



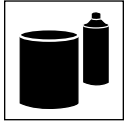
UNLEASH THE COLOR™

Hot Clear Urethane Baking Clear HHC-5100™

2K Overall Urethane Baking Clear

Description

Hot Clear Urethane Baking Clear HHC-5100™ is a 2K high-solid, three-component urethane clear designed for overall repairs in a baking environment. This premium-quality clearcoat has been formulated for a two-coat application. It delivers superior appearance for those custom finishes shops looking for the ultimate show quality shine and depth.



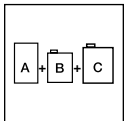
General Information

Components

- Hot Clear Urethane Baking Clear HHC-5100™
- Hot Activator Fast HHA-8003™
- Hot Activator Standard HHA-8005™
- Hot Reducer Fast HHR-7065™
- Hot Reducer Medium HHR-7075™
- Hot Reducer Slow HHR-7085™

Usage Recommendations for HHC-5100™

	65° F	75° F	85° F	95° F or above
Multi-Panel	HHR-7065™	HHR-7075™	HHR-7085™	HHR-7085™
Overall	HHR-7065™	HHR-7085™	HHR-7085™	Not Recommended



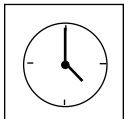
Mix Ratio / Viscosity

Combine the components by volume or weight, then mix thoroughly.

	Volume	Weight (cumulative qt.)
HHC-5100™	2	564 grams
HHA-8003™ / HHA-8005™ Activator	1	856 grams
HHR-7075™ Reducer	10%	929 grams

Viscosity

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



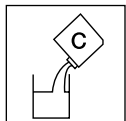
Pot Life

90 Minutes at 70° F (21° C)



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Additives

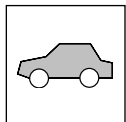
Accelerator: DuPont™ MasterTint® 389S™ Fast Dry Accelerator: add up to 1 oz per ready-to-spray quart when activating with Hot Activator Standard HHA-8005™.
Do not add MasterTint® 389S™ Fast Dry Accelerator when activating with Hot Activator Fast HHA-8003™.

Fish Eye Eliminator: DuPont 659S™ Additive ([silicone free] use 0.5 to 1.5 oz per ready-to-spray quart), or DuPont 459S™ Anti-Cratering Additive (use 0.25 to 0.5 oz per ready-to-spray quart).

Retarder: Not required.

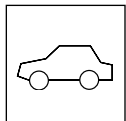
Flex Additive: Only needed if optimum performance is required.
 Add 2 oz. Plas-Stick® 2350S™ Flexible Additive per ready-to-spray quart of activated clearcoat or use Plas-Stick® 2350S™ as described below.

	Volume	Weight (cumulative qt)
Hot Clear HHC-5100™	6	266
Hot Activator standard HHA-8005™	3	403
Plas-Stick® 2350S™ Flex Additive	0.5	430
Hot Reducer medium HHR-7075™	10%	464



Basecoats

Hot Hues™ Hot Colors Basecoats



Application

Substrates

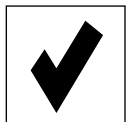
Hot Colors Basecoats
Hot Intercoat Adhesion Promoter HHM-6222™



Surface Preparation

For application over a properly prepared basecoat:

- Mask the entire vehicle to protect from overspray.
- Allow basecoat to dry 15 - 30 minutes prior to clearcoat application.
- Extend basecoat flash to 30 minutes when applying several base color coats, tri-coat colors, or in cooler shop conditions.



Gun Setups*

Conventional

Siphon Feed: 1.3 mm - 1.4 mm* (.051" - .055")
 Gravity Feed: 1.3 mm - 1.4 mm* (.051" - .055")

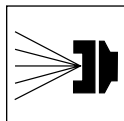
HVLP

Siphon Feed: 1.3 mm - 1.4 mm* (.051" - .055")
 Gravity Feed: 1.3 mm - 1.4 mm* (.051" - .055")

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



Hot Clear Urethane Baking Clear HHC-5100™



Air Pressure*

Conventional

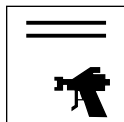
Siphon Feed: 50 - 55 psi @ the gun.

Gravity Feed: 45 - 55 psi @ the gun.

HVLP7 - 10 psi @ the gun cap.

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

*Note: If using "reduced pressure" in gun, make sure air pressure is sufficient to fully atomize the clearcoat.



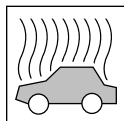
Application

This clear is designed as a two coat clear.

- Apply 2 medium-wet coats with a 7-10 minute flash between coats.
- Applying 3 coats of clear is not recommended and may cause dieback.
- For 4 coats: after 2 coats, bake for 30 minutes at 140°F and allow to sit for 24 hours. Sand with 1000 grit and apply two additional coats with 12-15 minute flash between coats.

