

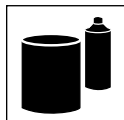


UNLEASH THE COLOR™

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

## Description

Hot Seal 2K Sealers are three-component, high performance sealers for premium-quality spot, panel and overall projects. It provides excellent top coat coverage with fewer coats, uniform color and gloss retention. The performance of this product, from its ability to lock down feather edges to superior color hold out, cannot be ignored if you are looking for a first class finish on your top notch project.



## General Information

### Components

- Hot Seal 2K Sealer HHU-4110™
- Hot Seal 2K Sealer HHU-4140™
- Hot Seal 2K Sealer HHU-4170™
- Hot Activator Standard HHA-8005™
- Hot Activator Fast HHA-8003™
- Hot Seal Reducer Fast HHR-4175™
- Hot Seal Reducer Medium HHR-4185™
- Hot Seal Reducer Very Slow HHR-4195™

### Tips for Success

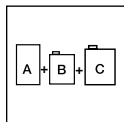
<i>For shop temperature</i>	<i>Use Reducer</i>
55° F – 75° F	HHR-4175™
75° F – 95° F	HHR-4185™
95° F +	HHR-4195™

## 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-4110™	—
VS2	VS1:VS4	HHU-4110™:HHU-4140™	2:1
VS3	VS1:VS4	HHU-4110™:HHU-4140™	1:2
VS4 (Medium Gray)	—	HHU-4110™	—
VS5	VS4:VS7	HHU-4140™:4170™	2:1
VS6	VS4:VS7	HHU-4140™:4170™	1:2
VS7 (Dark Gray)	—	HHU-4170™	—

After creating the desired ValueShade®, activate and reduce.



## Mix Ratio / Viscosity

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

	Volume	Weight (cumulative qt.)
HHU-4110™/ HHU-4140™/ HHU-4170™	4	896.4 grams
HHA-8005™/ HHA-8003™	1	1050.4 grams
HHR-4175™/ HHR-4185™/ HHR-4195™	1.5	1251.6 grams

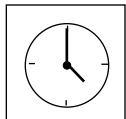
### Viscosity

18 - 22 seconds in a Zahn #2 (DuPont M-222) cup.



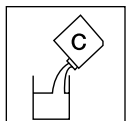
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### Pot Life

1 hour at 70° F (21° C).



### Additives

Accelerator: Not recommended.  
 Fish Eye Eliminator: Not recommended.  
 Retarder: Not recommended.  
 Flex Additive: Plas-Stick® 2350S™ Flexible Additive.

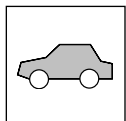
### Undercoats

HHU-4110™  
 HHA-8005™  
 HHR-4175™ / HHR-4185™ / HHR-4195™  
 Plas-Stick® 2350S™  
 HHU-4140™  
 HHA-8005™  
 HHR-4175™ / HHR-4185™ / HHR-4195™  
 Plas-Stick® 2350S™  
 HHU-4170™  
 HHA-8005™  
 HHR-4175™ / HHR-4185™ / HHR-4195™  
 Plas-Stick® 2350S™

Volume	Weight (cumulative qt.)
3	385.3
1	462.2
1.5	562.6
1	633.1
3	335.1
1	412.0
1.5	512.4
1	582.9
3	336.7
1	413.6
1.5	514.0
1	584.5

### Tips for Success

Keep film builds to a minimum on flexible parts.



### Topcoats

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



### Application

#### Substrates

- Properly sanded OEM finishes and OEM replacement parts
- Direct to Variprime® 615S™
- Direct to DuPont ChromaPremier® 22860S™ Etch Primer
- Hot Prime HHU-3040™ 2K Urethane Primer
- Hot Prime HHU-3140™ 2.1 VOC 2K Urethane Primer
- Fiberglass, SMC

### Tips for Success

Hot Seal 2K Sealers are not intended for use direct to metal.



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## 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™ or DuPont Kwik Clean 3949S™. For unprimed plastic or fiberglass, wipe with Plas-Stick® 2320S™ Plastics Cleaner.
- Repair and prime areas as required.
- Finish sanding substrate with a minimum of P400 DA grit or P600 grit dry or wet.
- For substrates other than plastic or fiberglass, remove sanding sludge with DuPont Final Klean 3901S™, DuPont 3939S™ Lacquer and Enamel Cleaner, or DuPont Low VOC Final Klean 3909S™. For unprimed plastic or fiberglass, use Plas-Stick® 2320S™ Plastics Cleaner.
- Apply 2 medium coats of Variprime® 615S™ or Variprime® 625S™ Lead- and Chromate-Free or ChromaPremier® 22860S™ Etch Primer to large areas of bare steel. For aluminum, treat with DuPont 225S™ followed by DuPont 226S™ and apply 1 coat of Variprime®.



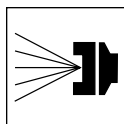
## Gun Setups\*

### Conventional

Siphon Feed:	1.6 mm - 1.8 mm (.063" - .070")
Gravity Feed:	1.5 mm - 1.8 mm (.059" - .070")

### HVLP

Siphon Feed:	1.2 mm - 1.8 mm (.047" - .070")
Gravity Feed:	1.2 mm - 1.8 mm (.047" - .070")



## Air Pressure\*

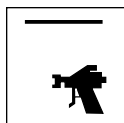
### Conventional

	Spot or Panel	Overall
Siphon Feed:	30 - 45 psi @ the gun.	40 - 45 psi @ the gun.
Gravity Feed:	25 - 35 psi @ the gun.	35 - 40 psi @ the gun.

### HVLP

Siphon Feed:	6 - 8 psi @ the gun cap.	8 - 10 psi @ the gun cap.
Gravity Feed:	6 - 8 psi @ the gun cap.	8 - 10 psi @ the gun cap.

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

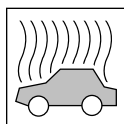


## Application

Apply 1 medium-wet coat.

### Tips for Success

Normally, only 1 coat of sealer is needed. However, for sensitive substrates, 2 coats can provide better holdout.



## Flash/Dry Times

	1 Coat	2 Coats
Flash between Coats:	N/A	15 minutes.
<i>Air Dry @ 70°F</i>		
Nib Sanding:	15 - 30 minutes.	30 - 40 minutes
Topcoating:	20 - 30 minutes.	30 - 40 minutes.

### Force Dry

Flash before Force Dry:	0 - 10 minutes.	0 - 10 minutes.
Cycle Time:	10 minutes @ 140° F (60° C).	15 minutes @ 140° F (60° C).
Cool Down:	20 minutes.	20 minutes.

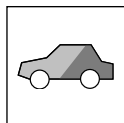
### Infrared

Refer to the Infrared Guide for setup recommendations.



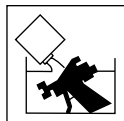
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### Recoatability/Re-repair

When recoating Hot Seal 2K Sealer with itself or topcoating, sanding (P400 DA or P500 grit dry or wet) is required if the sealer has been allowed to dry more than 16 hours.



### Cleanup

Clean spray equipment immediately after use with DuPont Lacquer Thinner.

### Physical Properties

VOC: 4.6 lbs/gal ready-to-spray.

Theoretical Coverage: 621 sq. ft. per ready-to-spray gallon at 1 mil.

Weight Solids: 58.7% ready-to-spray.

Volume Solids: 38.7% ready-to-spray.

Recommended Dry Film Thickness: 0.8 - 1.2 mils in 1 coat.

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.



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