



Montana Big Sky™ PS501X 2K Urethane Primer/Sealer



COMPONENTS

PS501X Primer/Sealer
PS5012B Urethane Primer
Activator
TH03X Zero VOC Reducer



APPLICATION

Primer: 2 coats with 5-10
minute flash
Sealer: 1 coat with 30-45
minute flash



MIX RATIO

Primer: 4 : 1
Sealer: 4 : 1 : 1



DRY TIME

Primer: To sand – 2 hours
Sealer: To topcoat – 30-45
minutes



VISCOSITY

N/A



VOC

252 grams / liter
2.1 lbs / gallon



GENERAL

DESCRIPTION

Montana Big Sky™ PS501X is a 252 grams/liter (2.1 lbs/gallon) VOC, two component urethane primer that complies with VOC Regulations. This primer is designed to provide high film build, easy sanding and excellent color holdout. PS5011™, PS5012A™ & PS5015™ may be mixed together to optimize hiding. They are chromate free and can be used as a primer surfacer or sealer. This primer/sealer meets the guidelines for Rule 1156.

COLOR

- PS5011 White
- PS5012A Gray
- PS5015 Black

COMPATIBLE SUBSTRATES

- Properly cleaned and conditioned steel, aluminum, and galvanized steel
- PS3009 ViperGrip II Metal Etch Primer Rule 1156 Compliant
- Thoroughly sanded OEM
- Thoroughly sanded and cured paint
- Cured body filler (the use of stain free body fillers on light colors will reduce the chance of yellowing)
- Sanded fiberglass (apply 1-coat of Epic Prime epoxy primer prior to 2.1 VOC for maximum adhesion.)

The products referenced herein may not be sold in your market. Please consult your distributor for product availability.



MIXING

COMPONENTS



As a Primer

Mix 4 parts 2.1 VOC Urethane Primer with 1 part PS5012B Urethane Primer Activator.

- 4:1 mix yields a heavy build of 2.5 mils \pm 0.5 per coat
- A 10% reduction, using Zero Voc Reducer Series, may be desired for better level & flow.

Component

Volume

Montana Big Sky PS501X Primer
Montana Big Sky PS5012B Activator

4
1

As a Sealer

Mix 4 parts 2.1 VOC Urethane Primer with 1 part PS5012B Urethane Primer Activator and 1 part TH035, TH036 or TH037 Zero VOC Reducer Series.



Component

Volume

Montana Big Sky PS501X 2K Primer
Montana Big Sky PS5012B Primer Activator
Montana Big Sky TH035, TH036 or TH037 Zero VOC Reducer

4
1
1

POT LIFE

Catalyzed Primer

1 hour at 75°F/23°C.

Sealer

1½ hours at 75°F/23°C

Note: Accelerator, reducer, and temperature will affect pot life. Clean equipment immediately after use.



APPLICATION

APPLICATION EQUIPMENT

High Build Primer

HVLP Gravity	1.4 - 1.6 mm	6 – 10 PSI	*At the cap
High Efficiency	1.4 - 1.6 mm	17 – 32 PSI	At gauge

Sealer

HVLP Gravity	1.4 - 1.6 mm	8 – 10 PSI	*At the cap
High Efficiency	1.4 - 1.6 mm	27 – 32 PSI	At gauge

NOTE: Refer to spray gun manufacturer for further information regarding HVLP Inlet Pressures

SURFACE PREPARATION

NOTE: Be sure to completely remove all rust or oxidation prior to applying primer.

- Solvent clean with a Strong Wax & Grease Remover. Featheredge with P180- P320 grit sandpaper. Sand the existing areas with P400 grit sandpaper. Large bare Metal areas should be sprayed with etch primer prior to priming.
- A Strong Wax & Grease Remover and a red scuff pad may be used to remove light surface oxidation on aluminum. Follow by re-cleaning the aluminum to remove sanding residue with a Strong Wax & Grease Remover.



Sealer Option

- Solvent clean with a Strong Wax & Grease Remover.
- Sand repair areas, finishing with P400 grit sandpaper or finer.
- Re-clean repair with TH5951™ Mild Wax & Grease Remover to remove sanding residue before sealing.



