

5 STAR AUTOBODY PRODUCTS®
TECHNICAL DATA INFORMATION
DATED: MARCH 2014

PRODUCT NUMBER DESCRIPTION

#5068 – POLYESTER PREMIUM FINISHING PUTTY (12OZ)

DESCRIPTION:

5 STAR #5068, Polyester Premium Finishing Putty spreads effortlessly and self-levels to a smooth, high density and pinhole free surface that is easy to sand to a seamless featheredge. 5 STAR #5068 contains a new adhesion Additive that speeds the cure and improves adhesion to zinc coated auto body panels. Use 5 STAR #5068 over body filler, sand scratches, pinholes, aged OEM topcoats, steel, aluminum, galvanized steel, fiberglass and other substrates for stain free undetectable repairs.

PRODUCT USES:

Use for minor body work and surface imperfections (1/8" thick or less) such as sand scratches, chips, scratches and pinholes. 5 STAR #5068 is ideal for use as a finish coat over body filler.

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 80 – 180 grit disc to featheredge paint for good mechanical adhesion.

MIXING:

For best results, bring putty and provided hardener to room temperature (minimum temperature 65°F). Knead hardener tube before use. Place a 4" diameter puddle of putty on clean mixing surface; we recommend a non-absorbent plastic mixing board (puddles larger than 4" in diameter will require additional hardener) or, measure hardener 2% by weight - 50 to 1 ratio. Add a ribbon of cream hardener from edge to edge across the center of the putty puddle. Mix thoroughly using a folding motion with a plastic spreader until uniform color is achieved. At room temperature (65°F) approximate setting time is 3-5 minutes.

APPLICATION:

1. Using a plastic spreader, apply a thin layer of putty to surface, using firm pressure for maximum adhesion.
2. Apply additional layers, building up damaged area higher than the surrounding surface to allow for sanding of the putty. Do not apply over fresh or uncured coatings.

FINISHING:

When material has hardened, in approximately 15 minutes, sand with 100 - 180 grit sandpaper followed by 220 - 400 grit if desired.

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:	Aqua
VOC	Packaged: 278 g/l - Applied: 2.2 g/l
Weight Per Gallon (Density):	8 pounds (Average)
Maximum Recommended Thickness (sanded):	1/8"
Viscosity @ 77°F:	10,400 – 15,200 cps
Gel Time @ 77°F:	3.0 – 5.0 minutes
Shore "D" Hardness Values @ 24 hours:	65-75
Sanding Time @ 77° F:	15 minutes
Maximum Heat:	200°F for 30 minutes
Catalyst Required:	Benzoyl Peroxide
Catalyzation Ratio:	2% by weight (50:1 ratio)
Exotherm Temperature:	210°F - 230°F
Tack Free Time:	8 – 10 minutes
Corrosion Resistance:	Excellent

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. or Canada call CHEMTREC at 1-800-424-9300

