INFRATECH
A U T O M O T I V E

ASSEMBLY INSTRUCTIONS
MEDIUM WAVE
S-2005 | S-2005-IR

REF	PART	DESCRIPTION
1	10-2030	E-3024 3000W 240V 58"
2	10-2055	E-4024 4000W 240V 58"
3	13-1090	LOCK/NUT MAL 1/4-20 X 9/16"
4	13-1200	W HEATER REFLECTOR (S-2005)
5	13-1210	W HEATER END REFLECTOR (S-2005)
	13-1230	W HEATER LEAD WIRE SET (S-2005)
6	13-1240	W HEATER GRILL (S2005)
7	13-1490	SHOCK ARM
8	13-1605	SHOCK STOP ARM
9	13-1614	5" LOCKING CASTER
10	13-1617	240V 50 AMP PLUG
11	13-1520	50' POWER CORD SO 8 GA 3 WIRE

ASSEMBLING YOUR NEW SYSTEM

Unpack Your System: Carefully unpack your new system, making sure all parts for assembly are included. Remove all packing, bubble pack, and cardboard boxes on the bottom of the pallet. If any parts are missing, call customer service for replacement.

Assemble Top Arm: Remove wooden brackets bolted to top of stand to free top arm assembly. The top arm is pre-assembled and wired, ready to insert into the vertical posts of the main stand assembly. The brackets are designed to accept the top arm and hold it in place while you use the same bolts that held the wooden shipping brackets in place to secure the top arm in place. Unbolt the stand from the wooden shipping pallet and remove the system from the pallet.

Assemble Hardware: Open the small cardboard box and remove the casters and hardware. Attach the casters in the four holes provided and secure them using the lock washers and nuts provided.

Prepare Elements: To prevent breakage, unit is shipped without elements installed. To install the elements, open the long cardboard box and remove the quartz tubes. Remove end reflectors and guard from each heater. There is a wire with ring terminal on each end of the heater (under the reflector). Connect the wires to the elements, taking care to get a tight connection. Insert the two

elements marked 4000 watts into the two heaters on the top arm assembly. Insert the three elements marked 3000 watts into the three lower heaters.

Install Elements: Remove end plates. Open element clips at each end of heater and carefully install quartz tube. Remove one nut from end of element. Slip on wire over element screw. Replace nut. NOTE: Hold element ceramic firmly while tightening nut to prevent damage to element. Nut should be tightened snug; loose connection can cause element to fail. Connect other side of element in the same manner. Close element clips over tube. Replace end plates. Clean tube and reflector with alcohol or equivalent. Snap on grill provided.

First Use: Refer to operating instructions before using the Heater.

WARNINGS:
- NEVER block front of heater
- DO NOT operate within 25' of flammable materials
- DANGER: Do not use within 10' when spraying operations are in progress
- NEVER service heater without disconnecting from power
- Source of possible shock
- Use only with grounded power source
- Only use grounded extension cords that are rated for the amp load of these units

ELEMENT REPLACEMENT INSTRUCTIONS

Step 1: Check U/L label on heater for proper voltage.

Step 2: Remove end plates.

Step 3: Open element clips at each end of Heater and carefully install quartz tube. Remove one nut from end of element. Slip on wire over element screw. Replace nut. NOTE: Hold element ceramic firmly while tightening n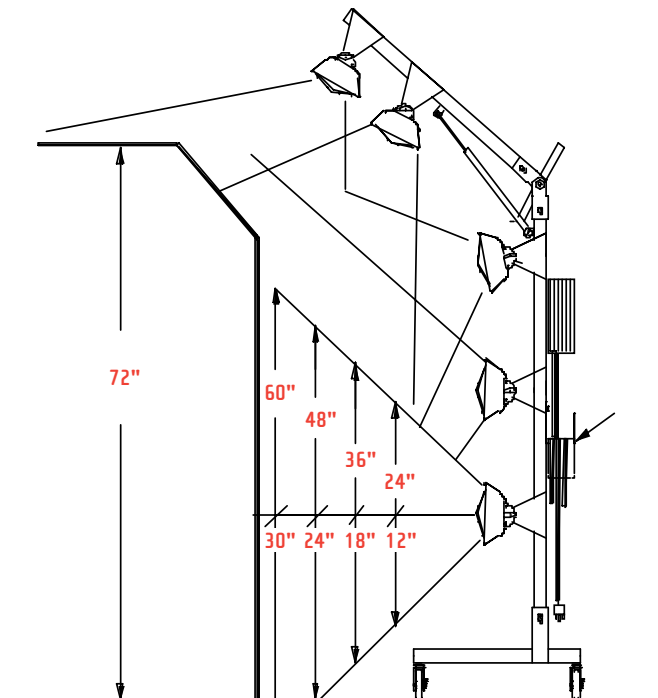ut to prevent damage to element. Nut should be tightened snug, as loose connection could cause element to fail. Connect other side of element in like manner. Close element clips over tube.

Step 4: Replace end plates.

Step 5: Clean tube and reflector with alcohol.

Step 6: Snap on grill provided.

