

**5 STAR XTREME AUTOBODY PRODUCTS**  
**TECHNICAL DATA INFORMATION**  
**DATED: OCTOBER 2013**

**PRODUCT NUMBER DESCRIPTION**

#5451 – MAXX FILL 2K™ HIGH BUILD URETHANE PRIMER SURFACER (GRAY) 4.4 VOC

**PRODUCT DESCRIPTION:**

5451 is formulated to provide a fast-drying, high-build film that has maximum adhesion, easy sanding properties and excellent color holdout. 5451 is designed to be used on properly prepared steel, aluminum, iron, fiberglass and previously painted surfaces. This primer surfacer can be topcoated with any paint system. Offered in a Gray color.

**PRODUCTS:**

- **5451-1**            4.4 VOC Primer Gray, Gallon
- **5451-4**            4.4 VOC Primer Gray, Quart
- **5457-4**            4.4 VOC Activator, Quart
- **5457-8**            4.4 VOC Activator, Pint
- **5457-16**          4.4 VOC Activator, Half Pint

**SURFACE PREPARATION:**

Clean all areas to be painted with 5 STAR XTREME #5900 Wax & Grease Remover to remove all dirt, wax, grease and other contaminants. Featheredge and sand original finish. Surface must be clean and dry. Bare metal, galvanized steel, and aluminum should be coated with 5 STAR XTREME #5414 & #5415 Self Etching Primer prior to applying #5451 MAXX FILL 2K High Build Primer.

**MIXING DIRECTIONS:**

**Mix the components in the order and ratio indicated below.**  
**Stir thoroughly after adding each item.**

**HIGH BUILD PRIMER SURFACER**

- 4 PARTS: #5451 Maxx Fill Gray Primer
- 1 PART: #5457 Maxx Fill Activator
- 1 PART: 5 STAR XTREME Urethane Grade Reducer

**EXTRA HIGH BUILD PRIMER SURFACER**

- 4 PARTS: #5451 Maxx Fill Gray Primer
- 1 PART: #5457 Maxx Fill Activator

**TINTED HIGH BUILD PRIMER SURFACER**

- 4 PARTS: #5451 Maxx Fill Gray Primer
- 1/2 PART: Mixing Tint
- 1 PART: #5457 Maxx Fill Activator
- 1 PART: 5 STAR XTREME Urethane Grade Reducer

**APPLICATION & DRY TIME DIRECTIONS:**

Apply 2 full wet coats at 40-50 psi to achieve 3 mils of film that can be sanded and topcoated in 3 hours. Sanding and cure time may be longer depending on thickness of application, tints used and/or temperature. Let each coat flash 5-10 minutes. Better appearance and holdout will be achieved by letting dry overnight prior to sanding and topcoating. It can also be force-dried for 30 minutes at 140°F (60°C) after allowing the final coat to flash 20 minutes. Films in excess of 3 mils should not be force-dried. #5451 should always be sanded before topcoating.

**POT LIFE:**

Pot life of activated primer is approximately 3 hours. Some mixing bases may shorten the pot life. Test your system before proceeding.

**COMPATIBLE BASECOATS:** BASF, Dupont, ICI, PPG, Sherwin Williams, Sikkens, Spies Hecker, Valspar

**GUN SETUPS:**

1.5mm - 2.2 mm for Conventional and HVLP guns

35-45 psi at the gun for Conventional gun

28-35 psi at the gun for HVLP gun

**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.

**FIRST AID:** In case of eye contact, immediately flush eyes with plenty of water for at least 15 minutes and get medical attention. For skin: Wash thoroughly with water. If difficulty in breathing is experienced, get medical attention immediately. If swallowed, do not induce vomiting, get medical attention immediately. See Material Safety Data Sheet.

**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  
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