



# Technical Data Sheet

## Force Dry Recommendations

General Finishes products are designed for ambient dry and cure at 70°F and 50% humidity, out of direct sunlight. Higher temperatures and lower humidity will accelerate dry and cure times. Incorporating ovens, fans, and/or radiant heat in production settings can allow finishing to be done in a shorter period of time.

The following recommendations are a guide, but every finishing environment is unique. Test your finishing schedule to your complete satisfaction. Ensure any air movement is clean and free of contaminants.

### Force Cure Recommendations:

**Wet Film Thickness:** 3.5 - 4.5 wet mils

**Flash Time:** 10 minutes in ambient conditions

**Surface Temp:** Do not exceed 105°F

**Oven Temp:** 100°F to 120°F

**Oven Dwell Time:** 5 - 15 minutes

**Cool Time Before Sanding:** At least 5 minutes

**Time Before Recoat:** At least 30 minutes

### General Troubleshooting Tips:

#### Topcoat Blistering:

Cause 1: Temperature too hot. Solution: Lower heat in 5° intervals

Cause 2: Excessive film thickness. Solution: apply thinner coats

Cause 3: Excessive air movement during flash time. Solution: 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 temperature and increase dwell time

#### Coating balls when sanded:

Cause 1: Softening due to heat. Solution: Decrease temperature or shorten dwell time

Cause 2: Coating not completely dry. Solution: Increase temperature 5°F or increase dwell time

The information and recommendations on this sheet are based upon information gathered at the time of publication and do not act as a safety data sheet. For complete safety and product data, consult the product labels and visit [www.generalfinishes.com](http://www.generalfinishes.com) for complete SDS sheets.

Published March 2020 by General Finishes Corp. East Troy, Wi.