

5 STAR XTREME AUTOBODY PRODUCTS
TECHNICAL DATA INFORMATION
DATED: JULY(Rev) 2015

PRODUCT NUMBER DESCRIPTION
#5185 – ORIGINAL KLEARKOTE 4.4 VOC

PRODUCT DESCRIPTION

5185 is a medium solids two component polyurethane clearcoat with a sprayable VOC of 4.4 lbs/gal. Formulated to offer Refinishers ease of application, great flow and leveling, superior gloss and excellent distinctness of image in a productive 2K polyurethane clearcoat.

PRODUCTS

#5185-1 Original Klearkote, Gallon
#5185-4 Original Klearkote, Quart

*#5186 Original Hardener, Fast 4.4 VOC Quart
*#5187 Original Hardener, Medium 4.4 VOC Quart
*#5188 Original Hardener, Slow 4.4 VOC Quart
* Also available in half pints

CAUTION ACCELERATOR NOT RECOMMENDED

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 #5902 Final Wipe Surface Cleaner. Allow basecoat adequate flash time (follow manufacturer's recommendation) Follow basecoat manufacturer's recommendation for recoat intervals.

MIXING DIRECTIONS

Mix 4 parts 5185 base with 1 part 5186, 5187, or 5188 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

Number of Coats: 2-3	Application Density: full wet coats
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, 5185 will maintain a sprayable viscosity for at least from 3-5 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.

SUBSTRATES

Commercially available basecoats with a VOC of less than 6.6 lbs/gal.
 Properly prepared previously painted surfaces.

CLEAN-UP & STORAGE

Clean spray equipment immediately after use with gun wash solvent.

GUN SETUPS:**CONVENTIONAL**

Gravity Feed 1.3 – 1.5 mm tip

Siphon Feed 1.6 – 1.8 mm tip

HVLP 1.3 mm – 1.5 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

	5186 @ or above 77°F	5187 @ or above 85°F	5188 @ or above 95°F
Flash Between Coats	10-15 min	10-15 min	10-15 min
Dust Free	10-15 min	15 min	15-20 min
Sand/Polish	8-10 hours	10-12 hours	12-14 hours
Force Dry (Convection Heat)	<u>5186</u>	<u>5187</u>	<u>5188</u>
Purge time before applying heat	20 min	20 min	20 min
Force Dry Time	20 min@ 165°F	20 min@ 165°F	20 min@ 165°F
Sand and Buff	After Cool Down		

TECHNICAL DATA

Density: 7.64 lbs/gal (unactivated)

Solids

By Weight: 36.2%

By Volume: 29.0%

VOC (Volatile Organic Content): 4.56 lbs/gal

Viscosity: 17-19 seconds Zahn #2

Flash Point: -4°F

Theoretical Coverage: 465 sq ft per gal @ 1 mil thickness

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: 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 professional 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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