Hot Hues
HHM-6400™ Hot Rod Black

GENERAL

DESCRIPTION
A two-component, single stage, matte topcoat designed for custom paint applications that require a semi-gloss matte black topcoat. Hot Hues HHM-6400™ Hot Rod Black is formulated to exhibit excellent satin gloss and color retention, and is designed to achieve the required build and appearance in two coats. It is ideal for cross-flow and downdraft booth conditions under normal bake (30 minutes at 140°F) processing conditions.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS
Hot Hues HHM-6400™ Hot Rod Black
Hot Hues HHA-6405™ Hot Rod Black Activator

MIX RATIO
Combine the components by volume, then mix thoroughly.

Code	Volume
HHM-6400™	3
HHA-6405™	1

HHM-6400™ can be reduced 5-10% to achieve recommended reduction using ChromaPremier® 12365S™ / 12375S™ / 12385S™ / 12395S™ Reducers.

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

VISCOSITY
15-16 Second in a Zahn 4 mm

POT LIFE
6 hours at 68°F

ADDITIVES
Refer to Mix Ration section for recommended additive. All other non-recommended additives (i.e. accelerators) will affect gloss and product performance adversely.

TOPCOATS
Compatible with Hot Hues Basecoat and Axalta topcoats.

APPLICATION

SUBSTRATES
Compatible with Axalta undercoats

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 at the gun cap.

APPLICATION
Apply 2 medium-wet coats. Flash 5-10 minutes between coats. HHM-6400™ should be hand slick prior to next coat.

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

CLEANUP
Clean spray equipment immediately with a lacquer thinner.

DRY TIMES

AIR DRY
Air dry overnight at 68°F

FORCE DRY
25 minutes at 140°F panel temperature

INFRARED DRY

Short wave:	8-12 minutes
Medium wave:	12-14 minutes

PHYSICAL PROPERTIES

All Values Ready To Spray

	3:1	3:1:10%
Max. VOC (LE):	513 g/L (4.3 lbs./gal)	547 g/L (4.6 lbs./gal)
Max. VOC (AP):	513 g/L (4.3 lbs./gal)	547 g/L (4.6 lbs./gal)
Avg. Gal. Weight:	1212 g/L (10.11 lbs./gal)	1159 g/L (9.67 lbs./gal)
Avg. Weight % Volatiles:	42.3%	47.1%
Avg. Weight % Water:	0.0%	0.0%
Avg. Weight % Exempt Solvent:	0.0%	0.0%
Avg. Volume % Water:	0.0%	0.0%
Avg. Volume % Exempt Solvent:	0.0%	0.0%

Flashpoint: See MSDS/SDS

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 usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In Canada:
1.800.668.6945
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