

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

PRODUCT NUMBER DESCRIPTION

#5425 – HIGH BUILD 2K **DIRECT TO METAL** PRIMER/FILLER/SEALER
(GRAY) 2.1 VOC

PRODUCT DESCRIPTION:

5 STAR XTREME #5425 Direct to Metal Primer is a 2K epoxy hybrid product that exhibits anti-corrosion characteristics, excellent adhesion, exceptional filling capabilities, and ease of sanding. The addition of reducer makes it a great 2K sealer, and it's GRAY color provides a neutral base to paint over.

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

PRODUCTS:

- 5425-1 DTM Primer (GRAY) 2.1 VOC - Gallon
- 5425-4 DTM Primer (GRAY) 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:

- 5423-1 DTM Primer (WHITE) 2.1 VOC - Gallon
- 5423-4 DTM Primer (WHITE) 2.1 VOC – Quart
- 5424-1 DTM Primer (BLACK) 2.1 VOC - Gallon
- 5424-4 DTM Primer (BLACK) 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 #5425 DTM Primer
- 1 PART #5426 Activator

REGULAR BUILD PRIMER FILLER

- 4 PARTS #5425 DTM Primer
- 1 PART #5426 Activator
- 1 PART Urethane Reducer - Nat'l Rule
ZERO VOC Reducer for compliancy

PRIMER SEALER

- 4 PARTS #5425 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

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:

#5425 VOC Reg: 204 g/l
#5425 VOC Actual: 142 g/l
#5426 VOC Reg: 458 g/l
#5426 VOC Actual: 271 g/l
VOC Packaged (4:1 Mix) RTS 240 g/l
VOC Spray Applied: 2.1 lbs/gal
VOC Content: 141.0 g/l / 1.18 lb/gal
#5425 Primer (Density) 1.66 gm/cc (13.83#/gal)
#5426 Activator (Density) 1.02 gm/cc (1.02#/gal)
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 Safety Data Sheet.

SAFETY INFORMATION - FOR INDUSTRY USE ONLY

DANGER: Highly flammable liquid and vapour. Causes serious eye irritation. Causes skin irritation. May cause an allergic skin reaction. May cause respiratory irritation. May cause drowsiness or dizziness. Suspected of causing cancer. May damage fertility or the unborn child. **PRECAUTIONS:** Obtain special instructions before use. Do not handle until all safety precautions have been read and understood. Keep away from heat, sparks, open flames or hot surfaces. — No smoking. Take precautionary measures against static discharge. Use only non-sparking tools. Use explosion-proof electrical, ventilating, lighting or equipment. Ground or bond container and receiving equipment. Use only outdoors or in a well-ventilated area. Avoid breathing dust, fume, gas, mist, vapours or spray. Wear protective gloves, protective clothing, eye protection and face protection. Wash thoroughly after handling. Contaminated work clothing must not be allowed out of the workplace. **RESPONSE:** In case of fire: Use for extinction: CO₂, powder or water spray. IF exposed or concerned: Get medical advice or attention. IF INHALED: Remove victim to fresh air and keep at rest in a position comfortable for breathing. Call a POISON CENTER or doctor or physician if you feel unwell. IF IN EYES: Rinse cautiously with water for several

minutes. Remove contact lenses, if present and easy to do. Continue rinsing. Specific treatment (see on this label). Take off contaminated clothing and wash before reuse. If eye irritation persists: Get medical advice or attention. IF ON SKIN (or hair): Remove or take off immediately all contaminated clothing. Rinse skin with water or shower. If skin irritation or rash occurs: Get medical advice or attention. Wash contaminated clothing before reuse. STORAGE: Store locked up. Store in a well-ventilated place. Keep container tightly closed. Keep cool. DISPOSAL: Dispose of contents and container in accordance with local, regional, national, and international regulations. Safety data sheet available on request.

WARNING: Cancer and Reproductive Harm -

www.P65Warnings.ca.gov.

AVERTISSEMENT: Cancer et Harm Reproductive -

www.P65Warnings.ca.gov.

ADVERTENCIA: Cáncer y Daños Reproductivos -

www.P65Warnings.ca.gov

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For Chemical Emergencies/Pour les urgences chimiques/Para Emergencias Químicas Contact CHEMTREC (day or night) at 1-800-424-9300

www.5staradvantage.com 1-87-REFINISH

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