

X T R E M E



5158

Hi-Velocity Klearkote 2.1 VOC

PRODUCT DESCRIPTION:

5158 is a durable medium solids two component polyurethane clearcoat formulated to offer refinishers ease of application, extremely fast dry and polish times, great gloss and excellent distinctness of image. 5158 is compliant under current 2.1 VOC regulations in the United States.

PRODUCTS:

- 5158 **Hi-Velocity Klearkote 2.1 VOC**
- 5162 **Universal Urethane Activator Fast (Spot/Panel Repairs)**
- 5163 **Universal Urethane Activator Medium (Multi Panel/Small Overall)**
- 5164 **Universal Urethane Activator Slow (Small Overall/Larger Overall)**

* Use appropriate urethane reducer if desired. Use of reducer may increase VOC.

SURFACE PREPARATION:

- Apply Undercoats and Basecoat per manufacturer's instruction. Over OEM or completely cured previously painted substrates scuff with a grey scuff pad or 600 grit then wipe clean with an approved solvent or water-borne wipe.
- Allow basecoat adequate flash time (follow manufacturer's recommendation)
- Follow basecoat manufacturer's recommendation for recoat intervals.

MIXING DIRECTIONS:

Mix 4 parts 5158 base with 1 part 5162, 5163, or 5164 by volume. Activator selection should be based on the size of the part to be painted and the temperature of both the air and part at time of painting.

APPLICATION DIRECTIONS:

Number of Coats:	2-4
Application Density	Medium-wet to wet
Overlap	50%
Flash:	Follow recommendations in "Dry Time" section
Film Thickness Range:	Dry 1 mil – 6 mils Wet 3 mils – 6 mils
Application Conditions	Minimum Temp 50°F (Substrate Temp.) Max Temp 100°F (Substrate Temp.) Ambient Humidity Less than 80% preferred

POT LIFE:

When properly covered at 77°F, 5158 will maintain a sprayable viscosity for at least 2 hours depending on activator selection.

ADDITIVES:

ACCELERATOR: N/A

FISHEYE: N/A

FLEX ADDITIVE: Not required

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



X TREM E



5158 Hi-Velocity Klearkote 2.1 VOC

CLEAN UP:

Clean spray equipment immediately after use with gun wash solvent.

SUBSTRATES:

- Commercially available basecoats with a VOC less than 6.3 lbs/gal (SCAQMD rule 1151 Group 1)
- Properly prepared previously painted substrates

GUN SETUPS:

CONVENTIONAL

Gravity Feed	1.3 mm – 1.5 mm
Siphon Feed	1.6 mm – 1.8 mm
HVLP	1.3 mm – 1.6 mm

AIR PRESSURES

Conventional @ Gun	PANEL	OVERALL
Gravity Feed	35-40 psi	.45 psi
Siphon Feed	35-45 psi	.45-50 psi
HVLP @ Cap	6-8 psi	9-10 psi

FLASH/DRY TIMES:

	5162 @ or above 77°F	5163 @ or above 85°F	5164 @ or above 95°F
Flash Between Coats	3-5 min	5-7 min	7-10 min
Dust Free	5-7 min	7-10 min	10-15 min
Sand/Polish	1.5-2.5 hrs	1.5-2.5 hrs	1.5-2.5 hrs

Force Dry (Convection Heat)

	5162	5163	5164
Purge time before applying heat	0-10 min	0-10 min	0-10 min
Force Dry Time	20 min@ 165°F	20 min@ 165°F	20 min@ 165°F
Sand and Buff	After Cool Down	After Cool Down	After Cool Down

TECHNICAL DATA:

Density	9.28 lbs/gal (unactivated)
Solids	
<i>By Weight</i>	37.5%
<i>By Volume</i>	35.2%
VOC (Volatile Organic Content)	2.08 lbs/gal
Viscosity	20 seconds Zahn #2
Flash Point	-4°F
Theoretical Coverage	565 ft ² /gal @ 1 mil thickness

SAFETY INFORMATION - FOR INDUSTRY USE ONLY

Danger: Vapor and spray mist harmful. Overspray may cause lung damage. May cause allergic skin and respiratory reaction, effects may be permanent. Flammable liquid and vapor. Harmful if inhaled. May affect the brain or nervous system causing dizziness, headache, or nausea. May cause eye, skin, nose, and throat irritation.

Contents: See product label for contents and CAS #'s. **The contents of this package must be blended with other components before the product can be used. Any mixture of components will have hazards of all components. Before opening the packages, read all warning labels. Follow all precautions.** 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 Scottsdale, AZ - www.autobodybrands.com

