

**5 STAR XTREME AUTOBODY PRODUCTS**  
**TECHNICAL DATA INFORMATION**  
**DATED: SEPTEMBER 2023**

**PRODUCT NUMBER DESCRIPTION**

#5423 – HIGH BUILD 2K **DIRECT TO METAL** PRIMER/FILLER/SEALER  
(WHITE) 2.1 VOC

**PRODUCT DESCRIPTION:**

#5423 is formulated with a hybrid of epoxy and acrylic polymers, which provide excellent adhesion, good corrosion resistance, productive dry times, and ease of sanding.

**Three products in ONE! High Build Primer, Primer Filler & Primer Sealer.**

**PRODUCTS:**

- 5423-1 DTM Primer (WHITE) 2.1 VOC - Gallon
- 5423-4 DTM Primer (WHITE) 2.1 VOC – Quart
- 5426-4 DTM Primer Activator 2.1 VOC - Quart
- 5426-16 DTM Primer Activator 2.1 VOC - Half Pint

**ADDITIONAL OPTIONS:**

- 5424-1 DTM Primer (BLACK) 2.1 VOC - Gallon
- 5424-4 DTM Primer (BLACK) 2.1 VOC – Quart
- 5425-1 DTM Primer (GRAY) 2.1 VOC - Gallon
- 5425-4 DTM Primer (GRAY) 2.1 VOC - Quart

**SURFACE PREPARATION:**

Clean all areas to be primed with compliant Wax & Grease Remover to remove all dirt, wax, grease, and other contaminants. Featheredge and sand the original finish. Surface must be clean and dry.

**Note: Rust and oxidation must be removed prior to applying primer by sanding, grinding, or sand blasting.**

**MIXING DIRECTIONS:**

**HIGH BUILD PRIMER FILLER**

- 4 PARTS #5423 DTM Primer
- 1 PART #5426 Activator

**REGULAR BUILD PRIMER FILLER**

- 4 PARTS #5423 DTM Primer
- 1 PART #5426 Activator
- 1 PART Urethane Reducer - Nat'l Rule  
ZERO VOC Reducer for compliancy

## PRIMER SEALER

- 4 PARTS #5423 DTM Primer
- 1 PART #5426 Activator
- 2 PARTS Urethane Reducer - Nat'l Rule  
ZERO VOC Reducer for compliancy

## APPLICATION:

Spray one to three medium wet coats allowing 10-20 minutes flash between coats.

## POT LIFE:

2-3 hours @ 77° F

## TINTABLE?

The #5423 is **not tintable** with any other paint system but it can be intermixed with Gray #5425 and Black #5424 5 STAR XTREME DTM primer(s).

## ADDITIVES:

ACCELERATOR: N/A

FISHEYE: N/A

FLEX ADDITIVE: Not required

Note: Do not spray when surface temperature is below 50°F

## CLEAN UP:

Clean spray equipment immediately after use with 5 STAR XTREME #5414 Virgin Wash Thinner.

## SUBSTRATES:

- Properly cleaned and sanded aluminum, steel, galvanized steel or sand blasted steel
- Properly cleaned and sanded fiberglass, SMC, E-Coat and OEM finish.

## GUN SETUPS:

AIR PRESSURES			
CONVENTIONAL	CONVENTIONAL @ Gun	PANEL OVERALL	
Gravity Feed 1.6 mm - 2.0 mm	Gravity Feed	30-35 psi	40-45 psi
Siphon Feed 1.8 mm - 2.0 mm	Siphon Feed	30-40 psi	45-55 psi
HVLP 1.6 mm - 2.0 mm	HVLP @ Cap	6-8 psi	8-10 psi

## FLASH/DRY TIMES:

AIR DRY @ 77°F

Flash between coats 10-20 Minutes

To Sand 60-90 Minutes (Surface prepped in 80 to 120 grit)

\* Once the primer has been sanded, there is no need for another coat of primer prior to topcoating.

To Topcoat 30 Minutes\*

**PLEASE NOTE:**

Reduction may accelerate flash times.

\*To Topcoat without sanding - 24 hrs max

\*\* The 24 hour window refers to the amount of time between spraying the primer and topcoating. During this time, it is not mandatory to sand the primer before topcoating. Once the primer sits for longer than 24 hours, it must be sanded for adhesion prior to topcoating.

**TECH DATA:**

VOC Reg: 198 g/l

VOC Actual: 126 g/l

VOC Content: 209.9 g/l / 1.75 lb/gl

Pot Life: 2-3 Hours @ 77°F

Disposal/Safety: See SDS for this product

SHELF LIFE: Primers & Activators (3 years sealed & unopened). Do NOT expose to extreme weather – hot/humid/ cold climates or performance could be compromised.

Batch Codes: First digit year produced (Example 6 = 2016), next two digits Month of the year (Example 04 = April)

**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.**

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