

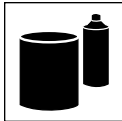


UNLEASH THE COLOR™

# Hot Prime 2K Urethane Primer HHU-3040™

## Description

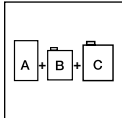
Hot Prime 2K Urethane Primer HHU-3040™ is a three-component, high-build, easy-to-sand primer that is ideal for any top-notch project, whether it is large, small or complete. This easy-to-use primer integrates with Hot Activator Standard HHA-8005™/Fast HHA-8003™ to provide excellent fill and holdout in a wide range of application conditions. Use Hot Seal 2K Sealers HHU-4110™/HHU-4140™/HHU-4170™ to complete premium projects.



## General Information

### Components

- Hot Prime 2K Urethane Primer HHU-3040™
- 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™



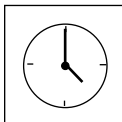
### Mix Ratio / Viscosity

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

	Gram Weight (cumulative qt.)			
	Vol	HHR-7065™	HHR-7075™	HHR-7085™
HHU-3040™	5	1060	1060	1060
HHA-8005™	1	1203	1203	1203
Hot Hues Reducer* *HHR-7065™, HHR-7075™ or HHR-7085™	1	1319	1318	1314

### Viscosity

9.5 - 12 seconds in a Zahn #3 cup.



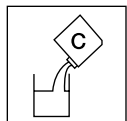
### Pot Life

1 hour at 70°F (21°C).



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### Additives

Accelerator: Not recommended.  
 Fish Eye Eliminator: Not recommended.  
 Retarder: Not recommended.  
 Flex Additive: Add 5 ounces Plas-Stick® 2350S™ Flexible Additive per ready-to-spray quart of activated Primer or use Plas-Stick® 2350S™ as described below.

	Volume	Weight (cumulative qt.)
HHU-3040™	5	463.5
HHA-8005™ / HHA-8003™	1	526.1
HHR-7075™	1	576.3
Plas-Stick® 2350S™	1	633.0

### Tips for Success

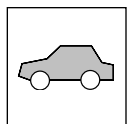
Keep film builds to a minimum on flexible parts

### Sealer

Hot Seal 2K Sealer HHU-4110™ / HHU-4140™ / HHU-4170™

### Topcoats

Hot Hues Hot Colors Basecoats  
 Hot Intercoat Adhesion Promoter HHM-6222™  
 Hot Rod Black HHM-6400™



### Application

#### Substrates

Properly treated Steel, Aluminum and Galvanized Steel.  
 Properly sanded OEM finishes and OEM replacement parts.  
 Fiberglass, SMC  
 Direct to DuPont ChromaPremier® 22860S™ Etch Primer, Variprime® 615S™



#### Surface Preparation

Clean surface thoroughly with mild detergent and water. For substrates other than plastic or fiberglass, wipe surface with DuPont™ First Klean 3900S™, Prep-Sol® 3919S™ or DuPont™ Kwik Clean 3949S™. For flexible and rigid plastic and fiberglass, wipe with Plas-Stick® 2320S™ Plastics Cleaner.

Sand and featheredge according to the following minimum grit recommendations:

Steel: P180 grit.  
 Aluminum: P320 grit, then pretreat.  
 Galvanized: P320 grit, then pretreat.  
 E-coat: P320 grit.  
 Cured paint: P320 grit.  
 OEM featheredge: P180 grit followed by P240 grit.  
 Body filler: P180 grit.  
 2K putty: P180-P240 grit.  
 SMC/fiberglass: P180-P240 grit.

Remove sanding sludge with DuPont™ Final Klean 3901S™, DuPont™ 3939S™ Lacquer and Enamel Cleaner or DuPont Low VOC Final Klean 3909S™.

Notes: Aluminum, galvanized, and steel must be pretreated with Variprime® 615S™; lead- and chromate-free Variprime® 625S™; or ChromaPremier® 22860S™ Premier Etch Primer. Alternately, aluminum may be pretreated with DuPont™ 225S/226S™.



## Hot Prime 2K Urethane Primer HHU-3040™

### Tips for Success

- When using coarse grit paper, step your way up through P80/P180/P240 grit prior to priming to remove coarse scratches and avoid sandscratch swelling in OEM finishes. Finish sensitive substrates in P320 grit.
- Sand beyond the area to be primed with P320 grit or finer to ensure good adhesion at the thin edge of the primer.



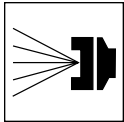
### Gun Setups\*

#### Conventional

Siphon Feed:	1.6 mm - 1.8 mm (.063" - .070")
Gravity Feed:	1.6 mm - 1.8 mm (.059" - .070")

#### HVLP

Siphon Feed:	1.6 mm - 1.9 mm (.047" - .073")
Gravity Feed:	1.6 mm - 1.9 mm (.047" - .073")



### Air Pressure\*

#### Conventional

Siphon Feed:	30 - 40 psi @ the gun.
Gravity Feed:	30 - 40 psi @ the gun.

#### HVLP

Siphon Feed:	6 - 8 psi @ the gun cap.
Gravity Feed:	6 - 8 psi @ the gun cap.

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

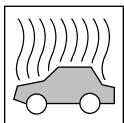


### Application

Apply 3 medium wet coats.

### Tips for Success

Allow adequate flash between coats – 10 minutes @ 70°F.



### Flash/Dry Times

#### Air Dry

Flash between Coats:	10 minutes.
Dry Sanding (machine or hand)	4 hours.
Wet Sanding:	4 hours.

#### Force Dry

Flash before Force Dry:	5-10 minutes.
Cycle Time:	30 minutes @ 140° F.
Cool Down:	30 minutes.

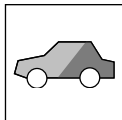
#### Infrared Dry

For a 1500-2000 Watt unit, cure 15 minutes at a distance of 36 inches. Allow to flash 10 minutes before applying IR. Refer to the Infrared Guide for specific setup recommendations.



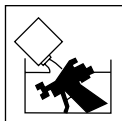
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## Hot Prime 2K Urethane Primer HHU-3040™



### Recoatability / Re-repair

When recoating Hot Primer 2K Urethane Primer HHU-3040™ with itself, sanding is required if the primer has been force dried or has been allowed to air dry.



### Cleanup

Clean spray equipment immediately after use with DuPont Lacquer Thinner.

### Physical Properties

VOC: 4.25 lbs/gal ready-to-spray.  
Theoretical Coverage: 663.6 sq. ft. per ready-to-spray gallon at 1 mil.  
Weight Solids: 63.43% ready-to-spray.  
Volume Solids: 41.3% ready-to-spray.  
Recommended Dry Film Thickness: 4.2 - 5.5 mils in 3 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. 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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