



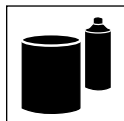
UNLEASH THE COLOR™

# Hot Clear High Speed Clear HHC-5400™

*Ultra-Productive HS Urethane Clear*

## Description

Hot Clear High Speed Clear is a 2.1 VOC high solids clear, which offers air dry/low bake characteristics and low overspray and a fast tack free cycle. It's a two-component spot and panel clear designed to increase production by maximizing energy savings and vehicle throughput. Specially designed to provide outstanding cure rates under air dry (1.5 to 2 hours @ 70°F) and express dry (10 min. x 120°F) processing conditions. It is perfect for covering graphics, murals, touch-ups or smaller projects.



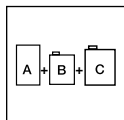
## General Information

### Components

Hot Clear High Speed Clear HHC-5400™  
Hot Clear Standard Activator HHA-5405™  
Hot Clear Slow Activator HHA-5407™

**\*See page 2 (Surface Preparation) for approximate overspray distance.**

	70° F	80° F	90° F
Spot Repair	HHA-5405™	HHA-5405™	HHA-5407™
Panel Repair	HHA-5405™	HHA-5407™	HHA-5407™



### Mix Ratio Viscosity

Combine the components by either volume or weight and then mix thoroughly.

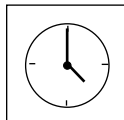
	Volume	Weight (cumulative qt.)
HHC-5400™	4	808 grams
HHA-5405™ / HHA-5407™	1	1024 grams (sprayable qt.)

### Viscosity

15 - 16 seconds in a Zahn #2 (DuPont M-222) cup.

### Tips for Success

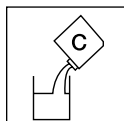
Use a mixing stick for accurate measurements.



### Pot Life

2 Hours at 70° F (21° C).

*Note: When using DuPont V-3895™, pot life is reduced to 1 hour at 70°F.*



### Additives

Accelerator Enhancer: For enhanced application at elevated temperatures (>94°F), use 1/2 ounce of 2350S™ per ready-to-spray quart of activated clearcoat.

Accelerator: DuPont V-389S™; use 1/4 – 1/2 ounce per ready-to-spray quart.

Fish Eye Eliminator: DuPont V-459S™; use 1/4 – 1/2 ounce per ready-to-spray quart.

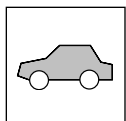


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# Hot Clear High Speed Clear HHC-5400™

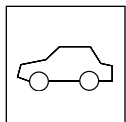
Flex Additive: Add 2 ounces Plas-Stick® 2350S™ per ready-to-spray quart or it can be mixed by weight as described below.

Clear	Volume	Weight (cumulative qt)
Hot Clear HHU-5400™	4	783 grams
Hot Activator HHA-5405™	1	1003 grams
Plas-Stick® 2350S™	2 ounces / RTS quart	1030 grams



## Basecoats

Hot Hues™ Hot Colors Basecoats



## Substrates

Hot Colors Basecoats

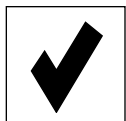
Hot Intercoat Adhesion Promoter HHM-6222™



## Surface Preparation

For application over a properly prepared basecoat:

- Use 36" masking paper to prevent overspray from sticking when using Hot Clear Standard Activator HHA-5405™. If Hot Clear Slow Activator HHA-5407™ is used at 70°F, the overspray is in the range 37-45". At 90°F, however, Hot Clear Slow Activator HHA-5407™ exhibits about 36" overspray. **Caution: If spraying in a cross-flow booth, the overspray will be larger.**
- Allow basecoat to dry 15 - 30 minutes.
- Tack with appropriate basecoat tack cloth prior to applying clear.



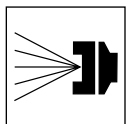
## Gun Setups\*

HVLP

Siphon Feed: 1.7 mm - 1.9 mm (.067" - .075")

Gravity Feed: 1.4 mm - 1.6 mm (.055" - .063")

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

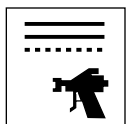


## Air Pressure\*

HVLP

6 - 8 psi @ the gun cap.

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

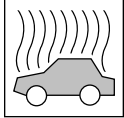


## Application

Apply 2 medium-wet coats with a 3 - 5 minute flash between coats.



## Hot Clear High Speed Clear HHC-5400™



### Flash/Dry Times

#### Air Dry

Flash between Coats:	3 - 5 minutes
Dust Free:	8 - 10 minutes
Time to Handle (Assemble):	1.5 to 2 hours
Time to Polish:	1.5 to 2 hours*
Time to Stripe:	1.5 to 2 hours
Time to Deliver:	1.5 to 2 hours
Time to Decal:	After 24 hours

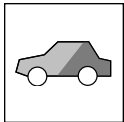
\*Although the clearcoat may fingerprint slightly at 1.5 to 2 hours, it will polish very well.

#### Express Dry

Flash before Express Dry:	0 minutes
Dry Cycle	10 minutes @ 120°F
Dust Free:	After cool down
Time to Handle :	40 minutes
Time to Polish:	40 minutes
Time to Stripe:	40 minutes
Time to Deliver:	40 minutes
Time to Decal:	After 24 hours

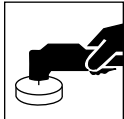
#### Infrared Dry

Not recommended. Clearcoat may solvent pop.



### Recoatability/Re-repair

Hot Clear High Speed Clear HHC-5400™ clearcoat may be recoated 2 hours @ 90°F or 4 hours @ 70°F air dry. If the clear is force dried, wait 1 hour. If recoating after 24 hours, scuff sand with 1200 - 1500 grit.



### Polishing

#### Optimum Times

Air Dry:	1.5 - 72 hours.
Express Dry:	40 minutes to 72 hours.

#### Sanding

Use 1500 grit or finer. Or use P1500 DA or finer.

#### Compounding

Use finishing compound. Apply a thin ribbon of material to the area to be polished. Use a double-sided wool polishing pad. Maintain air polisher or variable speed buffer at 1800 - 3000 rpm. Remove excess finishing compound with a clean soft cloth prior to applying finishing polish.

#### Polishing

Use finishing polish (shake well before using). Apply a ribbon of material to work a 2 - 3 foot square area. Use a foam pad or a terry cloth cover. Maintain a variable speed buffer or an orbital polisher at 1200 - 1800 rpm. 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.

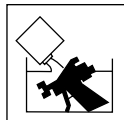
#### Tips for Success

- 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.
- Do not use medium to heavy-duty compounds. 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.



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### Cleanup

Clean spray equipment immediately with Lacquer Thinner.

### Physical Properties

VOC: 2.1 lbs/gal ready-to-spray.

Theoretical Coverage: 572 sq. ft. per ready-to-spray gallon at 1 mil.

Weight Solids: 37.5% ready-to-spray.

Volume Solids: 35.6% 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 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. This product is intended for industrial use only by professional, trained painters.



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