont at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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Automotive Finishes

CURING CYCLE TIMES

CHROMA SYSTEMS CLEAR

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	Spray Booth Convection Indirect Fired Cure (Heat Exchanger) (140° F)	Spray Booth Convection Direct Fired Cure (140° F)	Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with SmartCure™	
72400 S ChromaPremier™ Appearance Clear 12305 S ChromaPremier™ Activator 12385 S ChromaPremier™ Slow Reducer	Not Recommended	30 minutes	30 minutes	20 minutes	Refer to paint manufacturer's tech sheets.
72400 S ChromaPremier™ Appearance Clear 12305 S ChromaPremier™ Activator 12385 S ChromaPremier™ Slow Reducer 389 S Accelerator	Not Recommended	30 minutes	30 minutes	10 minutes	

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with DuPont at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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Accelerated Paint Cure System



Automotive Finishes

CURING CYCLE TIMES

CHROMA SYSTEMS CLEAR

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	Spray Booth Convection Indirect Fired Cure (Heat Exchanger) (140° F)	Spray Booth Convection Direct Fired Cure (140° F)	Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with SmartCureTM	
2100 S ChromaClear® Multi-Use 2105 S ChromaClear® 2.1 Activator 2185 S ChromaClear® 2.1 Slow Reducer	16 hours	30 minutes	30 minutes	20 minutes	Refer to paint manufacturer's tech sheets.
2100 S ChromaClear® Multi-Use 2105 S ChromaClear® 2.1 Activator 2185 S ChromaClear® 2.1 Slow Reducer 389 S Accelerator	4 hours	30 minutes	30 minutes	15 minutes	

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with DuPont at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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Automotive Finishes

CURING CYCLE TIMES

CHROMA SYSTEMS CLEAR

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	Spray Booth Convection Indirect Fired Cure (Heat Exchanger) (140° F)	Spray Booth Convection Direct Fired Cure (140° F)	Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with SmartCure™	
ChromaPremier™ Single Stage 12305 S ChromaPremier™ Activator 12385 S ChromaPremier™ Slow Reducer	Not Recommended	30 minutes	30 minutes	20 minutes	Refer to paint manufacturer's tech sheets.
ChromaPremier™ Single Stage 12305 S ChromaPremier™ Activator 12385 S ChromaPremier™ Slow Reducer 389 S Accelerator	Not Recommended	30 minutes	30 minutes	20 minutes	

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with DuPont at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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Accelerated Paint Cure System



Automotive Finishes

CURING CYCLE TIMES

ACRYLIC URETHANE CLEAR

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	All cure times include 10 minutes to allow surface of vehicle to reach 140° F.		Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with 	
		Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)	Spray Booth Convection Direct Fire Cure (165° F)		
Chroma Premier 72200 (Spot) w/ 12385 Reducer, 12305 Hardener	16 hours	35-45 minutes	30-40 minutes	20 minutes	Refer to paint manufacturer's tech sheets.
Chroma Premier 72400 (Complete) w/ 12385 Reducer, 12305 Hardener	16 hours	35-45 minutes	30 minutes	20 minutes	

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with DuPont at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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SmartCure™

Performance Data

Accelerated Paint Cure System

CURING CYCLE TIMES

ACRYLIC URETHANE CLEAR

BASF



Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	All cure times include 10 minutes to allow surface of vehicle to reach 140° F.		Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with 	
		Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)	Spray Booth Convection Direct Fire Cure (165° F)		
Glasurit 923-94 (Spot or Complete) w/ 929-83 Hardener 352-91 Reducer	2 hours	45 minutes	40 minutes	20 minutes	Refer to paint manufacturer's tech sheets.
Glasurit 923-355 (Spot or Complete) w/ 929-84 Hardener	3 hours	45 minutes	40 minutes	20 minutes	
Glasurit 923-155 (Spot or Complete) w/ 929-74 Hardener 352-216 Reducer	2 hours	45 minutes	40 minutes	20 minutes	

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with BASF Glasurit at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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Accelerated Paint Cure System

**AUTOCOLOR**

CURING CYCLE TIMES

ACRYLIC URETHANE CLEAR

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	All cure times include 10 minutes to allow surface of vehicle to reach 140° F.		Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with 	
		Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)	Spray Booth Convection Direct Fire Cure (165° F)		
HS Clear P190-643 w/ P210-854 Hardener P850-1693 Thinner	4-6 hours	35 minutes	30 minutes	20 minutes	Refer to paint manufacturer's tech sheets.

