

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

PRODUCT NUMBER & COLOR

5410 FRAME BLACK – GLOSS BLACK PAINT FOR CHASSIS 4.6 VOC

DESCRIPTION

#5410 Frame Black is an economical protective coating for chassis, engine compartments, and miscellaneous parts to refinish. It has excellent adhesion and impact resistance. #5410 is resistant to fuels when thoroughly cured using 5 STAR XTREME #5132 Enamel Hardener. Offered in Gloss Black.

NOT SCAQMD 102 & 1151 Rule Compliant.

SURFACE PREPARATION

Prior to repair, wash the surface with mild detergent and hot water, making sure to rinse well and dry with a clean dry cloth. Solvent clean with 5 STAR XTREME #5902 Final Wipe Wax & Grease Remover to remove any contaminants prior to sanding or bodywork. Final sand bare metal with 150 – 220 grit sandpaper. Final sand painted surfaces with 220-320 grit sandpaper. Final clean with 5 STAR XTREME #5902, making sure surface is clean and dry. Final wipe using a tack cloth.

MIXING DIRECTIONS

READY TO SPRAY. NO MIXING REQUIRED.

OPTIONAL MIX BY VOLUME - For Added Durability & Protection

Mix the components in the order and ratio indicated below.

Stir thoroughly after adding each item.

#5410 FRAME BLACK Paint	8 PARTS					MIX RATIO IN OUNCES
#5132 Enamel Hardener	1 PART					MIX RATIO IN OUNCES
COLOR	8	16	24	32	48	64
HARDENER	1	2	3	4	6	8

APPLICATION & DRY TIMES DIRECTIONS

Allow appropriate dry times for primers and sealers. Strain paint prior to application. Apply one medium-wet coat and allow 10 minutes flash or until surface is hand slick. Apply a second full wet coat. For best results, do not apply more than 2 coats.

Disclaimer: #5410 was designed and manufacturer recommended as a ready to spray product. If you choose to brush instead of spray, product may tend to run or sag because it is at a sprayable viscosity. **Try on a test panel first.** You may need to add a slower enamel reducer if product is setting up too quickly and make sure to use a good quality brush.

BAKING - #5410 MUST BE HARDENED IN ORDER TO BAKE OR FORCE DRY

Full Bake Cycle: Allow 30 minutes purge. Bake 30 minutes - 1 hour at 140°F. Allow a 2 hour cool down prior to assembling.

POT LIFE – 6 hours at 75°F (if hardened with 5132). Do not try to thin color after thickening has occurred – do not use. Clean equipment immediately after use.

Note: Accelerators, reducers, and temperature will affect pot life.

COMPATIBLE SUBSTRATES : Bare Steel

GUN SETUPS

	Fluid Tip	Air Pressure
HVLP Gravity.	1.3mm - 1.4mm	6 - 10 PSI at the cap
HVLP Siphon	1.5mm - 1.8mm	6 - 10 PSI at the cap
Con.Gravity	1.3mm - 1.4mm	50 PSI at the gun
Con. Siphon	1.5mm - 1.8mm	50 PSI at the gun

DATA

Dust Free - 20 minutes (will vary with hardener & reducer)

Solvent Resistance - Xylene pass 100 rubs (w/ 5132)

Dry to Handle - 2 hours

Recommended Coats - 2

VOC as applied - 4.6 lbs/gal

DFT per coat - .80 .20 mils

Mixed Volume Solids - 36.62%

Theoretical Coverage - 587 sq. ft @ 1 mil.

DFT Film Hardness - 2H (with #5132 Hardener)

NOTES

Use in shop temperatures that are maintained above 75°F for the first 24-hours of the cure cycle. Ensure surfaces are up to shop temperature prior to work. Ensure proper metal conditioning/preparation procedures in early stages are followed. Use a mixing cup for accurate volume measurements. #5410 will be water resistant in 24-hours.

Note: Do not allow raindrops to dry on a new finish for the first 3 – 4 days to prevent staining.

CLEAN UP

Clean spray equipment immediately after use with Urethane Grade Reducer or 5 STAR XTREME #5214 Virgin Wash Thinner. Do not leave material in spray gun.

DISPOSAL

Dispose of all paint and paint related materials in accordance with state and local regulations.

SAFETY INFORMATION- FOR INDUSTRY USE ONLY

Danger: Vapor harmful. May affect the brain or nervous system causing dizziness, headache, or nausea. May cause eye, skin, nose, and throat irritation. Harmful

if swallowed. **Precautions:** Vapors may ignite explosively. Keep away from heat, sparks, and flame. Vapors may cause flash fire. Do not smoke. Extinguish all flames and pilot lights, and turn off stoves, heaters, electric motors and other sources of ignition during use and until all vapors are gone. Prevent buildup of vapors by opening all windows and doors to achieve cross-ventilation. **Use only with adequate ventilation.** Do not breathe vapor or spray mist. Do not get in eyes, on skin or clothing. Wash thoroughly after handling. Wear solvent resistant gloves. 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. **KEEP OUT OF REACH OF CHILDREN. ABI - Autobody Brands International a division of IAMG - International Autobody Marketing Group. Scottsdale, AZ – www.5starxtreme.com**

NOTE: ABI 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

SEE SDS AND PRODUCT LABELS FOR ADDITIONAL SAFETY INFORMATION.
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