

5 STAR XTREME AUTOBODY PRODUCTS TECHNICAL DATA INFORMATION

DATED: JULY 2015

PRODUCT NUMBER DESCRIPTION

#50140 - HP QUICK FINISH KLEARKOTE 2.1 VOC

HARDENERS DESCRIPTION

#50142 - HP QUICK FINISH ACTIVATOR 2.1 VOC

DESCRIPTION

Designed to provide the shortest cycle times for maximum efficiency. It flows out to a smooth, durable finish with excellent gloss. Intended for spot, small, 1 panel in size jobs.

BASECOAT

Apply basecoat as per manufacturer's mixing and application instructions. Allow sufficient flash times before applying #50140. Inadequate flash time will affect the performance of the clear.

MIXING RATIO (4:1)

Mix 4 parts #50140 Clearcoat to 1 part #50142 Activator.

SURFACE PREPARATION

1. Allow the final coat of basecoat to dry to touch prior to applying clearcoat.
2. Use a tack cloth to remove any surface contaminants that may have settled on the basecoat.
3. Apply Clearcoat.

APPLICATION

Apply 2-3 full wet coats at 40-50 psi at the gun (6-10 psi when using HVLP at the cap), **NO** flash between coats on large panels. 3-5 minute flash on small panels.

IMPORTANT: NOT FOR USE ON MORE THEN 1 PANEL.

DRY TIMES AT 77° F

DUST FREE 5 - 10 MINUTES

TO SAND 1 HOUR

TO BUFF 1 HOUR OR LESS

DELIVER 2 ½ - 3 HOURS

RECOATING

#50140 may be recoated after an overnight dry at 77° F

BUFFING

2 COATS 45 MINUTES

3 COATS 60 MINUTES

Temperature, humidity and film thickness will affect buff times. If extreme color sanding and buffing is needed allow overnight dry time.

POT LIFE

Pot life will be about 1-2 hours at 77° F.

ACCELERATOR

Not Recommended.

BLENDING

Dry edges can be blended in with the use of a Blend Edge Blender. Refer to the technical data sheet.

FISH EYE

The use of fish eye eliminator is strongly discouraged. If a fish eye additive is needed, use urethane fish eye eliminator, mix 1/2 ounce per sprayable quart. Use no more than necessary as it will directly affect flow out of #50140

EQUIPMENT CLEAN-UP

Clean equipment immediately after use according to local regulations.

TECHNICAL DATA

Mixing Ratio: 4 parts #50140

1 part #50142

Viscosity (RTS): 17-19 seconds #2 Zahn

Volume Solids (RTS): 31.59%

Weight Solids (RTS): 33.52%

Film Build: 1.0 - 1.5 mils per full wet coat

Coverage: 393 sq. ft. per gallon @ 1 dry mil

V.O.C. as Delivered:	Regulatory VOC in LBS./GAL.	Regulatory VOC in G./L.	Material VOC in LBS./GAL.	Material VOC in G./L.
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#50140	1.0	121	0.3	39
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#50142	3.5	422	3.5	422
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V.O.C. (RTS):

#50140/#50142 2.1		253	1.0	115
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Disposal/Safety: see MSDS for this product

Humidity Resistance: Excellent

Salt Spray Resistance Excellent

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 INDUSTRY 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 MSDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.

KEEP OUT OF REACH OF CHILDREN.

ABI – Autobody Brands International a division of IAMG –

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1-87-REFINISH