

5 STAR AUTOBODY PRODUCTS
TECHNICAL DATA INFORMATION
DATED: JULY 2012

PRODUCT NUMBER DESCRIPTION

#5064 – PREMIUM GOLD BODYFILLER GALLON 4/CS

DESCRIPTION: 5 STAR Autobody Products - Premium Gold Body Filler is manufactured with the latest premium resin technology for effortless sanding. This same technology provides superior adhesion to all types of metals including galvanized, bare steel and aluminum. Easy to spread, #5064 is also clog free and tack free. Blue cream hardener is included.

PRODUCT USES: Use for filling and repair of bodywork up to ¼", such as dents, dings, scratches, rust, hail damage and small holes.

TYPICAL SUBSTRATES:

Steel
Aluminum
Fiberglass
Body Filler
Wood
2K Primers
Aged, sanded OEM Topcoats
Galvanized and other zinc-coated steel

SMC – can be used for cosmetic repairs.

For structural repairs prone to high degrees of stress and flexibility, use an SMC repair product.

SURFACE PREPARATION:

1. Clean surface. Remove all dirt, oil, grease and wax with a Wax & Grease Remover.
2. Make sure surface is dry before repairing.
3. Use 40-80 grit disc to featheredge paint for good mechanical adhesion.

MIXING:

For best results, bring filler and provided hardener to room temperature (minimum temperature 75°F). Stir product before dispensing with a bottom to top motion. Knead hardener tube before use. Place a 4" diameter puddle of filler on a clean mixing surface (we recommend a non-absorbent plastic mixing board) and add a ribbon of cream hardener from edge to edge across the center of the filler puddle (puddles larger than 4" will require additional hardener); or measure hardener at 2% by weight of filler – a 50 to 1 ratio. Mix thoroughly with a plastic spreader, using a folding motion, until uniform color is achieved. At room temperature (75°F) approximate setting time is 3 – 5 minutes.

APPLICATION:

1. Using a plastic spreader, apply a thin layer of filler to surface, using firm pressure for maximum adhesion.
2. Apply additional layers, if necessary, building up damaged area higher than surrounding metal surface to allow for sanding of filler.
3. **IMPORTANT! DO NOT RETURN UNUSED MIXTURE TO CAN AS IT WILL HARDEN THE REMAINING CONTENTS.**

FINISHING:

1. When material has cured, in approximately 15 minutes, sand with an 80-120 grit sandpaper.
2. Finish sand with 180-240 grit.

TOPCOATING:

May be topcoated with polyester, 2K urethane or 1K primer. Refer to paint manufacturer's instructions for topcoat application.

TECHNICAL INFORMATION:

Appearance as Packaged:	Gold
VOC	Packaged: 215 g/l - Applied: 0.8 g/l
Weight Per Gallon (Density):	8.45 pounds (Average)
Maximum Recommended Thickness (sanded):	1/4"
Viscosity @ 77°F	94,000 cps (Average)
Gel Time @ 77°F:	3.0 - 5.0 minutes
Shore "D" Hardness Values @ 24 hours:	50 - 55
Sanding Time @ 77o F:	15 - 20 minutes
Catalyst Required:	Benzoyl Peroxide
Catalyzation Ratio:	2% by weight
Exotherm Temperature:	220°F (Average)
Tack Free Time:	10 - 15 minutes
Maximum Heat:	200°F for 30 minutes

HEALTH & SAFETY:

Read all warnings, first aid and safety for all components before using. Keep out of reach of children and animals. Protect hands with impervious rubber gloves. Wear face, skin and eye protection. When sanding, we recommend the use of a respiratory covering device to protect from dust (MSA mask P/N 459029 with MSA cartridge 464029 or equivalent). When using power equipment, refer to power tool manufacturer's recommendations for safety equipment. 5 STAR AUTOBODY PRODUCTS are for industrial use by trained professionals only.

Emergency Medical or Spill Control Information:

In U.S. and Canada call CHEMTREC at 1-800-424-9300