



INTERNATIONAL MARKETING, INC. TECHNICAL BULLETIN

SUBJECT: Quick Reference Guide to Oven Recipe or Zone Settings

DATE: October 20, 2006

Ref. IMI Electric and Gas IR Ovens

IMI « QuikCoil » Electric Oven Settings		
	White/Light Colors	Black/Dark Colors
Zone 1	75%	70%
Zone 2	75%	70%
Zone 3	80%	75%
Zone 4	80%	75%

PREHEAT DURATION: 5 minutes *

PHASEDOWN OUTPUT LEVEL: 20% *

PHASEDOWN DURATION: 60 minutes *

* These are factory set defaults. – Phasedown needs to be set at 0%.

IMI « QuikCat » Catalytic Gas Oven Settings		
	White/Light Colors	Black/Dark Colors
Zone 1	75%	69%
Zone 2	75%	69%
Zone 3	75%	69%

Burn-off: All zones 100% (run usually for 45 minutes to an hour once a week)

These zone settings generally produce temperatures in the range of 380° F to 420° F @ 12 - 14 minutes. When analyzing the speed of the wheels passing through the oven, from the time the wheel is ½ in the entrance to the time it is ½ out of the exit will be timed from 12 – 16 minutes depending on the choice of powder. The exit temperature should be close to the max temperature specified within that products cure curve requirements.

Questions regarding the above technical bulletin may be directed to:

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