



Enduro Topcoats

Force Cure

Recommendations

The industry leader in water based technology.

Enduro Topcoats are designed for ambient cure. Typical dry time recommendations are based on an average temperature of 75°F and humidity of 50%. Curing conditions will accelerate at higher temperatures and lower humidity. Although heat is not required for cure, dry time can be greatly accelerated by incorporating ovens, fans, and radiant heat.

Force Cure Oven Recommendations:

The following are *typical suggested guidelines* used in production environments where ovens are used:

Topcoats (over a sealed surface):

Topcoat Wet Film Thickness:	3.5—4.5 mils WFT
Flash Time:	3—10 minutes
Oven Temperature:	100°F—120°F
Oven Dwell Time:	5—15 minutes

Starting Point Recommendation:

The following starting point recommendation is used for Pre-Cat Sanding Sealer and Pre-Cat Topcoat:

Topcoats (over a sealed surface):

Topcoat Wet Film Thickness:	3.5—4.5 mils WFT
Flash Time:	3—5 minutes
Oven Temperature:	105°F
Oven Dwell Time:	7 minutes
Cool Down (before sanding):	3-5 minutes

General Troubleshooting Guide:

Topcoat Blistering:

- Cause 1: Excessive film thickness
Solution 1: Apply thinner coat
- Cause 2: Excessive heat
Solution 2: Lower heat in 5°F intervals
- Cause 3: Excessive Air movement during flash time
Solution: 3 Reduce fan speed or divert air movement

Hazing:

- Cause: Moisture trapped in film
Solution 1: Reduce film thickness
Solution 2: Increase Flash Time
Solution 3: Decrease oven temperature in 5°F interval and increase Oven Dwell Time

Coating Balls When Sanded:

- Cause 1: Softening due to heat
Solution 1: Lower oven temperature
Solution 2: Lower oven dwell time
- Cause 2: Coating not completely cured
Solution 1: Increase oven temperature 50°F or increase dwell time

General Notes:

- 1) Sanding Sealers will dry faster than topcoats and require less dwell time before sanding.
- 2) Insure that all air movement is clean, dry, and free of contaminants
- 3) Enduro Topcoat Dry Times (general):