Tips for Success

- **HHC-5001™ is a high-solid clear coat and designed for a maximum application of two coats.**
- Be sure to select the correct temperature activator and reducer depending on the shop climate conditions.
- Do not ignore the required flash time recommendations; this is critical in overlap areas where there is a tendency to have excessive film builds.
- Proper tip size and air pressure is important for consistent film build and performance.
- Flash times must be increased between coats to no less than 15-20 minutes for air dry situations. The air flow in the booth must be left on for at least one hour following the application of the clear to avoid dieback.
- Follow proper bake recommendations depending on the choice of activator. Bake recommendations are a guide and need to be adjusted for non-recirculating and recirculating booths.



Flash/Dry Times

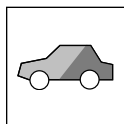
Force Dry

	HHA-8005™	HHA-8003™
Flash between Coats:	12 - 15 minutes.	12 - 15 minutes.
Flash before Force Dry:	None.	None.
Cycle Time:	30 minutes @ 140° F. (a)	15 minutes @ 160° F.
Dust Free:	At cool down.	At cool down.
Dry to Touch:	At cool down.	At cool down.
Time to Handle (Assemble):	4 hours after cool down.	1.5 hours after cool down.
Time to Polish:	4 hours after cool down.	1.5 hours after cool down.
Time to Stripe:	4 - 6 hours after cool down.	3 hours after cool down.
Time to Deliver:	4 - 6 hours after cool down.	3 hours after cool down.
Time to Decal:	After 48 hours.	After 24 hours.

(a) The bake cycle time can be reduced if MasterTint® 389S™ is added. See p. 2 "Additives" section for details.

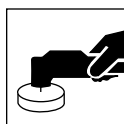
Air Dry

	HHA-8005™	HHA-8003™
Flash between Coats:	12 - 15 minutes.	12 - 15 minutes
Dust Free:	Not recommended.	30 - 35 minutes.
Time to Handle (Assemble):	Not recommended.	6 hours.
Time to Polish:	Not recommended.	6 hours.
Time to Stripe:	Not recommended.	Overnight.
Time to Deliver:	Not recommended.	Overnight.
Time to Decal:	Not recommended.	After 24 - 48 hours.



Recoatability/Re-repair

A minimum of 24 hours must be given prior to the application of additional coats of Hot Clear Urethane Baking Clear HHC-5001™.



Polishing

Optimum Times

Force Dry: 2 - 48 hours after cool down.



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Hot Clear Urethane Baking Clear HHC-5100™

Sanding, Compounding, Polishing

The optimum technique for removing dirt is as follows:

1. Sanding

- Use 1500 grit wet or finer or use a foam interface pad with P1500 DA or finer.

2. Compounding

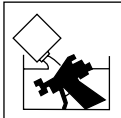
- Apply a thin ribbon of rubbing compound to the area that was sanded or contains sandscratches.
- Maintain air polisher or variable speed buffer at 1400 - 1800 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.
- Use a wool pad and an effective rubbing compound (e. g. , 3M Perfect-it II).
- *Less favorable: Foam pad and 3M Extra Cut Perfect-it III rubbing compound. A foam pad will not remove sandscratches as easily.*

3. Polishing

- Apply a ribbon of polishing material to the area to be polished.
- Maintain a variable speed buffer or an orbital polisher at 1400 - 1800 rpm.
- Use a foam pad and an effective polishing compound. Keep the polisher/buffer moving at all times. Overlap each pass approximately 50%. As finishing polish begins to dry, stop polishing.
- Wipe off excess finishing polish with a clean soft cloth.
- Hand buff with a clean soft cloth as a finishing touch.

Tips for Success

- *Always use clean water to wet sand and add a few drops of soap to help clear the paper.*
- *Always use a foam interface pad when DA sanding.*
- *Use clean cloths and pads to insure that the clear does not get scratched with dirt particles from old or re-used cloths or pads.*
- *Do not wax for the first 120 days after painting.*



Cleanup

Clean spray equipment immediately with lacquer thinner.

Physical Properties

VOC: 3.6 lbs/gal ready-to-spray.

Theoretical Coverage: 735 sq. ft. per ready-to-spray gallon at 1 mil.

Weight Solids: 53% ready-to-spray.

Volume Solids: 46% ready-to-spray.

Recommended Dry Film Thickness: 2.0 - 2.4 mils in 2 coats.

Flash Point: See MSDS.

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 Hot Hues™ product, be sure to read all safety directions and warnings. WEAR A POSITIVE-PRESSURE, SUPPLIED AIR RESPIRATOR (NIOSH TC-19C), EYE PROTECTION, GLOVES AND PROTECTIVE CLOTHING WHILE MIXING ACTIVATOR WITH PAINT, DURING APPLICATION AND UNTIL ALL VAPORS AND SPRAY MISTS 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 BE EXPOSED TO THIS PRODUCT. Do not permit anyone without protection in the painting area. This product is intended for industrial use only by professional, trained painters.



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