

**5 STAR XTREME AUTOBODY PRODUCTS**  
**TECHNICAL DATA INFORMATION**  
**DATED: JULY 2015**

**PRODUCT NUMBER DESCRIPTION**

#5173 - ORIGINAL SPEED KLEARKOTE 2.1 VOC

**PRODUCT DESCRIPTION:**

5173 is a medium solids two component urethane klearkote formulated to offer Refinishers ease of application, great flow and leveling, superior gloss and excellent distinctness of image in a highly productive 2K urethane klearkote. Under proper conditions 5173 can be polished in as little as 90 minutes.

**PRODUCTS:**

- **5173-01**                      **Original Speed Klearkote 2.1 VOC – Gallon**
  - **5173-04**                      **Original Speed Klearkote 2.1 VOC – Quart**
  
  - **\*5181-04**                      **Original Activator Fast 2.1 VOC – Quart**
  - **\*5182-04**                      **Original Activator Medium 2.1 VOC – Quart**
  - **\*5183-04**                      **Original Activator Slow 2.1 VOC – Quart**
- \* Also available in half pints**

**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 #5173. Inadequate flash time will affect the performance of the clear.

**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 5173 base with 1 part 5181, 5182, or 5183 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:**        2-3
- Application Density:**    Full wet coats
- Overlap:**                50%
- Flash:**                    Follow recommendations in "Dry Time" section

**Film Thickness Range:**

- Dry                            1 mil – 4 mils
- Wet                            3 mils – 4 mils

**Application Conditions**

- Minimum Temp            50°F (Substrate Temp.)
- Max Temp                 100°F (Substrate Temp.)
- Ambient Humidity        Less than 80% preferred

**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 compliant gun wash solvent.

**SUBSTRATES:**

Commercially available basecoats with a VOC less than 6.6 lbs/gal 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 – 1.5 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:**

	<b>5181 @ or above 77°F</b>	<b>5182 @ or above 85°F</b>	<b>5183 @ or above 95°F</b>
Flash Between Coats	5-10 min	5-10 min	5-10 min
Dust Free	10-15 min	10-15 min	10-15 min
Sand/Polish	1.5-2 hours	1.5-2 hours	1.5-2 hours
<b>Force Dry (Convection Heat)</b>			
Purge time before applying heat	<b>5181</b> 0-15 min	<b>5182</b> 0-15 min	<b>5183</b> 0-15 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:**

VOC (Volatile Organic Content)	2.1 lbs/gal
Viscosity	17-19 seconds Zahn #2
Flash Point	-4°F
Film Build	1.0 mils per full wet coat
Theoretical Coverage	531 ft <sup>2</sup> /gal @ 1 mil thickness
Solids (Ready to Spray)	
<i>By Volume</i>	33.1%

**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 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**

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