



Hot Hues Hot Candy Colors



GENERAL

DESCRIPTION

Hot Hues Hot Candy Color concentrates are liquid additives designed and packaged to provide maximum color impact. The Hot Candy Colors can be added to a variety of “carriers” including:

- Hot Hues HHM-6222™ Intercoat Adhesion Promoter
- Hot Hues HH-6200™ Binder and Hot Hues HH-6300™ Balancer
- Cromax® Clearcoats

By design, these candy concentrates are meant to be applied over the top of ground coat colors and then cleared with a topcoat quality clear.

Important Note

Dye-based Candy Concentrates are subject to fading on exposure to direct sunlight. Axalta does not warrant Hot Hues Candy Colors against color fading.

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



MIXING

COMPONENTS

- Hot Intercoat Adhesion Promoter HHM-6222™
- Hot Hues HH-6200™ Basecoat Binder and HH-6300™ Basecoat Balancer
- HCC-6210™ Lazer Blue Candy Concentrate
- HCC-6215™ True Blue Candy Concentrate
- HCC-6230™ Hot Raspberry Candy Concentrate
- HCC-6235™ Hot Apple Red Candy Concentrate
- HCC-6240™ Molten Orange Candy Concentrate
- HCC-6245™ Golden Honey Candy Concentrate
- HCC-6250™ Lemon Mist Candy Concentrate
- HCC-6255™ Irish Green Candy Concentrate
- HCC-6265™ Charcoal Candy Concentrate

MIX RATIO

Hot Candy Concentrate is designed to be used at a rate of 5% to 10% Candy Concentrate on the “Carrier”. The “Carrier Options” are Hot Hues HH-6200™ Binder, Hot Hues HH-6300™ Balancer and Hot Hues HHM-6222™ Intercoat Adhesion Promoter.

Shake the Hot Candy Concentrate by hand prior to mixing and reduction for application. Insoluble material may settle out over time so be sure to strain with a fine mesh strainer during mixing process. Hot Candy Concentrates cannot be used individually as a coating they must be mixed with a carrier.

Hot Hues HHM-6222™ Intercoat Adhesion Promoter

For optimal film properties add ChromaPremier® Pro 14305S™ or ChromaPremier® 12305S™ Activator at a rate of 1 ounce per RTS Quart. Stir each component upon addition. Do not apply more than 3 coats as this product is not designed for high film builds.

Code	Vol. Oz.
HHM-6222™	16
ChromaPremier® 12365S™ Fast Reducer	8
HCC-62XX	1
ChromaPremier® Activator listed above	0.5



Hot Hues HH-6200™ Binder and Hot Hues HH-6300™ Balancer

For optimal film properties add ChromaPremier® Pro 14305S™ or ChromaPremier® 12305S™ Activator at a rate of 1 ounce per RTS Quart. Stir each component upon addition.

Code	Vol. Oz.
HH-6200™	8
HH-6300™	8
Cromax® 7175S™ Basemaker	16
HCC-62XX™	1
ChromaPremier® Activator listed above	1

Cromax® Clearcoats

To create a pint mixture of ready to spray Candy Concentrate, take 15 ounces of RTS Cromax® clearcoat and add 1 ounce of Candy Concentrate. Stir each component upon addition. Do not apply more than three coats as solvent pop may become an issue.

Code	Vol. Oz.
Cromax® clearcoat RTS – see clearcoat TDS for instructions	15
HCC-62XX™	1

Tips for Success

Use the fastest reducer the job and conditions will allow. For optimal film properties use 1 oz. of ChromaPremier® Pro 14305S™ or ChromaPremier® 12305S™ Activator to a ready to spray quart.

POT LIFE

Pot life will be equal that of the carrier for the Candy Concentrate.

TINTING

Hot Candy Color concentrates can be used as blends with one another. Application work suggests that the optimal amount of Candy Concentrate is about 7% on carrier. Use a 15:1 ratio of carrier to candy concentrate. Do not exceed 10% dye concentrate on carrier.



APPLICATION

SUBSTRATES

Use over properly dry basecoat graphics and art work.

GUN SETUP

Conventional

Siphon: 1.4 mm - 1.6 mm (.055" - .066")

Gravity: 1.4 mm - 1.6 mm (.055" - .066")

HVLP

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

Gravity: 1.3 mm - 1.6 mm (.051" - .063")

Tips for Success

Gravity and HVLP equipment usually perform better than siphon.

AIR PRESSURE

Conventional

Siphon: 25 - 30 psi at the gun

Gravity: 25 - 30 psi at the gun

HVLP

Siphon: 6 - 8 psi at the gun

Gravity: 6 - 8 psi at the gun

APPLICATION

When using Hot Hues HHM-6222™ Intercoat Adhesion Promoter, Hot Hues HH-6200™ Binder and Hot Hues HH-6300™ Balancer, or Cromax® clearcoats three coats, with a 15:1 mix ratio, is the optimal application for color space. With any of these carriers use a medium



wet application. Hot Hues HHM-6222™ Intercoat Adhesion Promoter and Cromax® clearcoats should not exceed three coats when mixed with candy concentrates. Hot Hues HH-6200™ Binder and Hot Hues HH-6300™ Balancer mixes may have more than three coats as long as dry times between coats are extended to ensure a fully dried film. In all cases, the application of carrier and candy concentrate, must be followed by top coat clear for durability.

Allow to flash a minimum of 10 minutes between coats.

SANDING

Hot Hues HHM-6222™ Intercoat Adhesion Promoter can be applied to a smooth semi-gloss surface and does not require sanding. To remove dirt nibs or to provide an absolute flat surface, sanding can be performed after 60 minutes. Sand with P600 or finer depending on subsequent application.

Sanding of Hot Hues HH-6200™ Binder and Hot Hues HH-6300™ Balancer mixes are not recommended.

Sanding of Cromax® clearcoats can only be performed after thorough cure.

CLEANUP

Clean spray equipment as soon as possible with a lacquer thinner.



DRY TIMES

AIR DRY AT 70°F (21°C)

Flash before Clearcoat:	30 minutes
Flash before tape:	60 minutes*
Flash before two-toning:	60 minutes*
Maximum allowable before clearcoating:	12 hours

*These times do not apply to mixes done with Cromax® clearcoat mixes. If taping and two-toning is desired use either of the other carriers.



PHYSICAL PROPERTIES

All Values Ready To Spray

Hot Hues HHM-6222™ Intercoat Adhesion Promoter

Max. VOC (LE):	731 g/L (6.1 lbs./gal)
Max. VOC (AP):	731 g/L (6.1 lbs./gal)
Avg. Gallon Weight:	904 g/L (7.54 lbs./gal)
Avg. Weight % Volatiles:	80.5%
Avg. Weight % Water:	0.1%
Avg. Weight % Exempt Solvent:	0.0%
Avg. Volume % Water:	0.1%
Avg. Volume % Exempt Solvent:	0.0%

Hot Hues HH-6200™ Binder and Hot Hues HH-6300™ Balancer

Max. VOC (LE):	767 g/L (6.4 lbs./gal)
Max. VOC (AP):	695 g/L (5.8 lbs./gal)
Avg. Gallon Weight:	840 g/L (7.01 lbs./gal)
Avg. Weight % Volatiles:	90.8%
Avg. Weight % Water:	0.0%
Avg. Weight % Exempt Solvent:	9.2%
Avg. Volume % Water:	0.0%
Avg. Volume % Exempt Solvent:	9.5%



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.

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