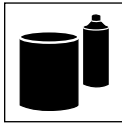




HHM-6399™ Hot Efx™ Crystallized™

Description

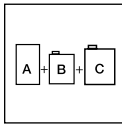
HHM-6399™ Hot Efx™ Crystallized™ is a liquid mask, designed to be the perfect enhancement to any custom project. When applied over a cured, painted and sanded surface, HHM-6399™ Hot Efx™ Crystallized™ forms into a beautifully complex crystallized mask. Then apply a second coat of paint, let it dry, and wash it away. You can mix and match any Hot Hues colors, so the combinations are virtually limitless. Apply a clear coat and you'll have an individually customized paint job.



General Information

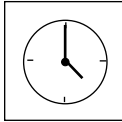
Components

HHM-6399™ Hot Efx™ Crystallized™



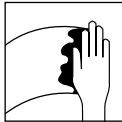
Mix Ratio / Viscosity

HHM-6399™ Hot Efx™ Crystallized™ is ready to spray



Pot Life

No pot life limitations.



Application

HHM-6399™ Hot Efx™ Crystallized™ is used in combination with a cured base coat / clear coat paint surface, and a suitable contrasting second color. The use of the cured and sanded surface, HHM-6399™, and a contrasting color, combine to form an intricate crystallized mask.

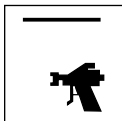


Surface Preparation

- Start with an OEM finish or a refinish basecoat / clearcoat finish that is cured. (24 hours, no quick-dry clears.)
- Wash surface with DuPont™ Kwik Clean 3949S™. DO NOT USE any solvent based cleaning solutions. Wash thoroughly.
- Dry sand the clear with 320 grit sandpaper until surface is thoroughly sanded. Be sure to sand all edges of panel thoroughly. Note that the scratched surface ultimately holds the HHM-6399™ product while the crystals form.
- Re-wash surface thoroughly with DuPont™ Kwik Clean 3949S™, because any contaminants will disrupt the product. Surface must be clean and dry.

Tips for Success

Put tap water on your surface. If tap water beads-up, so will HHM-6399™ Hot Efx™ Crystallized™. If it beads, you have surface contamination or insufficient sanding. A slight bubbling as product begins to dry is normal.



Application

HHM-6399™ Hot Efx™ Crystallized™ is ready to spray.



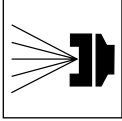
Gun Setups

Fluid Tips: 1.2 – 1.4 mm



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Air Pressure

Range:	Conventional	25 - 40 psi
	HVLP	15 - 20 psi

Spray 1 wet coat. If you plan to do the entire vehicle make sure you do it all at the same time. (You may not get the same pattern if you do your paint job in segments).

Tips for Success

Before product is applied and after cleaning your gun, you can easily add humidity to your environment by spraying water from your paint gun (like a giant humidifier). Make sure not to re-wet the surface of your project.



Flash/Dry Times

30 to 120 minutes before applying contrast color as a general guideline.

Dry time varies with temperature and humidity. As a rule, the longer it takes for the product to dry, the larger the crystal patterns produced. Wait for complete forming of crystals in all areas of sprayed surface. If it is not what you desire, wash off the HHM-6399™ Hot Efx™ Crystallized™ with water and a sponge and reapply.

Entire surface is dry when no visible moisture is seen and has a dull appearance, especially edges and depressions.

For a larger crystal pattern:

- Slower drying time
- Higher humidity
- Apply 1 wet coat. Once completely dry, apply a second wet coat.

For a smaller crystal pattern:

- Faster drying time
- Lower humidity
- Two light applications of HHM-6399™ Hot Efx™ Crystallized™. Wait until 1st coat is thoroughly dry before applying 2nd application. This will re-wet the first one, and when it dries this second time, you will have small crystals.

Contrast Color Application:

Contrast color may be comprised of Hot Hues™ Hot Colors Basecoats, Hot Candy Colors, Powder Additives, or just about any "effect" that can be carried in HH-6200™ Binder and HH-6300™ Balancer. Follow mixing directions specific for the contrast color selected.

For application, spray a light coat of contrasting color by turning up the pressure on the paint gun to atomize the paint. By turning up the pressure, it will give you a light "misting" of color, preventing the top color from becoming shell.

Tips for Success

For your end result, a bottom candy or metallic color should be visible through the top coat. Dark top colors work best over a Candy bottom color. Light colored top coats work best over dark colored bottom coats. Avoid heavy build up of paint along edges using a blending action.

Remove the HHM-6399™ Hot Efx™ Crystallized™ Mask

Let the contrasting color dry to the touch. This coat of paint must be dry enough that it adheres well to the bottom color beneath. If your top coat is not dry enough, then it will be "torn" away.

With a wet smooth sponge and water, wipe off all the crystals. If the product is not washing off, then use a very mild scuff pad and gentle strokes to remove crystals and accompanying contrasting color.

