

See our new leaflet "Care and Repair of Body Finishes" for further details about touching-up and refinishing jobs. This brochure also contains details about enamel viscosity and sources of supply as well as our Information Sheets DBA-3100, DBA-3101, and DBA-3102.

N. Refinishing Large Panels

The priming and preparation of large panels requires the same amount of care as touching-up work. Large panels are dried in a drying oven. When 80° C enamel is used, it is particularly important to observe the prescribed temperatures. At all parts of the car the temperature should be between 85° C and 95° C. On no account should the temperature be higher than 95° C in order to avoid damage to parts of the car body. Remember that the minimum temperature of 80° C at the refinished part of the car will only be reached after a certain time-lag.

Air-drying enamels are dried at room temperature. It should be noted, however, that increased room temperatures (up to 70° C) accelerate the drying process and that room temperatures below 18° C considerably delay the drying process.

Drying Temperatures and Drying Times

Type of enamel	Drying temperature	Drying time
80° C Synthetic resin enamel	min. 80° C	60 min.
Air-drying synthetic resin enamel	Room temperature	24 hours
	(out-of-dust after 1½ hours) or 60°—70° C	1½ hours

Note: For further details please consult our Information Sheet DBA 3100 and the instructions published by the enamel manufacturers.