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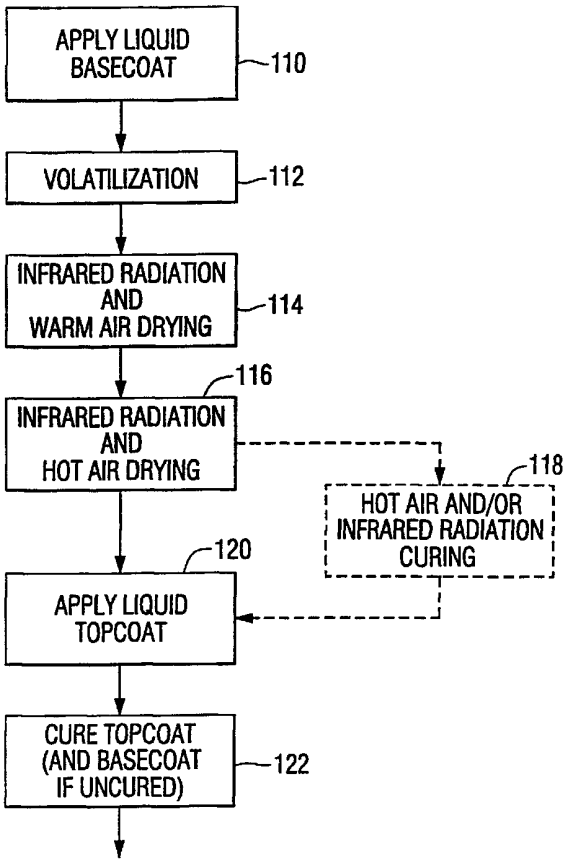
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(54) Title: MULTI-STAGE PROCESSES FOR COATING SUBSTRATES WITH LIQUID BASECOAT AND LIQUID TOPCOAT



(57) Abstract: A process for coating a metal substrate includes: (a) applying a liquid basecoating composition to a surface of the substrate; (b) exposing the basecoating composition to air having a temperature ranging from about 10°C to about 30°C for a period of at least about 30 seconds to volatilize at least a portion of volatile material from the liquid basecoating composition, the velocity of the air at a surface of the basecoating composition being less than about 0.5 meters per second; (c) applying infrared radiation and warm air simultaneously to the basecoating composition for a period of at least about 30 seconds, the velocity of the air at the surface of the basecoating composition being less than about 4 meters per second, the temperature of the substrate being increased at a rate ranging from about 0.02°C per second to about 0.4°C per second to achieve a peak temperature of the substrate ranging from about 20°C to about 60°C; (d) applying infrared radiation and hot air simultaneously to the basecoating composition for a period of at least about 30 seconds, the temperature of the substrate being increased at a rate ranging from about 0.4°C per second to about 1.5°C per second to achieve a peak temperature of the substrate ranging from about 40°C to about 75°C, such that a dried basecoat is formed upon the surface of the substrate; and (e) applying a liquid top coating composition over the dried basecoat. A similar process for coating a polymeric substrate also is provided.

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INTERNATIONAL SEARCH REPORT

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A. CLASSIFICATION OF SUBJECT MATTER
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According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)
IPC 7 B05D F26B

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)
EPO-Internal

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category °	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
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A	US 2 472 293 A (F.J.GROVEN) 7 June 1949 (1949-06-07) the whole document	1
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[X] Further documents are listed in the continuation of box C.

[X] Patent family members are listed in annex.

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Date of the actual completion of the international search	Date of mailing of the international search report
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Name and mailing address of the ISA	Authorized officer
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C.(Continuation) DOCUMENTS CONSIDERED TO BE RELEVANT

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