

5 STAR XTREME AUTOBODY PRODUCTS
TECHNICAL DATA INFORMATION
DATED: APRIL 2013

PRODUCT NUMBER DESCRIPTION

#6115 EuroStar Klearkote - 2.1 VOC | 5 Liters
#6116 EuroStar LOW VOC Activator - Fast - 2.1 VOC | 2.5 Liters
#6117 EuroStar LOW VOC Activator - Medium - 2.1 VOC | 2.5 Liters
#6118 EuroStar LOW VOC Activator - Slow - 2.1 VOC | 2.5 Liters

PRODUCT DESCRIPTION:

#6115 is a Euro 2.1 VOC high solids, tough, durable urethane clearcoat that helps make shops more productive. It provides great gloss direct from the gun, buffing is minimized. Provides high build, dries fast and is easy to spray with excellent flow out and leveling. Use on a variety jobs – from small repairs to overall refinishing.

BASECOAT:

Apply basecoat per manufacture's mixing and application instructions. Allow sufficient flash times before applying #6115 clearcoat. Inadequate flash time will affect the performance of the clear.

MIXING DIRECTIONS:

Mix 2 parts #6115 clear with 1 part #6116, #6117, or #6118 activator by volume. Activator selection should be based on the size of part to be painted and the booth temperature at the time of painting.

APPLICATION DIRECTIONS:

Apply 2-3 full wet coats at 40-50 psi or (6-10 psi when using HVLP at the gun), allowing a 10-15 minute flash between coats.

DRY TIMES AT 77 °F:

DUST FREE
5-10 MINUTES

TACK FREE
20-30 MINUTES

TO BUFF
16-24 HOURS

TO DELIVER
16-24 HOURS

FORCE DRYING:

PURGE TIME
15 MINUTES AT 77° F

BAKE TIME

40 MINUTES AT 140° F

Allow a one to two hour cool-down time before wet sanding or buffing after force drying.

RECOATING:

#6115 clearcoat may be recoated after a 16-24 hour air dry at 77° F or after 1 hour cool down after force drying at 140° F for 40 minutes. After 48 hours, clear must be sanded before recoating.

BUFFING:

Allow at least 16 hours air dry at 77° before buffing, or 1 hour cool down after force drying #6115 clear.

FISHEYE ELIMINATOR:

The use of fisheye eliminator is strongly discouraged.

CLEAN-UP & POTLIFE:

Clean spray equipment immediately after use with gun wash reducer or urethane reducer.

POT LIFE: 1-2 Hours at 77°F.

TECHNICAL DATA:

Temperature, humidity and film thickness will effect buff times.

Clear:2 parts using #6115
Hardeners:1 part #6116, #6117, or #6118
Viscosity (RTS):17 - 22 seconds #2 Zahn
Weight Solids (RTS):41.63%
Film Build:1.0 - 1.4 mils per full wet coat
Coverage:529 sq ft per gallon @ 1 dry mil
Pot Life:1 - 2 hours
V.O.C:2.1 lbs/gal
Disposal/Safety:See MSDS for this product
Humidity Resistance:Excellent
Salt Spray Resistance:Excellent

NOTE: ABI/Autobody Brands International - products are not recommended for use in temperatures below 60° F. Use below these temperatures will effect dry times and performance.

SAFETY INFO:

ALL IMPLIED WARRANTIES WHETHER IT BE OF MERCHANTABILITY AND/OR FITNESS FOR A PARTICULAR PURPOSE ARE EXCLUDED. THIS WARRANTY EXCLUDES ALL INCIDENTAL AND CONSEQUENTIAL DAMAGES.KEEP OUT OF REACH OF CHILDREN. REFER TO MATERIAL SAFETY DATA SHEET. EMERGENCY MEDICAL & SPILL CONTROL: CHEMTREC (800) 424-9300

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