



# #5453 MAXX-FILL HIGH BUILD 2K PRIMER SURFACER (BUFF) 4.4 VOC

## Product Description

#5453 is formulated to provide a fast-drying, high-build film that has excellent adhesion, easy sanding properties and excellent color holdout. It 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 Buff (Yellow) color.

## Products

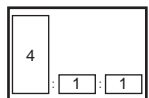
- Maxx-Fill High Build 2K Primer Surfacers (Buff) 4.4 VOC
- Maxx-Fill 2K Activator

Gallon	Qty/Cs.	Quart	Qty/Cs.
#5453-1	4	#5457-4	6



## 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 galvanized steel and aluminum should be coated with 5 STAR #5414 and #5415 Self-Etch Primer prior to applying #5453 Maxx-Fill High Build 2K Primer Surfacers.



## Mixing Directions

Mix 4 parts #5453 primer with 1 part #5457 activator, and 1 part 5 STAR Urethane Grade Reducer (available in fast, medium, and slow). Stir thoroughly after adding each item.



## Application

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 6-8 hours 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. #5453 Maxx-Fill High Build 2K Primer Surfacers must always be sanded before topcoating.



## Clean-up & Storage

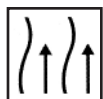
Clean spray equipment immediately after use with 5 STAR #5700 Virgin Wash Thinner or Urethane Grade Reducer. Do not leave material in spray gun.

## Gun Setups

CONVENTIONAL	1.5 mm – 2.2 mm
HVLP @ Gun	1.5 mm – 2.2 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
VOC Coating:	4.4 lbs/gallon (ready to spray)
Disposal/Safety:	See MSDS for this product