



# #5451 MAXX-FILL HIGH BUILD 2K PRIMER SURFACER (GRAY) 4.4 VOC

## Product Description

#5451 is formulated to provide a fast-drying, high-build film that has maximum adhesion, easy sanding properties and excellent color holdout. #5451 is designed to be used on properly prepared steel, aluminum, iron, fiberglass and previously painted surfaces. This primer surfacer can be topcoated with any paint system. Offered in a Gray color #5451 can also be tinted.

## Products

**Gallon Qty/Cs. Quart Qty/Cs. Half Pint Qty/Cs.**

- Maxx-Fill High Build 2K Primer Surfacers (Gray) 4.4 VOC #5451-1 4 #5451-4 6
- Maxx-Fill 2K Activator #5457-4 6 #5457-16 12

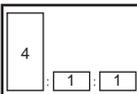


## Surface Preparation

Clean all areas to be painted with 5 STAR #5900 Wax & Grease Remover to remove all dirt, wax, grease and other contaminants. Feather edge and sand original finish. Surface must be clean and dry. Bare metal, galvanized steel, and aluminum should be coated with 5 STAR #5414 & #5415 Self Etching Primer prior to applying #5451 Maxx-Fill High Build 2K Primer Surfacers.

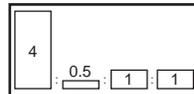
## Mixing Directions

Mix the components in the order and ratio indicated below. Stir thoroughly after adding each item.



### High Build Mixture

- 4 PARTS #5451 MAXX FILL Gray Primer
- Mixing or Tinting Base (Not Required)
- 1 PART 5 STAR Urethane Grade Reducer
- 1 PART #5457 MAXX FILL Activator



### Tinting Mixture

- 4 PARTS #5451 MAXX FILL Gray Primer
- 1/2 PART Mixing or Tinting Base
- 1 PART 5 STAR Urethane Grade Reducer
- 1 PART #5457 MAXX FILL Activator



## Application Directions

Apply 2 full wet coats at 40-50 psi to achieve 3 mils of film that can be sanded and topcoated in 3 hours. Sanding and cure time may be longer depending on thickness of application, tints used and/or temperature. Let each coat flash 5-10 minutes. Better appearance and holdout will be achieved by letting dry overnight prior to sanding and topcoating. It can also be force-dried for 30 minutes at 140°F (60°C) after allowing the final coat to flash 20 minutes. Films in excess of 3 mils should not be force-dried. #5451 should always be sanded before topcoating.



## Clean-up & Storage

Clean spray equipment immediately after use with Urethane Grade Reducer or 5 STAR #5700 Virgin Wash Thinner. Do not leave material in spray gun.

## Substrates

Properly prepared steel, aluminum, iron, fiberglass and cured previously painted surfaces.

## Gun Setups

**CONVENTIONAL** 1.5 mm - 2.2 mm  
**HVLP** 1.8 mm - 2.5 mm

## AIR PRESSURES

**CONVENTIONAL @ Gun** 35-45 psi  
**HVLP @ Gun** 28-35 psi



## Flash/Dry Times

Flash Between Coats: 5-10 minutes

## Air Dry @ 77°F

To Sand: 3 hours  
 To Topcoat: 3 hours



## Technical Data

Mixing Ratio (Primer Filler): 4:1:1 - 4 parts primer to 1 part activator to 1 part urethane grade reducer  
 Pot Life: 1 hour  
 Disposal/Safety: See MSDS for this products  
 VOC Coating: 4.4 lbs/gallon (ready to spray)