

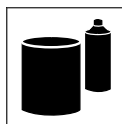


Hot Hue™ Hot Rod Black HHM-64™

Description

Hot Rod Black is a two-component single stage matte topcoat designed for the Custom paint applications which require a semi-gloss matte black topcoat. HHM-6400™ maintains a mix ratio of 2:1 (2 parts HHM-6400™, and 1 part HHA-6405™) by volume, and has been specifically formulated for custom application which may not utilize an electronic weight scale.

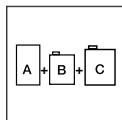
Hot Hues Hot Rod Black HHM-6400™ has been formulated to exhibit excellent satin gloss and color retention; and has been designed to achieve the required build and appearance in two coats, and is formulated to operate in cross-flow and downdraft booth conditions under normal bake (30 min. x 140°F) processing conditions.



General Information

Components

- Hot Rod Black, HHM-6400™
- Hot Rod Black Activator, HHM-6405™



Mix Ratio / Viscosity

Combine the components by volume then mix thoroughly.

Product SKI	Parts /Volume
HHM-6400™	2
HHM-6405™	1

Viscosity

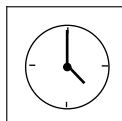
HHM-6400™ can be reduced 5-10% to achieve recommended reduction using the following Hot Hue™ Reducers

Product SKI	Product Description
Hot Reducer Slow	HHR-7085™
Hot Reducer Medium	HHR-7075™
Hot Reducer Fast	HHR-7065™

15-16 Second Zahn (Dont M-222) 4 mm / 70

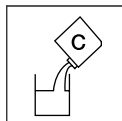
Tips for Success

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



Pot Life

6 hours at 68°F.



Additives

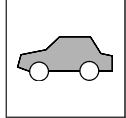
Please see "Mix Ratio" section for additive recommendations. All other non-recommended additives (i.e. accelerators) will affect gloss and product performance adversely.

*Hot Hues reducers can be used to reach the recommended material viscosity:



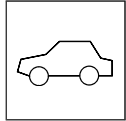
UNLEASH THE COLOR™

Hot Hues Hot Rod Black HHM-6™



Topcoats

Compatible with Hot Hues™ Hot Color Basecoats, and DuPont Performance Coatings topcoats appropriate for your VOC regulated area.



Application

Substrates

Compatible with Hot Hues undercoats and DuPont Performance Coatings undercoats appropriate for your VOC regulated area



Surface Preparation

- Prepare surface to be refinished using the recommended undercoating system and procedure
- Finish sand with P400 or finer (dry or wet)
- Tack with the appropriate tackcloth prior to applying topcoat.



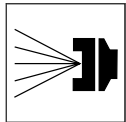
Gun Setup*

Conventional

Siphon Feed: 1.3 mm - 1.4 mm
 Gravity Feed: 2 = 2.0 mm - 2.4 mm (50-60 mic)

HVLP

Siphon Feed: 1.5 mm - 1.7 mm
 Gravity Feed: 2 = 2.0 mm - 2.4 mm (50-60 mic)



Air Pressure*

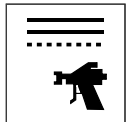
Conventional

Siphon Feed: 60 psi (4 bar)

HVLP

60 psi @ the gun

Please refer to gun manufacturer and local VOC legislation for proper spray pressure recommendations



Application

Apply 2 medium-wet coats with a 5-10 minute flash between coats (68°F); HHM6™ should be hand slick prior next coat



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Hot Hues Hot Rod Black HHM-6™



Flash/Dry Times

Force Dry

Flash between Cuts: 5-10 minutes at 68°F. Flash off hand slick between cuts

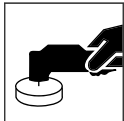
Air Dry

Air dry overnight at 68°F or 25 minutes at 140°F Panel temperature

Infrared Dry

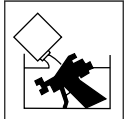
Short wave: 8-12 minutes

Medium wave: 12-14 minutes



Polishing

Not Recommended Any polishing or compounding will affect the gloss.



Cleanup

Clean spray equipment immediately with Dönat Lacquer Thinner.

Physical Properties:

VOC Content 4.1 lbs/g

Theoretical Coverage: 78.6 sq ft at 2.0 mil (50 micron) dry film thickness

Weight Solids 63.6% ready-to-spray

Volume Solids 44.2% ready-to-spray

Flashpoint: 24°C

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 properly fitted vapor/particulate respirator approved by NIOSH (TC-23C) for use with paints during application and until all vapors and spray mists are exhausted. Observe OSHA regulations for respirator use 29 CFR 1910.134. In all cases please read manufacturer's instructions carefully to determine the type of airborne contaminants against which the respirator is effective. **Ventilation:** Provide sufficient mechanical (general or local exhaust) ventilation to keep TLV and LEL below stated limits. **Protective Gloves:** Impervious gloves required for prolonged or repeated contact. **Eye Protection:** Use safety eyewear designed to protect against splash of liquid. **Other Protective Equipment:** Wear impervious clothing. Clothing must cover all exposed skin when spraying in enclosed area. **Hygienic Practice:** Eye washes and safety showers in the workplace is recommended. Wash hands thoroughly before eating or smoking.



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