



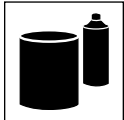
UNLEASH THE COLOR™

Hot Prime 2.1 VOC 2K Urethane Primer HHU-3140™

Description

Hot Prime 2.1 VOC 2K Urethane Primer HHU-3140™ is designed for custom shops that require a high-build, easy to sand primer-filler. Hot Prime HHU-3140™ is a superior high solids urethane primer-filler that provides excellent fill capacity, and is the foundation for high quality finishes.

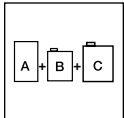
Hot Prime HHU-3140™ utilizes Hot Clear HHA-5400™ activator, which provide Hot Hues users the ability to have an integrated system approach.



General Information

Components

Hot Prime 2.1 VOC 2K Urethane Primer HHU-3140™
Hot Reducer Standard HHR-3175™
Hot Activator Standard HHA-5405™



Mix Ratio 3:1:1 / Viscosity

Combine the components either by volume or weight and then mix thoroughly. (cumulative quart)

	Volume	Weight
Hot Prime HHU-3140™	3	1023.00 grams
Hot Activator Standard HHC-5405™	1	1249.24 grams
Hot Reducer Standard HHR-3175™	1	1500.26 grams

Viscosity

Filler: 10-14 seconds in a Zahn #3 cup.

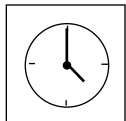
Tips for Success

- Shake Hot Prime HHU-3140™ primer on a mechanical shaker before first usage. To maintain thorough agitation, place primer on a mixing machine.
- Mix accurately using a mixing stick and a cup with straight sides for accurate measurements to ensure state product application and performance.



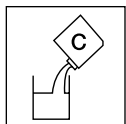
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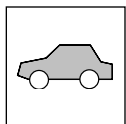
Pot Life

60-90 minutes @ 70°F



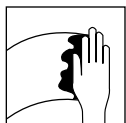
Additives

Accelerator:	Not required.
Fish Eye Eliminator:	Not required.
Reducer:	Not required.
Retarder:	Not required.
Flex Additive:	Add 3 oz. DuPont™ Plas-Stick® V-2350S™ Flexible Additive per RTS quart of activated and reduced primer.



Topcoats

Hot Hues Hot Colors Basecoats
Hot Intercoat Adhesion Promoter HHM-6222™



Application

Substrates

Properly treated steel, aluminum and galvanized
Properly sanded & prepared OEM finishes and OEM replacement parts
Direct to DuPont™ Variprime® 625S™ Self-Etching Primer

Tips for Success

- Apply primer using outside-in technique. Allow each coat to flash to a dull even gray before applying next coat.
- For best holdout, IR, force dry, or allow primer to dry overnight.



Surface Preparation

- Clean painted surfaces thoroughly with mild detergent and water.
- For substrates other than unprimed plastic or fiberglass, wipe surface with DuPont First Klean 3900S™, Prep-Sol® 3919S™, DuPont Kwik Clean 3949S™, or DuPont Surface Klean A-3970S™/A-3990S™ Aerosol Surface Cleaners.
- For unprimed plastic and fiberglass, wipe with DuPont™ Plas-Stick® 2320S™ Plastics Cleaner.
- As a primer, sand and featheredge with P180 / P240 / P320, stepping your way up using the stated grit paper.
- Remove sanding sludge with DuPont Final Klean 3901S™, DuPont 3939S™ Lacquer and Enamel Cleaner, DuPont Low VOC Final Klean 3909S™, or DuPont Surface Klean A-3970S™/A-3990S™ Aerosol Surface Cleaners.
- Apply 2 medium coats of Variprime® 625S™ Lead and Chromate Free Self-Etching Primer.

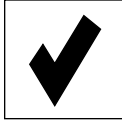
Tips for Success

Avoid the use of excessively coarse grit paper. When working with 36/40 grit scratches, step your way up through P80/ P180/P240 DA grit prior to the application of the primer to remove coarse scratches and avoid sandscratch swelling in OEM finishes.



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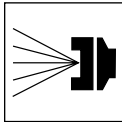


Gun Setups*

HVLP

Gravity Feed: 1.7 mm - 1.9 mm

**DO NOT USE a gun tip less than 1.7 mm, with Hot Prime HHU-3140™*



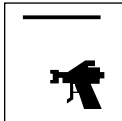
Air Pressure*

HVLP

Gravity Feed: 8 - 10 psi @ the gun cap.

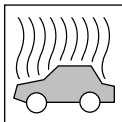
Fluid tip size refers to actual size diameter.

The listed setups cover the common range for various application equipment; for information on specific manufacturer's equipment, see the Appendix section titled "Equipment Information."



Application

Coats	3 wet coats
DFT	4.8 - 5.0 mils



Flash/Dry Times

Air Dry

Flash between coats: 10 - 12 minutes

Wet sanding: 2 - 3 hours

Dry sanding: 2 - 3 hours

Force Dry

Flash before Force Dry: 10 minutes

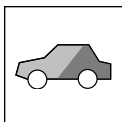
Cycle Time: 30 minutes @ 140° F (60° C).

Cool Down: 30 minutes

Infrared Refer to the Infrared Guide for setup recommendations.

Tips for Success

- For optimum holdout, air dry overnight or force dry.
- Stated flash times will depend on temperature and humidity.



Recoatability/Re-repair

When recoating Hot Prime HHU-3140™ Primer with more Hot Prime HHU-3140 Primer, sanding is required if the primer has been force dried or has been allowed to air dry more than 3 hours.



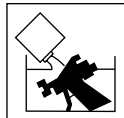
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Sanding

Prior to sealing or topcoating, sand with P400 DA, P500 dry or P600 wet.



Cleanup

Clean spray equipment as soon as possible with DuPont Lacquer Thinner or Compliant DuPont equipment solvent cleaner.

Physical Properties

VOC: 2.08 lbs/gal RTS.

Theoretical Coverage: 894.81 sq. feet per RTS gallon at 1 mil.

Weight Solids: 72.31% RTS.

Volume Solids: 55.78% RTS.

Dry Film Thickness: 4.8 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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