

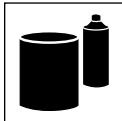


UNLEASH THE COLOR™

Hot Seal DTM Epoxy Primer Sealer HHU-4010™ / HHU-4040™ / HHU-4070™

Description

Hot Seal DTM Epoxy Primer Sealer offers superior corrosion resistance and excellent adhesion for direct-to-metal applications. It can be used directly on bare metal, fiberglass, SMC or plastics. If superior adhesion with minimal build is required or you want to get to the topcoat step with the least amount of steps possible, this non-sanding primer/sealer is the answer.



General Information

Components

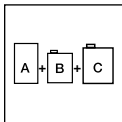
Hot Seal DTM Epoxy Primer/Sealer HHU-4010™
 Hot Seal DTM Epoxy Primer/Sealer HHU-4040™
 Hot Seal DTM Epoxy Primer/Sealer HHU-4070™
 Hot Seal DTM Mid Temp Activator HHA-4005™

ValueShade® Instructions for Use

Use VS1, VS4 and VS7 as packaged. To create VS2, VS3, VS5 or VS6, mix as shown below. Agitate thoroughly prior to activation.

| ValueShade® | Mix | Undercoat | Ratio |
|-------------------|---------|---------------------|-------|
| VS1 (White) | — | HHU-4010™ | — |
| VS2 | VS1:VS4 | HHU-4010™:HHU-4040™ | 2:1 |
| VS3 | VS1:VS4 | HHU-4010™:HHU-4040™ | 1:2 |
| VS4 (Medium Gray) | — | HHU-4010™ | — |
| VS5 | VS4:VS7 | HHU-4040™:4070™ | 2:1 |
| VS6 | VS4:VS7 | HHU-4040™:4070™ | 1:2 |
| VS7 (Dark Gray) | — | HHU-4070™ | — |

After creating the desired ValueShade®, activate and reduce the undercoat as shown on next page.



Mix Ratio / Viscosity

For 2.8 VOC. combine the components by volume or weight, then mix thoroughly.

Volume

| | |
|-----------------------------------|---------|
| HHU-4010™ / HHU-4040™ / HHU-4070™ | 2 Parts |
| HHA-4005™ | 1 Part |

Cumulative Weights for a RTS pint of HHU-4010™ / HHU-4040™ / HHU-4070™ + HHA-4005™

| Ingredient | VS1 | VS2 | VS3 | VS4 | VS5 | VS6 | VS7 |
|------------|-----|-----|-----|-----|-----|-----|-----|
| HHU-4010™ | 517 | 335 | 172 | | | | |
| HHU-4040™ | | 517 | 510 | 506 | 337 | 169 | |
| HHU-4070™ | | | | | 506 | 506 | 506 |
| HHA-4005™ | 686 | 686 | 679 | 675 | 675 | 675 | 675 |



UNLEASH THE COLOR™

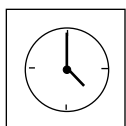
Hot Seal DTM Epoxy Primer Sealer HHU-4010™ / HHU-4040™ / HHU-4070™

Viscosity

20 - 22 seconds in a Zahn #2 cup at 2:1.

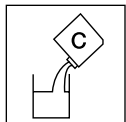
Tips for Success

Apply one medium wet coat. Film build dry should be 0.8-1.0 mils as a non-sanding primer/sealer over aluminum, galvanized steel, carbon steel and stainless steel. Time to topcoat is 30-40 minutes. Two coats of primer will build film build quickly and slow down the dry time to topcoat to 60 minutes. Can apply up to 2 coats (2.0-2.2 mils) as non-sanding primer/sealer.



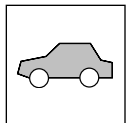
Pot Life

12 hours at 70° F in a sealed container.



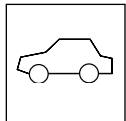
Additives

| | |
|----------------------|--|
| Reducer: | Up to 5% Hot Reducer HHR-7065™ / HHR-7075™ / HHR-7085™ (In areas where 2.8 VOC is required) |
| Accelerator: | Not recommended. |
| Fish Eye Eliminator: | Not recommended. |
| Retarder: | Not recommended. |



Topcoats

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



Application

Substrates

Properly sanded OEM replacement parts
Properly sanded or blasted steel.
Properly cleaned or sanded aluminum, galvanized, and stainless steel
SMC, fiberglass, body fillers, polyester putties
Over properly sanded Hot Hues primers.
Under all Hot Hues primers.

