



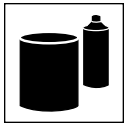
UNLEASH THE COLOR™

Hot Hues™ Hot Rod Black HHM-6400™

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 3:1 (3 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.

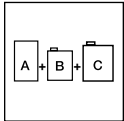
Hot Hues Hot Rod Black HHM-6400™ has been formulated to exhibit excellent satin gloss and color retention; and has been designed to achieve the required build and appearance in two coats, and is formulated to operate in cross-flow and downdraft booth conditions under normal bake (30 min. x 140°F) processing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



General Information

Components

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



Mix Ratio / Viscosity

Combine the components by volume, then mix thoroughly.

Product SKU	Parts / Volume
HHM-6400™	3
HHA-6405™	1

Viscosity

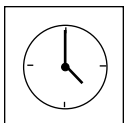
HHM-6400™ can be reduced 5-10% to achieve recommended reduction using the following Hot Hues™ Reducers.

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

15-16 Second Zahn (DuPont M-222) 4 mm / 70°F

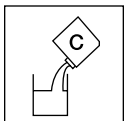
Tips for Success

- 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

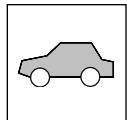
Please see "Mix Ratio" section for additive recommendations. All other non-recommended additives (i.e. accelerators) will affect gloss and product performance adversely.

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



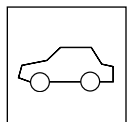
UNLEASH THE COLOR™

Hot Hues Hot Rod Black HHM-6400™



Topcoats

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



Application

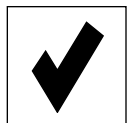
Substrates

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 undercoat system and procedures.
- Finish sand with P400 or finer (dry or wet).
- Tack with the appropriate tack cloth prior to applying topcoat.



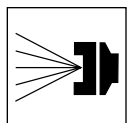
Gun Setups*

Conventional

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

HVLP

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

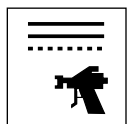


Air Pressure*

Conventional

Siphon Feed: 60 psi (4 bars)
HVLP 60 psi @ the gun cap.

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



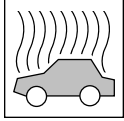
Application

Apply 2 medium-wet coats with a 5-10 minute flash between coats (68°F); HHM-6400™ should be hand slick prior to next coat.



UNLEASH THE COLOR™

Hot Hues Hot Rod Black HHM-6400™



Flash/Dry Times

Force Dry

Flash between Coats: 5-10 minutes at 68°F. Flash off hand slick between coats

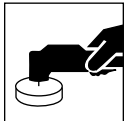
Air Dry

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

Infrared Dry

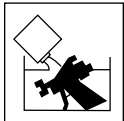
Short wave: 8-12 minutes

Medium wave: 12-14 minutes



Polishing

Not Recommended. Any polishing or compounding will affect the gloss level.



Cleanup

Clean spray equipment immediately with DuPont Lacquer Thinner.

Physical Properties

VOC Content: 4.1 lbs/gal

Theoretical Coverage: 78.6 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° F

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

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 liquids. **Other Protective Equipment:** Wear impervious clothing. Clothing must cover all exposed skin when spraying in an enclosed area. **Hygienic Practices:** Eye washes and safety showers in the workplace is recommended. Wash hands thoroughly and before eating or smoking.



The miracles of science™