

**5 STAR XTREME AUTOBODY PRODUCTS
TECHNICAL DATA INFORMATION
DATED: AUGUST 2017**

PRODUCT DESCRIPTION:

The 5 STAR XTREME Alkyd Enamel (Intermix System) are high solids 2.8 VOC performance coatings designed for fast dry, high gloss, excellent coverage and good durability. Available in three mix bases to allow custom tinting using the 5 STAR XTREME colorant systems. Mix and match endless colors!

FEATURES:

Easy to Use, **Direct to Metal**, VOC Compliant Coast to Coast and Canada, 50%+ Solids, Single Stage Alkyd Enamel Paint.

1K color (Base+Toner) can be loaded into an aerosol can!

For added durability, color can be activated.

ALKYD ENAMEL (INTERMIX SYSTEM) APPLICATIONS:

Best suited for Industrial & Equipment Industries. Covers parts/accessories, metal, wood, agricultural/construction equipment and other general finishing products.

**PLEASE SHAKE AND STIR ALL PRODUCTS THOROUGHLY
(We suggest you agitate at least 30 mins)**

INTERMIX SYSTEM TONERS 2.8 VOC:

8200-04		INTERMIX SYSTEM - LAMP BLACK	Quart
8201-04		INTERMIX SYSTEM - TITANIUM WHITE	Quart
8202-04		INTERMIX SYSTEM - PHTHALO BLUE Y/S	Quart
8203-04		INTERMIX SYSTEM - QUINACIDONE VIOLET	Quart
8204-04		INTERMIX SYSTEM - PHTHALO GREEN B/S	Quart
8205-04		INTERMIX SYSTEM - YELLOW OXIDE	Quart
8206-04		INTERMIX SYSTEM - ORGANIC YELLOW	Quart
8207-04		INTERMIX SYSTEM - LEAD FREE MED YELLOW	Quart
8208-04		INTERMIX SYSTEM - LEAD FREE ORANGE	Quart
8209-04		INTERMIX SYSTEM - BURNT UMBER	Quart
8210-04		INTERMIX SYSTEM - RED OXIDE Y/S	Quart

8211-04		INTERMIX SYSTEM - QUINACIDONE RED	Quart
*8220-01		INTERMIX SYSTEM - METALLIC TONER	Gallon
8212-04		INTERMIX SYSTEM - HS JET BLACK TONER	Quart
8213-04		INTERMIX SYSTEM - HS RED TONER	Quart
8214-04		INTERMIX SYSTEM - HS YELLOW TONER	Quart

ALKYD ENAMEL BASES 2.8 VOC:

8303-01		Alkyd Enamel White Base	Gallon
8304-01		Alkyd Enamel Deep Base	Gallon
8305-01		Alkyd Enamel Clear Base	Gallon

INTERMIX SYSTEM CATALYST & REDUCER :

8030-04		Premium Low VOC Reducer	Qt.
8040-04		2.8 VOC High Performance Urethane Paint Catalyst	Quart
8040-16		2.8 VOC High Performance Urethane Paint Catalyst	1/2 pt

CORESPONDING PRODUCTS

8050-04		Gloss Adjuster - Flattening Agent	Quart
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Used to convert our Single Stage color (Factory Pack & Intermix System) into a variety of Gloss Finishes: 1/4 Gloss, 1/2 Gloss and 3/4 Gloss.

DIRECT TO METAL ADHESION

NOTE: Performance is better when using 5 STAR XTREME DTM #5425 Primer under Alkyd Enamel Intermix System paint.

SUBSTRATES:

- Properly cleaned and sanded aluminum, steel, galvanized steel or sand blasted steel
- Properly cleaned and sanded fiberglass, SMC, E-Coat and OEM finish.

POT LIFE

Pot life will be about 3-5 hours at 77° F.

MIXING DIRECTIONS (6:1:+/-20%):

2.8 VOC

6 PARTS Alkyd Enamel Intermix Single Stage Color

1 PART #8040 Catalyst

Up to 20% #8030 Reducer or quality grade Low VOC Urethane Reducer

Note: If used as 1K, reduce up to 20%

*** METALLIC TONER MIXING NOTE:**

Up to 10% of compliant urethane reducer can be used for better flow and lay down of the metallic flakes.

SURFACE PREPARATION:

1. Wash area thoroughly with soap and water to remove contaminants that solvent based cleaners cannot remove effectively.
2. Clean area with Wax and Grease Remover.
3. Use a tack cloth to remove any surface contaminants that may have settled on the repaired areas prior to paint application.
4. Apply Alkyd Enamel Intermix Single Stage Color.

APPLICATION DIRECTIONS:

Adjust air pressure to 40-50 psi at gun for gravity, siphon feed guns or HVLP use 6-10 psi at air cap. Apply 2-3 medium coats (maximum 2 mils wet per coat) or until hiding is achieved. Allow a 15-20 minute flash time between coats and before force drying.

*** METALLIC TONER APPLICATION DIRECTIONS:**

1. APPLY 1 TACK COAT AND 1-2 WET COATS
ALLOWING A 10-15 MINUTE FLASH TIME IN BETWEEN COATS.
2. REDUCE PROPERLY FOR ULTIMATE FLOW AND LEVELING WITH THE RECOMMENDED REDUCERS.
3. APPLY RE-COAT BEFORE 3 HOURS OR ALLOW 36 HOURS DRY TIME.

DRY TIMES AT 77°F:

FLASH TIME 15-20 MINUTES
TO DELIVER 16-24 HOURS

FORCE DRYING AT 140°F:

PURGE TIME 15 MINUTES
BAKE TIME AT 140°F 40 MINUTES

RECOATING:

2.8 VOC 5 STAR XTREME Alkyd Enamel Intermix Single Stage Color may be recoated after 16-24 hours at 77° F. After 16-24 hours it must be lightly sanded/scuffed before additional color or clearcoat may be applied.

ACCELERATOR & FISHEYE ELIMINATOR:

Accelerator and/or Fisheye Eliminator is not recommended for use in this product.

CLEAN-UP:

Clean spray equipment immediately after use with 5 STAR XTREME Gun Wash, or a high quality lacquer thinner, or compliant solvent depending on area regulations.

TECHNICAL DATA:

Color: Various

Catalyst: #8040

Mixing Ratio (2.8 VOC): 6:1:±20%

Packaged Viscosity 45-55 #2 Zahn

Weight/Gallon 8.5-10.1 lbs./gal

% Weight Solids 40-55%

% Volume Solids 58 ±2.0%

% Gloss 90+ on a 60° glossmeter

Package V.O.C. 2.80 lbs/gal (minus exempt)

Method of Application Spray

Application Viscosity 18-24 Seconds #2 Zahn

Substrate Steel

Curing Conditions Air Dry

Air Dry to Touch 30-60 minutes

Air Dry to Handle 2.5 hours

Dry Film 1.8-2.4 Dry—4.2-5.6 Wet

Recommended

NOTE: 5 STAR XTREME products are not recommended for use in temperatures below 60° F. Use below these temperatures will effect dry times and performance.

FOR PROFESSIONAL USE ONLY**Read SDS Before Use**

The contents of the 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.

SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.

WWW.5STARXTREME.COM

Alkyd Enamel Intermix Color formulas:

WWW.5STARXTREMEINTERMIX.COM