



Hot Hues HHM-6390™ Hot Efx™ Brilliantz™



GENERAL

DESCRIPTION

Hot Hues HHM-6390™ Hot Efx™ Brilliantz™ is designed to offer a sophisticated, elegant and dramatic visual appeal that is unique, durable and offers infinite styling opportunities. This unique product utilizes diffractive pigments to display smooth, satin-like rainbow colors at any viewing angle and creates a three dimensional appearance with the illusion of movement.

The Hot Hues HHM-6390™ Hot Efx™ Brilliantz™ is packaged as a basecoat quality, with a range of reduction and optional number of coats in order to offer a broad array of color effects with ease of application.

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



MIXING

COMPONENTS

Hot Hues HHM-6390™ Hot Efx™ Brilliantz™
 ChromaPremier® 12305S™ Activator
 ChromaPremier® Pro 14305S™ Activator
 Cromax® 7160S™ / 7175S™ / 7185S™ / 7195S™ Basemaker

	65°F	75°F	85°F	95°F
Spot Repair	7160S™	7175S™	7185S™	7185S™
Panel Repair	7160S™	7175S™	7185S™	7195S™
Overall Repair	7175S™	7185S™	7195S™	7195S™

MIX RATIO

Stir thoroughly before activation.

Code	Volume
HHM-6390™	1
Basemaker	1
ChromaPremier® Activator listed in components	1 oz. per RTS quart

RTS Color	ChromaPremier® Activator listed in components
1 quart	1 oz. (32 g)
1 pint	½ oz. (16 g)
½ pint	¼ oz. (8 g)

Tips for Success

Hot Hues HHM-6390™ Hot Efx™ Brilliantz™ may be reduced at a 2:1 ratio for a more intense effect and can be sprayed in multiple coats until the desired effect is achieved.

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)

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™ Activator or ChromaPremier® Pro 14305S™ in HHM-6390™ Hot Hues Hot Efx™ Brilliantz™ 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.

TINTING

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

FLATTENERS

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



APPLICATION

SUBSTRATES

Properly sanded OEM finishes
Axalta undercoats appropriate for your VOC Regulated Area

SURFACE PREPARATION

- Prepare all surfaces to be painted 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.



BLENDING

- Hot Hues HHM-6390™ Hot Efx™ Brilliantz™ should be treated like the midcoat of a tri coat repair.
- Refer to the Tri-Coat Repair technical data sheet.

APPLICATION

Apply 1-3 light coats until the desired effect is achieved. Flash between Coats 5 - 10 minutes.

RECOATABILITY / REPAIR

Hot Hues HHM-6390™ Hot Efx™ Brilliantz™ may be recoated with itself within 24 hours.

SANDING

Hot Hues HHM-6390™ Hot Efx™ Brilliantz™ 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 clearcoat.

CLEANUP

Clean spray equipment immediately after use with a lacquer thinner.



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.



PHYSICAL PROPERTIES

All Values Ready To Spray

	1:1:1 ounce 1X305S	2:1
Max. VOC (LE):	763 g/L (6.4 lbs./gal)	754 g/L (6.3 lbs./gal)
Max. VOC (AP):	712 g/L (5.9 lbs./gal)	686 g/L (5.7 lbs./gal)
Avg. Gallon Weight:	852 g/L (7.11 lbs./gal)	870 g/L (7.26 lbs./gal)
Avg. Weight % Volatiles:	89.2%	87.0%
Avg. Weight % Water:	0.0%	0.0%
Avg. Weight % Exempt Solvent:	6.1%	8.1%
Avg. Volume % Water:	0.0%	0.0%
Avg. Volume % Exempt Solvent:	6.6%	8.9%

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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