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with ICI at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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SMC-ICI(03/03)/1

CURING CYCLE TIMES

ACRYLIC URETHANE CLEAR

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	All cure times include 10 minutes to allow surface of vehicle to reach 140° F.		Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with 	
		Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)	Spray Booth Convection Direct Fire Cure (165° F)		
TEC-BASE Clear 8889 w/ TS-5 Hardener	8 hours	35 minutes	30 minutes	13 minutes	Refer to paint manufacturer's tech sheets.

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with Martin Senour at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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SmartCure™**Performance Data**

Accelerated Paint Cure System

CURING CYCLE TIMES
ACRYLIC URETHANE CLEAR**PPG**
Global

Paint Product	Curing Time						Polishing
	Spray Booth No Heat (70° F)	Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)		Spray Booth Convection Direct Fire Cure (165° F)		Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with 	
		140° Metal Temp Time	P-Spec Cure Time	140° Metal Temp Time	P-Spec Cure Time		
Global D893 (Spot Repair) w/ D872 Reducer, D884 Hardener	8 hours	15 minutes	10-15 minutes	10 minutes	10-15 minutes	8 minutes	Refer to paint manufacturer's tech sheets.
Global D894 (Overall) w/ D872 Reducer, D885 Enhancer, D884 Hardener	8 hours	15 minutes	25 minutes	10 minutes	25 minutes	12 minutes	

Notes: 1. All testing was conducted with:

- Spray temperatures of 75-85° F.;
- Air velocity of 100 FPM at door handle height.
- Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.

- Specific results may vary depending on paint film thickness and formulation.
- SmartCure was tested at the Global Finishing Solutions Technical Center, Atlanta, GA.
- SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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SMC-PPG-GB(03/03)/1 of 2



Performance Data

Accelerated Paint Cure System

WORKABLE TIME FRAME

(Nib, Buff and Polish)

PPG
Global

Paint Company Cure Time	Type of Curing	Industry Norm Booth Purge Time	Booth Cure Time	Industry Norm Booth Cool Down Time	Out of Booth Cool Down Time Before Polishing	Total Time
Global D893 (Spot Repair) w/ D872 Reducer, D884 Hardener	SmartCure™	3 minutes *	8 minutes	5 minutes	10 minutes	26 minutes
	165° F Air	3 minutes *	15-20 minutes	5 minutes	10 minutes	33-38 minutes
Global D894 (Overall) w/ D872 Reducer, D885 Enhancer, D884 Hardener	SmartCure™	3 minutes *	12 minutes	5 minutes	10 minutes	30 minutes
	165° F Air	3 minutes *	30-35 minutes	5 minutes	10 minutes	48-53 minutes

* CONTAMINATION SAFEGUARD: Industry practices recommend 3 minutes before initiation of the cure cycle to allow for removal of overspray.



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SmartCure™**Performance Data**

Accelerated Paint Cure System

CURING CYCLE TIMES
ACRYLIC URETHANE CLEAR**PPG**
Deltron

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)	Spray Booth Convection Direct Fire Cure (165° F)	Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with SmartCure™	
Deltron DCU-2042 (Spot Repair) w/ DT 885 Reducer, DCX61 Hardener	8 hours	20-25 minutes	15-20 minutes	8 minutes	Refer to paint manufacturer's tech sheets.
Deltron DCU-2002 (Overall) w/ DT 885 Reducer, DCX61 Hardener	6-8 hours	35 minutes	30 minutes	30 minutes	

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

For additional information, contact:

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SMC-PPG-DL(03/03)/1 of 2

WORKABLE TIME FRAME

(Nib, Buff and Polish)

