

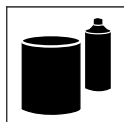


Hot Clear Matte Clear HHC-530™

Description

Hot Clear Matte Clear is a two-component matted clearcoat designed for custom painting to achieve various gloss levels. HHC-5300™ maintains a mix ratio of 4:1 (4 parts HHC-5300™, and 1 part HHA-5305™ Activator) by volume, and has been specifically formulated for custom application. Hot Clear Matte Clear is designed to achieve the required build and appearance in two coats, and is formulated to operate in crossflow and downdraft booth conditions; in addition HHC-5300™ formulation provides a fast cure rate under normal bake (30 min. x 140°F) processing conditions.

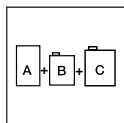
This product is categorized as a "Specialty Coating" in VOC-Regulated Areas under elastomeric coating and anti-glare safety coating designations; HHC-5300™ contains an elastic or flexible component in the product formulation, which eliminates the need to add a Flex-Add additive to the matted clearcoat. Satin, egg-shell and flat gloss levels can be obtained by mixing varying levels of DuPont™ Plas-Stick® 2360S™ Flexible Matting Additive by volume.



General Information

Components

- Hot Clear Matte Clear HHC-5300™
- Hot Activator Standard HHA-8005™



Mix Ratio / Viscosity

Combine the components by volume or weight then mix thoroughly

Weight (cum quart)	Semi-Gloss 50 - 60°		Eggshell 20 - 30°		Flat 0 - 5°	
	Volume	Weight	Volume	Weight	Volume	Weight
Hot Clear Matte Clear HHC-530™	4	732. g	3	550. g	2	366. g
Hot Clear Matte Activator HHA-5305™	1	920. g	1	751. g	2	770. g
DuPont™ Plas-Stick® 2360S™			1	940. g	1	958. g

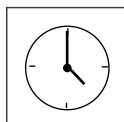
Viscosity

15 - 17 seconds in a Zahn #2 (Du M-222) cup

Note: May use Hot Hues Hot Reducer Fast HHR-706™, Hot Reducer Medium HHR-70™, or Hot Reducer Slow HHR-708™ to reach recommended viscosity (ie 5%)

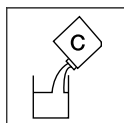
Tips for Success

- Use a mixing stick for accurate measurements
- Perform and spray a test panel to validate the desired gloss level



Pot Life

2 hours at 70°F.



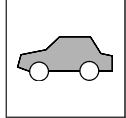
Additives

Please see Mix Ratio section for additive recommendations. All other additives will affect gloss and product performance adversely.



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Hot Clear Matt Clear HHC-530™

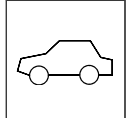


Basecoats

Hot Hue™ Hot Colors Basecoats

Hot Rod Black HHM-64™

Any DuPont Performance Coatings basecoats appropriate for your VOC regulated area



Application

Substrates

Hot Colors Basecoats

Hot Rod Black HHM-64™

Any DuPont Performance Coatings basecoats appropriate for your VOC regulated area



Surface Preparation

For application over a properly prepared basecoat repair

- Mask entire vehicle to prevent overspray from sticking
- Allow basecoat to dry; follow appropriate application recommendations for specific topcoat or basecoat being used
- Tack with appropriate basecoat tackcloth prior to applying clear.



Gun Setup*

Conventional

Siphon Feed: 1.5 mm - 1.7 mm. (0.59" - 0.67")

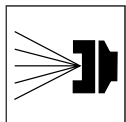
Gravity Feed: 1.4 mm - 1.6 mm. (0.55" - 0.63")

HVLP

Siphon Feed: 1.5 mm - 1.7 mm. (0.59" - 0.67")

Gravity Feed: 1.4 mm - 1.6 mm. (0.55" - 0.63")

*These numbers refer to the actual tip size of the spray gun in millimeters. Some gun manufacturers represent tip sizes in other units.



Air Pressure

Conventional

Siphon Feed: 40 - 45 psi @ the gun

Gravity Feed: 35 - 45 psi @ the gun

HVLP

8 - 10 psi @ the gun.

*The listed setups cover the usual range for various application equipment



Application

Apply 2 medium-wet coats with a 8 - 10 minute flash between coats



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Hot Clear Matt Clear HHC-530™



Flash/Dry Times

Air Dry

Flash between Cuts:	8 - 10 minute
Dust Free:	30 - 45 minute
Time to Handle (Assemble)	3 - 4 hour
Time to Strip	3 - 4 hour
Time to Deliver	3 - 4 hour
Time to Deca	After 24 - 48 hou

Force Dry

Flash before bake	0 minutes
Dry Cycle:	30 minutes @ 140F.
Dust Free:	After cool dwn.
Time to Handle	After cool dwn.
Time to Strip	After cool dwn.
Time to Deliver	After cool dwn.
Time to Deca	After 24 hours

Normal Bake

Infrared Dry

Not recommended Clearcoat may solvent po



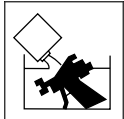
Recoatibility/Re-repair

Hot Clear Matte Clear HHC-530™ may be recoated 4-5 hours @ 70°F airy.dlf theclear is force driedwait 1 hou for cool dwn. If recating after 24 hoursscuff sand with 1200 - 1500 .



Polishing

Not Recommended Compounding and polishing will affect gloss I



Cleanup

Clean spray equipment immediately with DBont LacquerThinner.



UNLEASH THE COLOR™

Hot Clear Matt Clear HHC-530™

Physical Properties

VOC: 4.3 lbs/gal ready-to-spray.
Theoretical Coverage: 557 sq ft per ready-to-spray gallon at 1 mil
Weight Solids 43.2% ready-to-spray.
Volume Solids 34.7% ready-to-spray.
Recommended Dry Film Thickness: 2.0 - 2.4 mils in 24 hrs
Flash Point: See MSDS

VOC Regulated Area

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing and usage recommendations in the VOC Compliant Products Chart for your area.

Safety and Handling

WEAR A POSITIVE-PRESSURE, SUPPLIED-AIR RESPIRATOR (NIOSH APPROVED TC-19C), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING, ACTIVATOR WITH PAINT, DURING APPLICATION AND UNTIL ALL VAPORS AND SPRAY MIST ARE EXHAUSTED. Follow respirator manufacturer's directions for respirator use. INDIVIDUALS WITH HISTORY OF LUNG OR BREATHING PROBLEMS OR PRIOR REACTION TO ISOCYANATES SHOULD NOT USE OR BE EXPOSED TO VAPOR OR SPRAY MIST. Do not permit anyone without protection in the painting area.



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