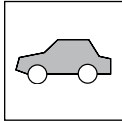
Note: If you do not like the pattern you have created, remove the top color using reducer, then soap and water.



HHM-6399™ Hot Efx™ Crystallized™

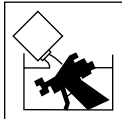
Mult-Toning / Graphics

If artwork is planned and tape outs are needed, use graphic mask or vinyl tape. DO NOT use masking tape.



Clearcoating

Apply topcoat clear according to the application guide for the clear coat selected.



Clean Up

Clean up all equipment that has been used to spray catalyzed products using DuPont lacquer thinner or Gun and Equipment Cleaner. For HHM-6399™, cleanup with water after the application is complete. After cleaning, always purge spray equipment with water when changing from solvent based to water based material, and purge with solvent when changing from water to solvent based applications.

Additional Product Usage Information

- HHM-6399™ Hot Efx™ Crystallized™ is not a color.
- HHM-6399™ Hot Efx™ Crystallized™ is a mask that is used in between two layers. When you are looking at the finished product, the lines are the bottom base coat color. The triangular shapes are the top color.
- The crystals simulate using tape to cover an area you do not want to paint. When you pull up the tape you see the area below. When you wash away the HHM-6399™ Hot Efx™ Crystallized™ you see the area below.
- HHM-6399™ Hot Efx™ Crystallized™ must be used with solvent-based paints.
- A clear coat must be applied for durability and UV protection.

- Do**
- Use a test panel before trying with the final project.
 - Clean the surface thoroughly before applying HHM-6399™ Hot Efx™ Crystallized™.
 - Check your humidity. When HHM-6399™ Hot Efx™ Crystallized™ is crystallizing, the room needs to be well humidified for larger patterns.
 - Thoroughly clean your gun before filling with HHM-6399™ Hot Efx™ Crystallized™
 - Select an appropriate ground color and contrast color combination.
 - When doing graphics where taping is required, use vinyl tape.

- Don't**
- Do not dilute product.
 - Do not force dry.
 - Do not leave the crystallized project overnight without spraying the top color.
 - Do not apply a heavy 2nd coat of color. A light misting is needed. Thick application will create a shell that will not wash off, destroying the effect.

Application Tips

- HHM-6399™ Hot Efx™ Crystallized™ needs a sanded surface to adhere to. We recommend a catalyzed urethane that has cured for 24 hours. Remember to sand edges and depressions.
- You can apply HHM-6399™ Hot Efx™ Crystallized™ over an OEM paint job. Dry sand it, clean it, and apply product. Once it dries, you can then apply the top color.
- A slight bubbling as product begins to dry is normal. Beading indicates contamination.
- When you apply a dark color over a light bottom color, the bottom color may become a darker shade.



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- If you do not like the crystal pattern after HHM-6399™ has dried, simply wash off with soap and water. Let area dry thoroughly then repeat product application again.
- If you have applied HHM-6399™ more than once to the same surface, it is recommended to re-sand before applying additional applications of HHM-6399™ Hot Efx™ Crystallized™.

Drying and Crystal Size Factors

- The crystals are finished drying when they become hard and have no appearance of moisture. After you have worked with this product a few times, you will be able to tell at this point whether or not you will get the pattern you desire.
- HHM-6399™ is a reverse mask, so the pattern of crystals will expose your bottom color.
- If your project is taking a long time to dry, use fans in the booth to get the air moving. Do not face directly on the project.
- Record shop temperature and humidity when apply HHM-6399™ Hot Efx™ Crystallized™. Use this as a guide to get larger or smaller crystal patterns on future projects.
- The pattern or size of the fissures can be modified by humidity and dry time. To get a smaller/closer pattern, lower humidity to speed dry time. For wider patterns, you want more humidity. To get more humidity, clean the spray gun, put some water in it and spray the air.
- A shorter dry time means smaller pattern. Longer dry time provides larger patterns.

Frequently Asked Questions

Q: Can I sand down the area where I did the HHM-6399™ Hot Efx™ Crystallized™ to avoid feeling or being able to see the line that would form on both side of this line.

A: You can sand the area to take down the tape line, but it would be better if you put down a coat of a HHM-6222™ Intercoat Adhesion Promoter. This will protect the HHM-6399™ Hot Efx™ Crystallized™ and allow you to feather the edges without damaging the art.

Q: Will HHM-6399™ Hot Efx™ Crystallized™ work on a finish that has a lot of medium to large metallic flakes?

A: HHM-6399™ will work on any surface, even large flakes, as long as it has been properly cleared and sanded.

Ideas To Try

- Use stencil to produce patterns on top of the crystal patterns.
- Spray several different layers of crystal patterns, one on top of another.
- Over a graphic, apply HHM-6399™ Hot Efx™ Crystallized™ then use a straight pearl over the mask. This will allow the bottom graphic to show through the crystal pattern.

VOC Regulated Areas

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

Before using any DuPont Refinish product, be sure to read all safety directions and warnings. 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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