

5 STAR XTREME AUTOBODY PRODUCTS
TECHNICAL DATA INFORMATION
DATED: JULY 2015

PRODUCT NUMBER DESCRIPTION

#5172 - ORIGINAL SPEED KLEARKOTE 4.2 VOC

PRODUCT DESCRIPTION:

5172 is a medium solids two component urethane klearkote formulated to offer Refinishers ease of application, great flow and leveling, superior gloss and excellent distinctness of image in a highly productive 2K urethane klearkote. Under proper conditions 5172 can be polished in as little as 90 minutes.

PRODUCTS:

- **5172-01** **Original Speed Klearkote 4.2 VOC – Gallon**
- **5172-04** **Original Speed Klearkote 4.2 VOC – Quart**

- ***5186** **Original Activator Fast**
- ***5187** **Original Activator Medium**
- ***5188** **Original Activator Slow**
 *** available in half pints**

BASECOAT:

Compatible with most paint manufacturers' solvent and waterborne systems. Apply basecoat as per manufacturer's mixing and application instructions. Allow sufficient flash times before applying #5172. Inadequate flash time will affect the performance of the clear.

SURFACE PREPARATION: Apply Undercoats and Basecoat per manufacturer's instruction. Over OEM or completely cured previously painted substrates scuff with a grey scuff pad or 600 grit then wipe clean with an approved solvent or water-borne wipe. Allow basecoat adequate flash time (follow manufacturer's recommendation). Follow basecoat manufacturer's recommendation for recoat intervals.

MIXING DIRECTIONS:

Mix 4 parts 5172 with 1 part 5186, 5187, or 5188 by volume. Activator selection should be based on the size of the part to be painted and the temperature of both the air and part at time of painting.

APPLICATION DIRECTIONS:

Number of Coats: 2-3
Application Density: Full wet
Overlap: 50%
Flash: 5-10 mins between coats

Film Thickness Range:

Dry 1 mil – 4 mils
Wet 3 mils – 4 mils

Application Conditions

Minimum Temp 50°F (Substrate Temp.)
Max Temp 100°F (Substrate Temp.)
Ambient Humidity Less than 80% preferred

ADDITIVES:

ACCELERATOR: N/A
FISHEYE: N/A

FLEX ADDITIVE: Not required

Note: Do not spray when surface temperature is below 50°F.

CLEAN UP:

Clean spray equipment immediately after use with gun wash solvent.

SUBSTRATES:

Commercially available basecoats with a VOC less than 6.6 lbs/gal Properly prepared previously painted substrates

GUN SETUPS:

CONVENTIONAL

Gravity Feed 1.3 mm – 1.5 mm

Siphon Feed 1.6 mm – 1.8 mm

HVLP 1.3 mm – 1.5 mm

AIR PRESSURES

Conventional @ Gun PANEL OVERALL

Gravity Feed 35-40 psi 45 psi

Siphon Feed 35-45 psi 45-50 psi

HVLP @ Cap 6-8 psi 9-10 psi

FLASH/DRY TIMES:

	5186 @ or above 77°F	5187 @ or above 85°F	5188 @ or above 95°F
Flash Between Coats	5-10 min	5-10 min	5-10 min
Dust Free	10-15 min	10-15 min	10-15 min
Sand/Polish	1.5-2 hours	1.5-2 hours	1.5-2 hours
Force Dry (Convection Heat)			
Purge time before applying heat	5186 0-15 min	5187 0-15 min	5188 0-15 min
Force Dry Time	20 min @ 165°F	20 min @ 165°F	20 min @ 165°F
Sand and Buff	After Cool Down	After Cool Down	After Cool Down

TECHNICAL DATA:

VOC (Volatile Organic Content) 4.2 lbs/gal

Viscosity 17-21 seconds Zahn #2

Flash Point -4°F

Film Build 0.8 - 1.0 mils per full wet coat

Theoretical Coverage 510 ft²/gal @ 1 mil thickness

Density: 8.69 lbs/gal (unactivated)

Solids (Ready to Spray)

ByWeight 37.71%

By Volume 32.5%

FIRST AID:

In case of eye contact, immediately flush eyes with plenty of water for at least 15 minutes and get medical attention. For skin: Wash thoroughly with water. If difficulty in breathing is experienced, get medical attention immediately. If swallowed, do not induce vomiting, get medical attention immediately. See Material Safety Data Sheet.

SAFETY INFORMATION - FOR INDUSTRY USE ONLY

Danger: Vapor and spray mist harmful. Overspray may cause lung damage. May cause allergic skin and respiratory reaction, effects may be permanent. Flammable liquid and vapor. Harmful if

inhaled. May affect the brain or nervous system causing dizziness, headache, or nausea. May cause eye, skin, nose, and throat irritation. **Contents:** See product label for contents and CAS #'s. **The contents of this package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions.** The material is designed for application only by professionally trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

KEEP OUT OF REACH OF CHILDREN.

**ABI - AutobodyBrands International a division of IAMG –
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1-87-REFINISH