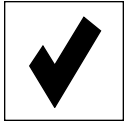


Hot Seal DTM Epoxy Primer Sealer HHU-4010™ / HHU-4040™ / HHU-4070™



Surface Preparation

- Clean painted surfaces thoroughly with mild detergent and water.
 - For substrates other than plastic or fiberglass, clean surfaces with Prep-Sol® 3909S™.
 - For rigid plastic or fiberglass, wipe with Plas-Stick® Plastic-Prep® 2319S™ or Plas-Stick® 2320S™.
 - For flexible fascia, refer to the DuPont Plastics Refinishing System
1. To Use Hot Seal DTM Epoxy Primer / Sealer HHU-4010™ / HHU-4040™ / HHU-4070™ as a Precoat:
 Finish sanding with 320 grit paper or finer.
 Final cleaning should be done with Prep-Sol® 3909S™.
 2. To Use Hot Seal DTM Epoxy Primer / Sealer HHU-4010™ / HHU-4040™ / HHU-4070™ as a non-sanding primer:
 For application to OEM replacement parts, sand with 320 grit or finer.
 For application direct to steel, sand with 80 grit followed by 180 grit or finer.
 For application to aluminum, galvanized or stainless steel, clean with Prep-Sol® 3909S™ or sand with 320 grit paper or finer.
 Remove sanding sludge with Prep-Sol® 3909S™.



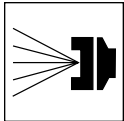
Gun Setups*

Conventional

| | |
|----------------|---------------------------------|
| Siphon Feed: | 1.6 mm - 1.8 mm (.063" - .071") |
| Gravity Feed: | 1.4 mm - 1.6 mm (.055" - .063") |
| Pressure Feed: | 1.0 mm - 1.2 mm |

HVLP

| | |
|----------------|--|
| Siphon Feed: | 1.9 mm - 2.1 mm |
| Gravity Feed: | 1.4 mm - 1.5 mm |
| Pressure Feed: | 0.8 mm - 1.0 mm (Set fluid flow 10-12 ounces per minute) |



Air Pressure*

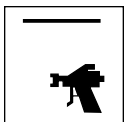
Conventional

| | |
|----------------|--|
| Siphon Feed: | 35 - 45 psi @ the gun |
| Gravity Feed: | 30 - 40 psi @ the gun |
| Pressure Feed: | 35 - 40 psi @ the gun (Set fluid flow 12-14 ounces per minute) |

HVLP

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

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



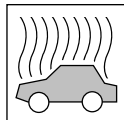
Application

Apply 1 medium-wet coat.



UNLEASH THE COLOR™

Hot Seal DTM Epoxy Primer Sealer HHU-4010™ / HHU-4040™ / HHU-4070™



Flash/Dry Times

Air Dry

| | |
|--------------|---|
| Nib Sanding: | 30 - 60 minutes |
| Topcoating: | 30 - 40 minutes (1 coat DTM) 50 - 60 minutes (2 coats DTM) |

Force Dry

| | |
|-------------------------|------------------------------|
| Flash before Force Dry: | 5 minutes |
| Cycle Time: | 20 minutes @ 140° F (60° C). |
| Cool Down: | 15 minutes |

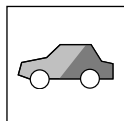
Infrared

Refer to the Infrared Guide for setup recommendations..

Note: For use under body filler, allow to dry overnight (minimum of 16 hours) or bake for 30 minutes @ 140°F.

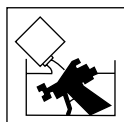
Tips for Success

Ambient air temperature (greater than 70°F) and air flow will maximize product performance.



Recoatability/Re-repair

Hot Seal DTM Epoxy Primer Sealer HHU-4010™ / HHU-4040™ / HHU-4070™ may be recoated at any stage of cure. DTM can be topcoated within 2 days air dry without sanding the DTM. If the DTM is baked or air dried longer than 2 days, it must be sanded with P400-P600 before topcoating.



Cleanup

Clean spray equipment immediately after use with DuPont Lacquer Thinner.

Physical Properties

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

Theoretical Coverage: 555 sq. feet per ready-to-spray gallon at 1 mil.

Volume Solids: 35% ready-to-spray.

Recommended Dry Film Thickness: 0.8 - 1.2 mils.

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 PROPERLY FITTED AIR PURIFYING RESPIRATOR with organic vapor cartridges (NIOSH approved TC-23C) and particulate filter (NIOSH TC-84A), eye protection, gloves and protective clothing during application and until all vapors and spray mists are exhausted. In confined spaces, or in situations where continuous spray operations are typical, or if proper air purifying respirator fit is not possible, wear a positive-pressure, supplied air respirator (NIOSH TC-19). In all cases follow respirator manufacturer's directions for respirator use. Do not permit anyone without protection in the painting area. This product is intended for industrial use only by professional, trained painters.



The miracles of science™