

★★★★★

#5425 XTREME HIGH BUILD 2K PRIMER/FILLER/SEALER 3-in-1 (GRAY) 2.1 VOC

Product Description

XTREME #5425 is formulated with a hybrid of epoxy and acrylic polymers, which provide excellent adhesion, good corrosion resistance, productive dry times, and ease of sanding.

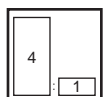
Products

	Gallon	Qty/Cs.	Quart	Qty/Cs.	Half Pint	Qty/Cs.
• XTREME High Build 2K Primer/Filler/Sealer 3-in-1(Gray) #5425-1	2	#5425-4	6			
• Primer Activator		#5426-4	6	#5426-16	12	



Surface Preparation

Clean all areas to be primed with compliant Wax & Grease Remover to remove all dirt, wax, grease, and other contaminants. Featheredge and sand the original finish. Surface must be clean and dry. Note: Rust and oxidation must be removed prior to applying primer by sanding, grinding, or sand blasting.

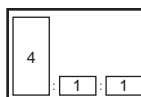


Mixing Directions

High Build Primer Filler

- 4 PARTS XTREME #5425 DTM Primer
- 1 PART XTREME #5426 Activator

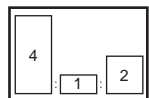
Note: 2.0mm gun setup is recommended for this mix ratio



Regular Build Primer Filler

- 4 PARTS XTREME #5425 DTM Primer
- 1 PART XTREME #5426 Activator
- 1 PART Urethane Reducer - Nat'l Rule Acetone - California

Note: 1.7mm gun setup is recommended for this mix ratio



Primer Sealer

- 4 PARTS XTREME #5425 DTM Primer
- 1 PART XTREME #5426 Activator
- 2 PARTS Urethane Reducer - Nat'l Rule Acetone - California

Note: 1.5mm gun setup is recommended for this mix ratio



Application

Spray one to three medium wet coats allowing 10-20 minutes flash between coats.



Clean-up & Storage

Clean spray equipment immediately after use with 5 STAR #5700 or #5700C

Substrates

- Properly cleaned and sanded aluminum, steel, galvanized or sand blasted steel, fiberglass, SMC, E-Coat and OEM finish.

Gun Setups

CONVENTIONAL

Gravity Feed 1.5 mm – 2.0 mm

Siphon Feed 1.7 mm – 2.0 mm

HVLP 1.5 mm – 2.0 mm

AIR PRESSURES

Conventional @ Gun

Gravity Feed

Siphon Feed

HVLP @ Cap

PANEL

30-35 psi

30-40 psi

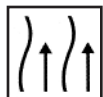
6-8 psi

OVERALL

40-45 psi

45-55 psi

8-10 psi



Flash/Dry Times

AIR DRY @ 77 degrees F

Flash between coats: 10-20 Minutes

To Sand: 60-90 Minutes

To Topcoat : 30 Minutes*

*To Topcoat without sanding - 24 hrs max

Please Note:

Reduction may accelerate flash times.



Technical Data

Volume Solids: 41.6%

Pot Life: 2-3 Hours @ 77 degrees F

VOC Coating: 1.9 lbs. per gallon

VOC Material: 1.4 lbs. per gallon

Disposal/Safety: See MSDS for this product