

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

PRODUCT NUMBER DESCRIPTION

#5165 - ORIGINAL FLAT FINISH KLEARKOTE 4.4 VOC

PRODUCT DESCRIPTION:

#5165 XTREME“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** **4.4 VOC Klearkote, Gallon**
- **5165-4** **4.4 VOC Klearkote, Quart**
- **5187-4** **4.4 VOC Medium Activator, Quart**
- **5187-16** **4.4 VOC Medium 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 will affect the performance of the clear.

MIXING RATIO (6:1):

IMPORTANT: STIR & SHAKE WELL BEFORE POURING

Mix 6 parts #5165 FLAT FINISH Klearkote to 1 part #5187 Activator.

APPLICATION:

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

NOTE: WET COATS WILL PRODUCE MORE GLOSS. DRIER COATS WILL PRODUCE A FLAT FINISH. UNEVEN COATING CAN PRODUCE VARIED GLOSS LEVELS IN THE FINISH.

DRY TIMES AT 77°F:

DUST FREE 15-20 Minutes
TACK FREE 45 Minutes
TO DELIVER 16-24 Hours

FORCE DRYING:

FLASH TIME @ 77° F 15 Minutes
BAKE TIME @ 140° F 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:

Mixing Ratio: 6 parts #5165: 1 part #5187
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 MSDS 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 - AutobodyBrands International a division of IAMG - International Autobody Marketing Group - Scottsdale, AZ - www.autobodybrands.com**