

5 STAR XTREME AUTOBODY PRODUCTS TECHNICAL DATA INFORMATION

DATED: October 2014

PRODUCT NUMBER DESCRIPTION

#5433-1 High Build Epoxy Primer/Sealer (2.1 VOC) Gray, Gallon

#5433-4 High Build Epoxy Primer/Sealer (2.1 VOC) Gray, Quart

#5434-1 High Build Epoxy Primer/Sealer Catalyst (2.1 VOC), Gallon

#5434-4 High Build Epoxy Primer/Sealer Catalyst (2.1 VOC), Quart

PRODUCT DESCRIPTION:

#5433 has been formulated for excellent adhesion and corrosion resistance when used on various types of substrates including properly prepared steel and aluminum.

SURFACE PREPARATION:

Clean all areas to be primed with compliant Wax & Grease Remover to remove all dirt, wax, grease, and other contaminants. Featheredge and sand the original finish. Surface must be clean and dry.

MIXING DIRECTIONS:

HIGH BUILD EPOXY PRIMER/SEALER

1:1:15-25% MIX RATIO

#5433 Primer: #5434 Catalyst

(SANDING FILLER) Reduce 15-20% with a LOW VOC Reducer for compliancy.

At 25% for Sealer option.

APPLICATION:

Primer:

- Apply 2-3 medium wet coats over substrate to desired film thickness.
- Allow 30 minutes between coats.
- 24 hours before sanding
- Clean gun after spraying is completed

Sealer:

- Apply one medium wet coat
- Allow 60 minutes before topcoating
- Apply topcoat after 60 mins.

POT LIFE: 8 Hours @ 77° F

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 5 STAR XTREME #5214 Virgin Wash Thinner.

GUN SETUPS: CONVENTIONAL

Conventional

Gravity Feed 1.3 mm – 1.8 mm

Siphon Feed 1.3 mm – 1.8 mm

AIR PRESSURES:

Conventional at Gun

Gravity Feed 30 – 40 psi

Siphon Feed 35 – 45 psi

HVLP at cap 8 – 10 psi

FLASH/DRY TIMES:

AIR DRY @ 77°F

Air Dry at 77° F

Flash between coats 30 minutes

To sand Overnight

To topcoat 60 minutes

Force Dry

Flash before force dry 15 minutes flash

Force dry time 30 minutes at 140° F

TECH DATA:

Volume solids as mixed 53%

VOC as mixed 2.1

Color Light Gray

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 harmful. May affect the brain or nervous system causing dizziness, headache, or nausea. May cause eye, skin, nose, and throat irritation. Harmful if swallowed. **Precautions:** Vapors may ignite explosively. Keep away from heat, sparks, and flame. Vapors may cause flash fire. Do not smoke. Extinguish all flames and pilot lights, and turn off stoves, heaters, electric motors and other sources of ignition during use and until all vapors are gone. Prevent buildup of vapors by opening all windows and doors to achieve cross-ventilation. **Use only with adequate ventilation.** Do not breathe vapor or spray mist. Do not get in eyes, on skin or clothing. Wash thoroughly after handling. Wear solvent resistant gloves. 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- Autobody Brands International
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