



## **INTERNATIONAL MARKETING, INC. TECHNICAL BULLETIN**

**SUBJECT: Verifiable Cure Procedures**

**DATE: October 19, 2004**

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**The following procedures should be logged daily for accountability purposes:**

This procedure should be followed at least two times per shift. If there have been problems with cure issues in the past, the frequency of the procedure may need to be increased. Log the events. Logging these procedures will provide you with a verifiable component in your QC process and an invaluable tool if problems do arise.

Tools needed: Non-contact Thermometer, Stop Watch, MEK, Q-tips, pen and a logbook or binder

1. Visual Oven Inspection – Check to make sure all emitters, generators, panels or rods are functioning. If the source of heat/IR is black instead of a red glow a non-contact thermometer will be needed to verify the core temperature. These readings should be recorded to note any changes. If there are poorly or nonfunctioning emitters they need to be replaced to assure the oven's full efficiency.
2. Entrance Temperature of the Wheel – Using a non-contact thermometer measure the temperature of the wheel when it is fully in the first position of the oven.
3. Exit Temperature of the Wheel – Using a non-contact thermometer measure the temperature of the wheel in its last position in the oven before exiting. The exiting temperature should be 360° - 400° depending on the type of powder and oven. Compare to manufacturer's cure curve.
4. Time the Duration – Time the wheel from the entrance to the exit position using either a stop watch or a chronograph. This will set a baseline when reporting cure problems. Most standard applications will need to see 400° for ten minutes or more to pull a full cure.
5. MEK Testing – When the wheels are room temperature check for a full cure using MEK and a Q-tip. Using 40-50 light rubs (usually in the tire mounting area) with a Q-tip moist with MEK. The coating may slightly soften but it should not dissolve to steel.
6. OPTIONAL – Other tests can be performed at this time for adhesion and pinholes if desired.

**NOTE:** In preparing a form for your log, include a page that lists the details of your oven for a quick reference for parts, etc. Include the following information: Manufacturer, Model Number, Serial Number, Voltage, Amperage, and any other information that will help with future service.

**Questions regarding the above technical bulletin may be directed to:**

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