

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

PRODUCT NUMBER DESCRIPTION

#5165 - ORIGINAL FLAT FINISH KLEARKOTE 4.4 VOC

PRODUCT DESCRIPTION:

5 STAR XTREME #5165 "FLAT FINISH" KLEAR is a matte finish clearcoat designed to offer that very popular Old School, no gloss look when used over any color basecoat paint, while offering the UV protection and durability of a standard clearcoat finish.

PRODUCTS:

- 5165-1 Original Flat Finish 4.4 VOC Klearkote, Gallon
- 5165-4 Original Flat Finish 4.4 VOC Klearkote, Quart
- 5187-4 Original 4.4 VOC Medium Activator, Quart
- 5187-16 Original 4.4 VOC Medium Activator, Half Pint
- 5194-4 Original 4.4 VOC Extra Slow Activator, Quart
- 5194-16 Original 4.4 VOC Extra Slow Activator, Half Pint

BASECOAT:

Compatible with most paint manufacturers' solvent and waterborne systems. Apply basecoat as per manufacturer's mixing and application instructions. Allow sufficient flash times before applying #5165. **Inadequate flash time and uneven coats will affect the performance of the clear.**

MIXING RATIO (6:1):

IMPORTANT: PICK UP FLATTENING AGENT FROM BOTTOM WITH STIR STICK, STIR VERY WELL, THEN AGITATE 45 MINS BEFORE POURING.

ALL NEW CUSTOMERS SHOULD SPRAY A TEST PANEL FIRST. APPROVE FINISH, BEFORE CLEARCOATING YOUR PROJECT.

- For temperatures ABOVE 60°F to 75°F (**OR SMALL PANELS**)
Mix 6 parts #5165 FLAT FINISH Klearkote to 1 part #5187 Medium Activator
- For temperatures ABOVE 75°F (**OR LARGE PANELS**)
Mix 6 parts #5165 FLAT FINISH Klearkote to 1 part #5194 Extra Slow Activator

APPLICATION:

Apply 2 **EVEN** wet coats with 75% overlap at 20-30 psi at the inlet allowing a 10-15 minute flash between coats.

NOTE: SPRAY A TEST PANEL BEFORE CLEARCOATING YOUR PROJECT. Spraying slower using a 6 inch fan pattern and 6-8 inches from the panel will help keep a wet edge.

THINGS IMPORTANT to Do:

Shake (agitate) and STIR (stick) well before pouring.
Measure correct amount of Activator.
Observe flash times for proper flat finish.
Apply **EVEN** wet coats. Heavy wet coats will increase the gloss level.
Wash car by hand using plenty of water and a soft sponge.

THINGS NOT to Do:

NOT designed to go over bare metal.

Do NOT use if temperature is under 60°F/15°C.

Do NOT buff, sand, wax or polish surface, as the gloss level will increase.

DRY TIMES AT 77°F:

Flash Time 10-15 mins

DUST FREE 15-20 Minutes

TACK FREE 45 Minutes

TO DELIVER 16-24 Hours (air dry)

FORCE DRYING:

BAKE TIME @ 140°F for 30 Minutes

RECOATING:

#5165 may be recoated after a 24 Hour dry at 77° F, or upon cool down after force drying at 140°F for 30 minutes.

POT LIFE:

Pot life will be about 4-5 hours at 77°F.

CLEAN UP:

Clean equipment immediately using 5 STAR #5700 Premium Lacquer Thinner or #5685 Urethane Reducer.

TECH DATA:

Small Panels/Lower Temps Mixing Ratio: 6 parts #5165: 1 part #5187

Large Panels/Higher Temps Mixing Ratio: 6 parts #5165: 1 part #5194

Viscosity (RTS): 17-19 seconds #2 Zahn

Volume Solids (RTS): 28%

Film Build: 0.8 - 1.0 mils per full wet coat

Coverage: 449 sq. ft. per gallon @ 1 dry mil

Disposal/Safety: see SDS for this product.

Humidity Resistance: Excellent.

Salt Spray Resistance: Excellent

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 –
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