Hot Hues Basecoat

GENERAL

DESCRIPTION

Hot Hues Basecoat is designed to provide high-performance and high-productivity solid, metallic, pearlescent and special-effect colors for a unique appearance. They are ideal for spot, panel and overall custom paint jobs. Hot Hues Basecoat is designed to deliver a smooth appearance with trouble-free application and excellent mottle control.

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.

MIXING

COMPONENTS

Hot Hues Basecoat "HH" Quality.
Hot Hues HH-6200™ Basecoat Binder and HH-6300™ Basecoat Balancer
Cromax® 7160S™ / 7175S™ / 7185S™ / 7195S™ Basemaker
ChromaPremier® Pro 14304S™ / 14305S™ / 14306S™ Activator
ChromaPremier® 12305S™ Activator

MIX RATIO / VISCOSITY

Mix Hot Hues Basecoat and Basemaker. Stir thoroughly, then activate.

Component	Mix Ratio
Hot Hues Basecoat	1
7160S™ / 7175S™ / 7185S™ / 7195S™ Basemaker	1
ChromaPremier® Activator listed in components	1 oz. / RTS quart

ADDITIVES

Accelerator:	Not recommended
Fish Eye Eliminator:	Not recommended
Flex Additive:	Not recommended. See Tips for Success.
Retarder:	Not recommended

Tips for Success

- If fish eyes occur, allow the basecoat to dry thoroughly, then apply dry coats of base color to bridge the affected area.
- The use of ChromaPremier® 12305S or ChromaPremier® Pro 14304S™ / 14305S™ / 14306S™ Activator in a Hot Hues Basecoat is mandatory. The recommended 1 ounce of activator per ready-to-spray quart of basecoat gives optimum performance over flexible substrates. No other flex additive is necessary.
- Hot Hues Basecoat may be reduced at a 2:1 ratio when faster coverage is desired.

VISCOSITY

15-17 seconds in a Zahn #2 cup.

Tips for Success

- Use activated basecoat within 2 hours for optimum performance
- Do not use activated basecoat after the 8-hour pot life
- Activate only what you intend to spray

POT LIFE

8 hours at 70°F (21°C)

TINTING

- Up to 5% with MasterTint® mixing colors that are 6.0 VOC or below

FLATTENERS

Flattening agents are not recommended with a Hot Hues Basecoat. Small amounts of Cromax® 4530S™ Flop Control Agent may be used to adjust color for flake orientation in metallic and pearl colors.

APPLICATION

CLEARCOATS

ChromaPremier® Pro 74500S™ Productive Clearcoat
ChromaPremier® Pro 74700S™ Productive Express Clearcoat
ChromaPremier® 72200S™ Productive Clearcoat
ChromaPremier® 72500S™ Premium Appearance Clearcoat
ChromaBase® "4 to 1" HC-7776S™ Snap Dry Clearcoat
ChromaClear® 7400S™ Non-Stop Clearcoat
ChromaClear® 7900S™ Multi-Use Clearcoat
ChromaBase® “4 to 1” G2-7779S™ Panel and Overall Clearcoat
ChromaClear® G2-4500S™ Ultra Productive Baking Clearcoat
ChromaClear® G2-4700S™ Ultra Productive Air Dry Clearcoat
Plas-Stick® 2370S™ Flexible Matted Clearcoat

SUBSTRATES

222S™ Midcoat Adhesion Promoter
Plas-Stick® 2340S™ Flexible Adhesion Sealer
2580CR™ / 2510S™ / 2540S™ / 2570S™ LF Epoxy DTM Primer
ChromaPremier® Pro 33430S™ Productive Primer Sealer (with or without 2350S™ Flexible Additive)
4004S™ Ultra Productive 2K Primer Filler (with or without 4150S™ Flex-Additive)
ChromaPremier® 42400S™ / 42410S™ / 42440S™ / 42470S™ / 2K Premier Sealer
ChromaBase® "4 to 1" 7701S™ / 7704S™ / 7707S™ 2K Urethane Primer Filler (with or without 2350S™ Flexible Additive)
ChromaBase® "4 to 1" 7710S™ / 7740S™ / 7770S™ 2K Urethane Sealer (with or without 2350S™ Flexible Additive)
Cromax® LE LE3004S™ 2K Primer Surfacer – National Rule
Cromax® LE LE3010S™ / LE3040S™ / LE3070S™ 2K Primer Sealer – National Rule
Plas-Stick® 2350S™ Flexible Additive
LE3130S™ and A-3130S™ UVA Primer Surfacer
Properly sanded OEM finishes

