

5 STAR XTREME AUTOBODY PRODUCTS
TECHNICAL DATA INFORMATION
DATED: OCTOBER 2017

HARDENERS DESCRIPTION

#5400C - HI-SOLIDS ACRYLIC LACQUER PRIMER SURFACER, 2.1 VOC

DESCRIPTION

#5400C is a fast drying, high build, and easy sanding Acrylic Primer Surfacer that offers good color holdout, minimal shrinkage, and great adhesion to properly prepared substrates.

PRODUCTS

- **5400C-1** 2.1 VOC Hi-Solids Acrylic Lacquer Primer Surfacer Gray, Gallon
- **5400C-4** 2.1 VOC Hi-Solids Acrylic Lacquer Primer Surfacer Gray, Quart

MIXING RATIO (1:1)

1 part #5400C - Acrylic Lacquer Primer Surfacer to 1 part #5910 –
5 STAR Acetone or LOW VOC High Grade Lacquer Thinner

SURFACE PREPARATION

Clean all areas to be primed with compliant #5903 XTREME Final Wipe - Wax & Grease Remover to remove all dirt, wax, grease, and other contaminants. Featheredge and sand the original finish. Surface must be clean and dry. Apply an etching primer if product is going over bare metal. Note: Rust and oxidation must be removed prior to applying primer by sanding, grinding, or sand blasting.

APPLICATION

Apply 1-3 wet coats to the clean and dry surface. Allow #5400C to flash 5-10 minutes between coats. Final dry film thickness should be 2-2.5 mils. after sanding.

DRY TIMES

30 MINUTES

SUBSTRATES

Treated steel, treated aluminum, fiberglass, body filler, OEM lacquers, OEM enamels

RECOATING

Allow to dry for 30 minutes before sanding. Cool temperatures or high film thickness will extend dry time. Finish sand with 220 grit or finer sandpaper. Sealing is recommended for maximum gloss holdout. When recoating with an enamel, sealing is required. When recoating with Urethane Single Stages and

Basecoats, sealing is recommended for maximum gloss holdout.

TOPCOAT

Primer may be directly topcoated after sanding with most acrylic topcoats.
Sealers are recommended for sealing large areas of primer surfacer to prevent bulls-eyes and for uniform gloss holdout.

TECHNICAL DATA

Color: #5400C - Gray Mix Ratio: 1:1
Reduction: 1: 1 with (Acetone) #5910 or Low VOC High Grade Lacquer Thinner
Viscosity (Sprayable): 17-21 seconds with a #4
Weight Solids (Sprayable): 29%
Volume Solids (Sprayable): 9.93% +/- 0.50%
Film Build @ full wet coat: 1 mil
Coverage: 159 +/- 16 sq. ft. per RTS gallon @ 1 dry mil
Pot Life: No pot life
V.O.C. (Sprayable): 2.1 lbs/gal
Regulatory V.O.C.: 2.0 lbs/gal (246 g/l)
Material V.O.C.: 0.3 lbs/gal (33 g/l)
Disposal & Safety: See SDS for these products
Humidity Resistance: Excellent
Lead/Chromate: This product is Lead & Chromate Free

SAFETY INFO FOR PROFESSIONAL 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. Use only with adequate ventilation. Before opening the packages, read all warning labels. Follow all precautions. The material is designed for application only by professional trained personnel using proper equipment under controlled conditions, and is not intended for sale to the general public.

KEEP OUT OF REACH OF CHILDREN.

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