

Frame Black

Gloss Black Paint for Chassis

**READY
TO SPRAY**



#5410

Optional Mix Ratio



#5410 - 4.6 VOC

NOT SCAQMD 102 & 1151 Rule Compliant

5410 is an economical protective coating for chassis, engine compartments, and miscellaneous parts to refinish. It has excellent adhesion and impact resistance. 5410 is resistant to fuels when thoroughly cured using 5 STAR #5132 Enamel Hardener. Offered in gloss black.

5410 FEATURES

- 4.6 VOC
- Ready to Spray!
- Gloss Black
- Excellent Adhesion
- Superior Impact Resistance
- Fast Drying

4.6 VOC FRAME BLACK
Gloss Black Paint for Chassis
#5410-1 Gallon

If Desired:
Synthetic Enamel Hardener
#5132-8 Pint

OPTIONAL MIX BY VOLUME: For Added Durability & Protection

Mix the components in the order and ratio indicated below. Stir thoroughly after adding each component. Pot life will be approximately 4-6 hours at 75° F (if hardened with #5132).

Mixing Ratio: 8: 1 8 parts - #5410 Frame Black (Gloss Black Paint for Chassis)
1 part - #5132 Enamel Hardener

MIX RATIO IN OUNCES

COLOR	8	16	24	32	48	64
HARDENER	1	2	3	4	6	8



DISTRIBUTED BY:

Call 1-87REFINISH (1-877-334-6474) to find your local 5 Star Autobody Products supplier. Or visit our website: www.autobodybrands.com

©2007 ABI-Autobody Brands International a division of IAMG-International Autobody Marketing Group
Part # 5410 Updated 9/07



Frame Black

Gloss Black Paint for Chassis



PRODUCT DESCRIPTION:

5410 Frame Black is an economical protective coating for chassis, engine compartments, and miscellaneous parts to refinish. It has excellent adhesion and impact resistance. 5410 is resistant to fuels when thoroughly cured using 5 STAR #5132 Enamel Hardener. Offered in Gloss Black. **NOT SCAQMD 102 & 1151 Rule Compliant.**

PRODUCTS & COLOR:

- 5410-1 4.6 VOC Frame Black (Gloss Black Paint for Chassis) Gallon

SURFACE PREPARATION:

Prior to repair, wash the surface with mild detergent and hot water, making sure to rinse well and dry with a clean dry cloth. Solvent clean with 5 STAR #5902 Final Wipe Wax & Grease Remover to remove any contaminants prior to sanding or bodywork. Final sand bare metal with 150 – 220 grit sandpaper. Final sand painted surfaces with 220-320 grit sandpaper. Final clean with 5 STAR #5902, making sure surface is clean and dry. Final wipe using a tack cloth.

MIXING DIRECTIONS:

READY TO SPRAY. NO MIXING REQUIRED

OPTIONAL MIX BY VOLUME - For Added Durability & Protection

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

#5410 FRAME BLACK Paint **8 PARTS**
#5132 Enamel Hardener **1 PART**

MIX RATIO IN OUNCES

COLOR	8	16	24	32	48	64
HARDENER	1	2	3	4	6	8

APPLICATION & DRY TIME DIRECTIONS:

Allow appropriate dry times for primers and sealers. Strain paint prior to application. Apply one medium-wet coat and allow 10 minutes flash or until surface is hand slick. Apply a second full wet coat. For best results, do not apply more than 2 coats.

BAKING - 5410 MUST BE HARDENED IN ORDER TO BAKE OR FORCE DRY

Full Bake Cycle: Allow 30 minutes purge. Bake 30 minutes - 1 hour at 140°F. Allow a 2 hour cool down prior to assembling.

POT LIFE:

4 – 6 hours at 75°F (if hardened with 5132). Do not try to thin color after thickening has occurred – do not use. Clean equipment immediately after use. Note: Accelerators, reducers, and temperature will affect pot life.

COMPATIBLE SUBSTRATES:

Bare Steel

GUN SETUPS:

HVLP Gravity	1.3mm - 1.4mm
HVLP Siphon	1.5mm - 1.8mm
Con. Gravity	1.3mm - 1.4mm
Con. Siphon	1.5mm - 1.8mm

Fluid Tip

Air Pressure

6 - 10 PSI at the cap
6 - 10 PSI at the cap
50 PSI at the gun
50 PSI at the gun

DATA:

Dust Free - 20 minutes (will vary with hardener & reducer)
Dry to Handle - 2 hours
VOC as applied - 4.6 lbs/gal
Mixed Volume Solids - 36.62%
Film Hardness - 2H (with 5132 Hardener)

Solvent Resistance - Xylene pass 100 rubs (w/ 5132)
Recommended Coats - 2
DFT per coat - .80± .20 mils
Theoretical Coverage - 587 sq.ft @ 1 mil. DFT

NOTES:

Use in shop temperatures that are maintained above 75°F for the first 24-hours of the cure cycle. Ensure surfaces are up to shop temperature prior to work. Ensure proper metal conditioning/preparation procedures in early stages are followed. Use a mixing cup for accurate volume measurements. 5410 will be water resistant in 24-hours. Note: Do not allow raindrops to dry on a new finish for the first 3 – 4 days to prevent staining.

CLEAN UP:

Clean spray equipment immediately after use with Urethane Grade Reducer or 5 STAR #5414 Virgin Wash Thinner. Do not leave material in spray gun.

DISPOSAL:

Dispose of all paint and paint related materials in accordance with state and local regulations.

SAFETY INFORMATION - FOR INDUSTRY USE ONLY

Danger: Vapor harmful. May affect the brain or nervous system causing dizziness, headache, or nausea. May cause eye, skin, nose, and throat irritation. Harmful if swallowed. **Precautions:** Vapors may ignite explosively. Keep away from heat, sparks, and flame. Vapors may cause flash fire. Do not smoke. Extinguish all flames and pilot lights, and turn off stoves, heaters, electric motors and other sources of ignition during use and until all vapors are gone. Prevent buildup of vapors by opening all windows and doors to achieve cross-ventilation. **Use only with adequate ventilation.** Do not breathe vapor or spray mist. Do not get in eyes, on skin or clothing. Wash thoroughly after handling. Wear solvent resistant gloves. 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 OF CHILDREN. ABI - Autobody Brands International a division of IAMG - International Autobody Marketing Group. Scottsdale, AZ - www.autobodybrands.com**