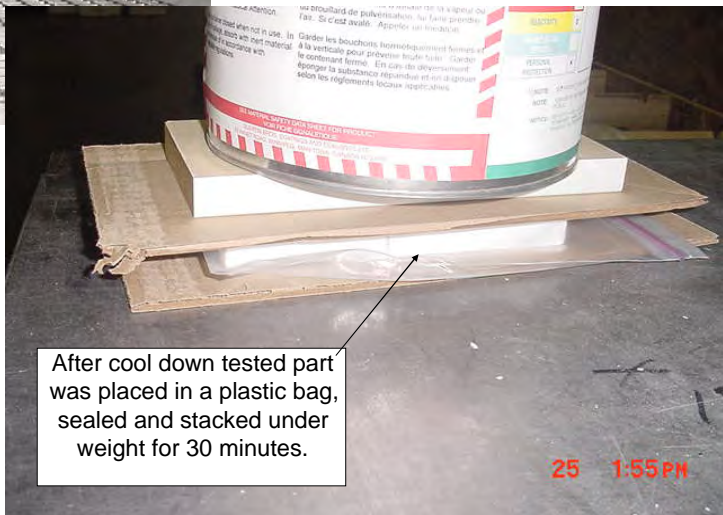
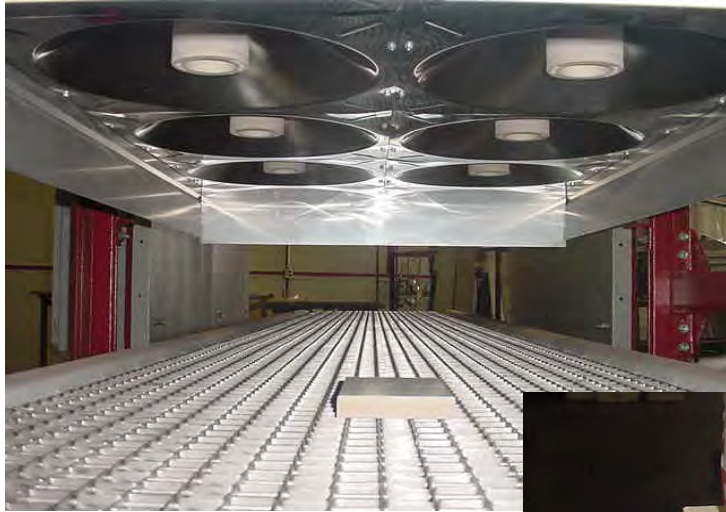




Test for	
Sales Manager	Derek McIntosh
Date	June 18, 2004
Part Description & size	Primed MDF Window Trim Size: 3.5"x 3 7/8x 3/4"
Line speed	N/A
Coating Mfg	Sherwin Williams
Coating Description (Type, Color, ID Number, Catalyst, etc)	Pigmented Catalyzed Lacquer (Sherwood #T77WJ1)
Describe Coating Process (coat, flash, etc)	Spray Coating (3 mils) - Air Flash - IR - Cool Down - Cure Test
Application Equipment Used	Devilbiss Air Spray Gun (.070 tip)
Voltage available	N/A
Gas Pressure Available	N/A
Conveyor Type Used	Flatline
In Attendance	David Cherry CCI Thermal

Test #	Part Descrip.	Coating Descrip.	Flash Time Ambient	Flash Time Heated	Test Oven Style	Oven Opening	Oven Output	IR Duration	Peak Temp.	Cool Down	Cure Test	Results
Test 1	Window Trim	Precat Lacquer	5 mins.	N/A	1500 W Ceramic	12"	60%	3 mins.	182 f.	10 mins. Ambient	Placed in plastic bag and stacked	Pass
Test 2	Window Trim	Precat Lacquer	5 mins.	N/A	1500 W Ceramic	12"	70%	2 mins	184 f.	10 mins. Ambient	Placed in plastic bag and stacked	Pass
Test 3	Window Trim	Precat Lacquer	5 mins.	N/A	1500 W Ceramic	12"	80%	1 mins	187 f.	10 mins. Ambient	Placed in plastic bag and stacked	Slight Marking, Some Blisters

Tests results indicate no less than a 2 minute IR time cycle is needed to dry supplied precat lacquer coating on MDF window trim parts.



After cool down tested part was placed in a plastic bag, sealed and stacked under weight for 30 minutes.