

SUBJECT: Tech Tip – Using Infra-Red Heat (IR) with Body Filler

Infra-Red Heat (IR) can be used to accelerate the cure time of Body Filler over galvanized steel. Typically IR is used during winter months when cold temperatures prolong cure time. It is important not to overheat the Body Filler or you may experience blistering.

To successfully use IR to accelerate Cure Time, we have developed the following step by step procedure.

1. Mix Body Filler and Catalyst at 50 to 1 mix ratio by weight (see below for examples of the proper amount of filler to use based on the size puddle of Body Filler you need for your job)
2. Thoroughly mix the Body Filler and Catalyst until you get a uniform color
3. Apply the Body Filler to the panel, start by wetting out the surface with a thin coat and then build up to the shape of the repair
4. IR Heat
 - a. Evercoat Body Fillers are designed to be used at body shop temperatures of 60° – 100°F (15° - 38 °C)
 - b. If an IR lamp must be used, take care to keep the surface temperature of the filler under 125°F (52°C)
 - c. Temperatures greater than 125°F (52°C) will interfere with the curing process over galvanized steel.
 - d. Generally, a lamp distance of 3 feet (91 cm) is adequate for proper cure.
 - e. Apply IR for 10 minutes, then allow the panel to cool for another 10 minutes
 - f. The panel will then be ready to Sand

Following these steps will accelerate the Cure Time of the repair, eliminate the risk of blistering, and ensure a quality repair.



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