

**5 STAR XTREME AUTOBODY PRODUCTS  
TECHNICAL DATA INFORMATION**

**DATED: October 2014**

**PRODUCT NUMBER DESCRIPTION**

5480-1	2K Rapid Filler Primer/Sealer (2.1 VOC) Gallon	4/cs
5480-4	2K Rapid Filler Primer/Sealer (2.1 VOC) Quart	4/cs
5481-4	Zero VOC Fast Activator Quart	4/cs
5481-16	Zero VOC Fast Activator Half Pint	4/cs
5482-4	Zero VOC Medium Activator Quart	4/cs
5482-16	Zero VOC Medium Activator Half Pint	4/cs
5483-4	Zero VOC Slow Activator Quart	4/cs
5483-16	Zero VOC Slow Activator Half Pint	4/cs

**PRODUCT DESCRIPTION:**

#5480 is a 2K high solids, high speed, high build primer surfacer with excellent filling and sanding properties. It can also be mixed and used as a sealer if needed. #5480 provides optimum holdout for most subsequent topcoats. Sand scratch swelling is minimal.

**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:**

**(4:1:20-25%) MIX RATIO**

(SANDING/HIGH BUILD PRIMER SURFACER)

#5480 2K Rapid Filler Primer to #5481/5482/5483 Zero VOC Activator to LOW VOC Reducer

**(4:1:2) MIX RATIO**

(SEALER)

#5480 2K Rapid Filler Primer to #5481/5482/5483 Zero VOC Activator to LOW VOC Reducer

**APPLICATION:**

**Sanding Filler Primer:**

- Apply 2-3 medium wet coats over substrate to desired film thickness, 2-2.3 mils DFT.
- Allow 5-10 minutes between coats. Recoating too quickly will result in slower cure rates and poor sanding

- 2-3 hours before sanding
- Clean gun after spraying is completed

**Sealer:**

- Apply one to two medium wet coats over substrate to desired film thickness
- Allow 5-10 minutes between coats
- Apply topcoat after 30 mins. (For waterborne topcoat application allow 45 minutes to 1 hour flash off.)

**POT LIFE: 45 to 60 minutes @ 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	5-10 minutes
To sand	1 hour - medium wet coat, 1.5 hours - heavy coat

To topcoat mixed as a sealer 30 minutes

**Force Dry to sand**

Flash before force dry 15 minutes flash  
Force dry time 15-30 minutes at 140° F

**When used as a sanding filler #5480 must be sanded before topcoat.**

**TECH DATA:**

Solids wt. (as mixed) 67.8%  
VOC as mixed (primer) 2.1  
Color Medium gray  
Dry mills per coat mixed as a filler 2 - 2.3 (medium wet coat as a sanding filler)

**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  
a division of IAMG - International Autobody Marketing Group -  
Scottsdale, AZ - [www.5starxtreme.com](http://www.5starxtreme.com)**