PPG Deltron

Paint Company Cure Time	Type of Curing	Industry Norm Booth Purge Time	Booth Cure Time	Industry Norm Booth Cool Down Time	Out of Booth Cool Down Time Before Polishing	Total Time
Deltron DCU-2042 (Spot Repair) w/ DT 885 Reducer, DCX61 Hardener		3 minutes *	8 minutes	5 minutes	10 minutes	26 minutes
	165° F Air	3 minutes *	15-20 minutes	5 minutes	10 minutes	33-38 minutes
Deltron DCU-2002 (Overall) w/ DT 885 Reducer, DCX61 Hardener		3 minutes *	30 minutes	5 minutes	6-8 hours	6-8 hours, 38 minutes
	165° F Air	3 minutes *	30-35 minutes	5 minutes	6-8 hours	6-8 hours, 38-43 minutes

* CONTAMINATION SAFEGUARD: Industry practices recommend 3 minutes before initiation of the cure cycle to allow for removal of overspray.

CURING CYCLE TIMES

ACRYLIC URETHANE CLEAR

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	All cure times include 10 minutes to allow surface of vehicle to reach 140° F.		Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with 	
		Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)	Spray Booth Convection Direct Fire Cure (165° F)		
Diamont DC 95 (Spot or Complete) w/ DH 495 Hardener, Jet95 Accelerator	1½-2 hours	45 minutes	40 minutes	20 minutes	Refer to paint manufacturer's tech sheets.
UNO HD, 3.5 VOC (Spot or Complete) w/ UH 38 Hardener, DR 43 Reducer Jet95 Accelerator	3-4 hours	45 minutes	40 minutes	20 minutes	

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with BASF R-M at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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CURING CYCLE TIMES

ACRYLIC URETHANE CLEAR

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	All cure times include 10 minutes to allow surface of vehicle to reach 140° F.		Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with 	
		Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)	Spray Booth Convection Direct Fire Cure (165° F)		
Permacron 8000 (Spot or Complete) w/ 3368 Hardener 3363 Reducer	12 hours	35-40 minutes	30-35 minutes	22 minutes	Refer to paint manufacturer's tech sheets.

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with Spies Hecker at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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SmartCure™**Performance Data**

Accelerated Paint Cure System

STANDOX

CURING CYCLE TIMES

ACRYLIC URETHANE CLEAR

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	All cure times include 10 minutes to allow surface of vehicle to reach 140° F.		Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with 	
		Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)	Spray Booth Convection Direct Fire Cure (165° F)		
Standocryl 20/60 (Spot) w/ MS Special Hardener	24 hours	35 minutes	30 minutes	20 minutes	Refer to paint manufacturer's tech sheets.
Standocryl 20/60 (Spot) w/ Polar Hardener	12 hours	35 minutes	30 minutes	20 minutes	

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with Standox at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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SMC-STDx(03/03)/1



SmartCure™

Performance Data

Accelerated Paint Cure System

CURING CYCLE TIMES

ACRYLIC URETHANE CLEAR



AUTOMOTIVE FINISHES

Paint Product	Curing Time				Polishing
	Spray Booth No Heat (70° F)	All cure times include 10 minutes to allow surface of vehicle to reach 140° F.		Global Finishing Ultra or Expert 2000 or Concept II / Cure™ Spray Booth with 	
		Spray Booth Convection Indirect Fire Cure (Heat Exchanger) (165° F)	Spray Booth Convection Direct Fire Cure (165° F)		
Ultra 7000 CC-635 (Spot or Overall) w/ US-5 Reducer	8 hours	35 minutes	30 minutes	13 minutes	Refer to paint manufacturer's tech sheets.

- Notes:
- All testing was conducted with:
 - Spray temperatures of 75-85° F.;
 - Air velocity of 100 FPM at door handle height.
 - Industry standards recommend booth purge is 3 minutes and 5 minutes for cool down. Neither cycle is included in curing times.
 - Specific results may vary depending on paint film thickness and formulation.
 - SmartCure was tested in co-operation with Sherwin-Williams at the Global Finishing Solutions Technical Center, Atlanta, GA.
 - SmartCure conforms to NFPA 33, 70 and 86 requirements and is ETL listed.

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