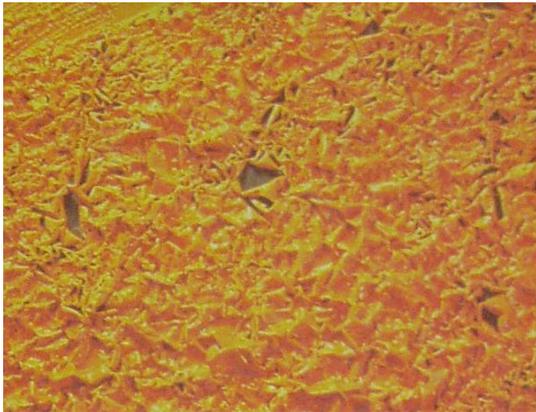


Your Window of Opportunity Opportunity

All freshly applied paints have a "window of opportunity" during which they are chemically soft enough to accept more of the same products or compatible products. For example, 2 coats of color with proper flash time between coats, and then clearcoat with proper dry time between paint and clear.

Danger



Freshly applied paints also have a "window of danger" in which they are not chemically soft enough for additional coats, but not hard enough to resist wrinkling. This happens when the top of the paint finish hardens and cannot be reflowed, but the bottom of the paint finish has not yet cured, so that when you spray additional coats on the car, the bottom of the paint finish floats or moves while the top remains stationary. This causes a wrinkling of the paint surface.

Stability

Once you have passed the window of danger, the paint finish reaches a level of stability where solvent will not affect them. Check your P-bulletin in the Tech area for the sensitivity is different on each product. Once you have passed into the stability window, in order to topcoat, you will need to create a bite into the paint through either sanding with 600 grit or using an adhesion promoter.

If you follow the information and dry times from your P-bulletins in the Tech area, your timing will not be a problem. If you get pulled away in the middle of painting and come back, it is best to wait the full "Air Dry" time listed in your product bulletins. However, here are some guidelines.

Lacquer

This is a 1K product is the most forgiving and you can sand and recoat anytime. That is why most spray can are made from lacquer. However, it is not very durable and is more expensive. The window of danger is almost nothing.

Acrylic Enamel

This can be either a 1K or 2K depending on whether or not you use a catalyst. ALWAYS USE A CATALYST. Otherwise the window of danger can be YEARS! With catalyst the window of danger is 16 hours.

Urethane

Most of these are basecoat clearcoat. The basecoat is pretty forgiving. The window of opportunity to add more coats is 24 hours. The only window of danger is if you go past 24 hours. You must then sand and apply another coat of color before clearing. Clear coats are different. Their window of danger is up to 16 hours depending on the clear. The same can be said for single stage urethane. The window of danger is up to 16 hours.

After 24 hour almost any paint (except enamel without hardner) would be ready to then be sanded and repainted.