OPERATING TIPS

Your new Infratech infrared (IR) curing system provides fast, efficient curing for virtually every type of paint, primer, body filler, bonding adhesive and plastic repair product. Infratech infrared heats from the inside out, providing the best possible cure. It does not heat the air. IR cures by first heating the coating for the prescribed time to effect solvent evacuating and cross linking; the cure cycle is complete after the heated area cools back to room temperature. Once this full cycle is complete, the coating is fully cured and final assembly or cleanup for delivery can start. Care should be taken when using your new system. Operating the system too close to the part being cured can cause damage. When you first use your system, start at a distance of 24" to 30". As you gain experience using your system, you may be able to move the system closer (18" min. distance) to apply more heat and speed the curing cycle. Infratech heaters are powerful enough to blister paint and melt plastic. Additionally, it should be noted that different colors absorb IR at different rates.

CURING TIME

PAINT TYPE	DISTANCE FROM SURFACE	UPPER HEATED AREA	LOWER HEATED AREA	HEAT SETTING	CURING TIME
Water Based Primer	24"	6' x 4'	6' x 5'	80%	6 minutes
Water Based Primer	36"	7' x 5'	7' x 6'	100%	10 minutes
Solvent Based Primer	24"	6' x 4'	6' x 5'	70%	10 minutes
Solvent Based Primer	36"	7' x 5'	7' x 6'	80%	15 minutes
Lacquer	36"	6' x 4'	6' x 5'	80%	15 minutes
High Solids Clear Topcoat	24"	6' x 4'	6' x 6'	70%	18 minutes
High Solids Clear Topcoat	36"	7' x 5'	7' x 6'	80%	20 minutes
Urethane Clear Coat	36"	6' x 4'	6' x 5'	70%	20 minutes
Polyurethane Clear Coat	36"	6' x 4'	6' x 5'	70%	20 minutes
Acrylic Enamel	36"	6' x 4'	6' x 5'	70%	20 minutes

WORKING WITH INFRARED & PAINT

Every coating system, applicator and shop have many variables (type of material, thickness applied, type of reducer, air temperature, and ambient moisture content) that come into play when applying and curing coating systems. All these variables must taken into consideration when setting curing time settings and power intensity settings. The following is our recommendation to establish the correct setting for you shop:

1. **Mix paint for the current weather conditions in your area as recommended by manufacturer.**
2. **Start with an intensity setting of 75% power (default setting).**
3. **Set cure time according to product being cured (refer to curing time chart).**
4. **If the job is not cured, add more time at the same intensity to complete the job.**
5. **For the next job using the same materials, increase intensity 5% (or 10% max.) and use the same recommended time.**
6. **At the first sign of solvent pop, back the intensity down 5% and use that setting down 5%.**
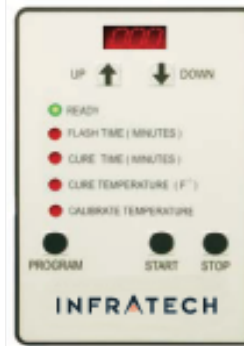
DIGITAL CONTROL SYSTEM SETUP

CONTROL BOX FUNCTIONS
S-2005 2 ZONE CONTROL

CONTROL SYSTEM FACTORY PRESETS:

Flash Time:	**3 Min.**
Cure Time:	**30 Min.**
Intensity:	**75%**

CONTROL BOX FUNCTIONS
S-2005-IR 2 ZONE WITH DIGITAL AUTO-TEMP CONTROL

IR CONTROL SYSTEM/AUTO-TEMP CONTROL FACTORY PRESETS:

Flash Time:	**3 Min.**
Cure Time:	**30 Min.**
Temperature:	**130° F**

Modifying Control Settings

With system plugged in to power and power light on, but prior to starting system, you can change the factory pre-sets.

To Change Flash Time: Press program button until flash time LED flashes, use arrow up or down buttons to increase or decrease time displayed. When light stops flashing, new time is locked into memory.

To Change Cure Time: Press program button until cure time LED flashes then use exact same procedure as described above to adjust cure time.

To Change Intensity Setting: Intensity setting are required for all three zones (heaters). You may operate one, two or all three zones at the same intensity or three different settings as required by specific circumstances. Press program button until first intensity LED flashes; use arrow up or down buttons to increase or decrease percent of power output displayed. Repeat for zones two and three as desired. When light stops flashing, new settings are locked into memory.

Changes During Operation: With system operating you can change any setting by using the above instructions.

Modifying Control Settings

With system plugged in to power and "Ready" light on but prior to starting system you can change the factory pre-sets.

To Change Flash Time: Press program button until flash time LED flashes, use arrow up or down buttons to increase or decrease time displayed. When light stops flashing, new time is locked into memory.

To Change Cure Time: Press program button until cure time LED flashes then use exact same procedure as described above to adjust cure time.

To Change Temperature Setting: Press program button until cure temperature led flashes, use arrow up or down buttons to increase or decrease temp displayed. When light stops flashing, new setting is locked into memory. Changes made prior to starting the system will be locked into memory until you change settings using the above procedures.

Changes During Operation: With system operating, you can change any setting by using the above instructions. However, any changes made when the system is operating will not be held in memory after the current operating cycle.

Change Temperature Calibration: The infrared sensor controller is factory calibrated to +/- 3° F. If you wish to re-calibrate the control, press the program button until the calibrate LED flashes. Use the arrow up/down buttons to change the setting to match your measuring instrument.

SPECIFICATIONS

PART NUMBER	MODEL	LENGTH	WATTS	VOLTS	AMPS	SHIPPING WEIGHT (LBS)
16-1030	S-2005	61"	17,000	240 - 1 PH	37.5	285
16-1040	S-2005-IR	61"	17,000	240 - 1 PH	37.5	285

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