SUBSTRATES

Properly sanded OEM finishes

SURFACE PREPARATION

- Prepare all surfaces to be repainted using the recommended undercoat systems and procedures.
- Finish sand with P400 DA, P600 grit or finer (dry or wet).
- Mask the entire vehicle to protect from overspray.
- Tack with appropriate tack cloth prior to applying color

GUN SETUPS*

Conventional	**Spot/Panel**	**Overall**
Siphon Feed:	1.3-1.5 mm (.051”-.059”)	1.4-1.6 mm (.055”-.063”)
Gravity Feed:	1.3-1.5 mm (.051”-.059”)	1.4-1.6 mm (.055”-.063”)
HVLP		
Siphon Feed:	1.3-1.5 mm (.051”-.059”)	1.4-1.6 mm (.055”-.063”)
Gravity Feed:	1.3-1.5 mm (.051”-.059”)	1.4-1.6 mm (.055” - .063”)

AIR PRESSURE*

Compliant

Siphon Feed:	35 - 45 psi at the gun.
Gravity Feed:	35 - 45 psi at the gun.

HVLP

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

*Refer to manufacturer's directions for gun specific recommendations.

APPLICATION

Apply 2-3 medium coats until hiding and color match are achieved. Flash 5-10 minutes between coats.

BLENDING

- Apply 1 coat of Cromax® 222S™ Mid-Coat Adhesion Promoter over the entire repair area.
- Apply the first coat of color beyond the primed area. Apply the second coat just beyond the first coat. Apply subsequent coats just beyond the previous coats, staying within the area covered by Cromax® 222S™ Mid-Coat Adhesion Promoter. Follow recommended flash times, then apply clearcoat over the entire panel.

Tips for Success

- Taper out each consecutive coat to melt the new color into the old color.
- Use of a slower Basemaker can improve the appearance of the blend edge.
- For alternate blending techniques see the technical data sheet for Special Basecoat Blending Procedures.
- Use Cromax® 69301S™ Basecoat Blender for difficult to blend colors, optimal flake control, improved edge wetting and improved melt-in.

RECOATABILITY / RE-REPAIR

Hot Hues Basecoat may be recoated with itself within 24 hours.

SANDING

Hot Hues Basecoat dries to a smooth matte finish and should not require sanding. Nib sanding of small areas to remove dirt must be followed by the application of more color before clearcoating.

DRY TIMES

AIR DRY AT 70°F (21°C)

Flash before clearcoat:	15-30 minutes
Flash before Tape:	30 minutes
Flash before Two-Toning:	30 minutes
Maximum allowable dry before clearcoat:	24 hours

FORCE DRY

Not recommended.

Tips for Success

Extend the basecoat flash to the full 30 minutes for higher film builds or in cooler temperatures.

CLEANUP

Clean spray equipment immediately after use with a lacquer thinner.

PHYSICAL PROPERTIES

All Values Ready To Spray

	1:1:1 ounce	2:1
Max. VOC (LE):	759 g/L (6.3 lbs./gal)	698 g/L (5.8 lbs./gal)
Max. VOC (AP):	710 g/L (5.9 lbs./gal)	661 g/L (5.5 lbs./gal)
Avg. Gallon Weight:	902 g/L (7.53 lbs./gal)	936 g/L (7.81 lbs./gal)
Avg. Weight % Volatiles:	80.3%	75.2%
Avg. Weight % Water:	0.0%	0.0%
Avg. Weight % Exempt Solvent:	3.5%	4.5%
Avg. Volume % Water:	0.0%	0.0%
Avg. Volume % Exempt Solvent:	4.0%	5.4%

Flash Point: See MSDS/SDS

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 usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and MSDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

Revised: February 2015

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