APPLICATION

As a Primer:

Apply over properly prepared surfaces. Apply in single full wet coats, allowing 5 -10 minute flash between coats. For best results, do not apply more than 3 coats.



As a Sealer:

Apply 1 single wet coat of properly mixed 2.1 VOC Urethane Sealer to create a uniform base. Allow to flash for 30 – 45 minutes before applying topcoats.

BRUSHABLE/ROLLABLE OPTION

Mix according to directions. Apply 1 even coat of 2.1 VOC Urethane Primer, making sure to cover the repair area completely into the featheredge. If a 2nd coat is applied, allow a 5 -10 minute flash between coats. Apply the 2nd coat within ¾ inch of the first coats outer edge. For best results, do not apply more than 3 coats.

COMPATIBLE TOPCOATS

- Acrylic Urethanes
- Acrylic Enamels
- Polyurethane Color
- Basecoat Color
- Synthetic Enamels

CLEAN-UP

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner. Dispose of all paint and paint related materials in accordance with state and local regulations.



DRY TIMES

AIR DRY
@75°F/23°C

To Sand

To Topcoat

Primer: 1.5 – 2 hours

Sealer: does not require sanding

Primer: within 4-6 hours after sanding

Sealer: 30-45 minutes

**DRY TIME TO SAND****Primer Option**

- Primer must be sanded prior to topcoating.
- Air Dry: 1 ½ - 2 hours at 75°F/23°C per coat before sanding.
- If 3 coats are applied, allow to dry overnight.
- Baking: Allow a 15 minute flash, then bake at 150°F/65°C for 45 minutes. Allow to cool before sanding.
- Infrared: Allow a 15 minute flash, then bake at 140°F/60°C for 20 minutes. Allow to cool before sanding.

Sealer Option

- Does not require sanding prior to topcoat unless 2.1 VOC urethane primer has dried for longer than the recommended recoat time.
- If not topcoated within 4 hours, scuff with gray scuff pad or P600 grit sandpaper. Then clean and apply color.

DRY TIME TO TOPCOAT**Primer Option**

- Primer must be sanded before topcoating.
- 2.1 VOC urethane primer does not require sealing, except to make a uniform color base. Finish sand with P600 grit sandpaper when not using a sealer.
- Topcoat within 4 - 6 hours after sanding.
- If 2.1 VOC urethane primers has set for longer than the recommended recoat time, re-sand with P600 grit sandpaper, or finer, for maximum adhesion.

Sealer Option

- 30 – 45 minutes at 75°F/23°C prior to topcoating.



PHYSICAL PROPERTIES**Mix 4:1**

Film Thickness	2.0 ± 0.5 mils per coat
Volume Solids	40.6%
VOC Applied	2.10 (252 g/L)
Theoretical Coverage RTS	652 sq. ft. @ 1 mil DFT
# of Coats	2

Mix 4:1:1

Film Thickness	1.2 ± 0.5 mils per coat
Volume Solids	33%
VOC Applied	2.10 (252 g/L)
Theoretical Coverage RTS	530 sq. ft. @ 1 mil DFT
# of Coats	1

STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C).



VOC REGULATED AREAS

VOC as Applied

252 grams/liter | 2.1 lbs/gallon

These directions refer to the use of products which may be restricted or require special mixing instructions in VOC regulated areas. Follow mixing usage and recommendations in the VOC Compliant Products Chart for your area.

SAFETY AND HANDLING

For industrial use only by professional, trained painters. Not for sale to or use by the general public. Before using, read and follow all label and SDS precautions. If mixed with other components, mixture will have hazards of all components.

Ready to use paint materials containing isocyanates can cause irritation of the respiratory organs and hypersensitive reactions. Asthma sufferers, those with allergies and anyone with a history of respiratory complaints must not be asked to work with products containing isocyanates.

Do not sand, flame cut, braze or weld dry coating without a NIOSH approved air purifying respirator with particulate filters or appropriate ventilation, and gloves.

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In the United States and Canada:

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