




Montana Big Sky™ PE1501 2K 2.1 VOC Speed Clear



PE1501 2K Speed Clear
MP1570, MP1580 Activator

COMPONENTS




2 coats
1-5 minutes flash
between coats

APPLICATION




4 : 1

MIX RATIO



To Hand Slick – 5-10 minutes
To Polish – 45-60 minutes
To Compound – 2-4 hours

DRY TIME



230 grams / liter
1.92 lbs / gallon

VOC



GENERAL

DESCRIPTION

Montana Big Sky PE1501 2K 2.1 VOC Speed Clear may be used for spot and panel application over properly applied basecoat color. This two-component clear is designed for fast setting, dust free dry times and delivers outstanding gloss with low overspray. PE1501 2K Speed Clear may increase productivity by maximizing vehicle throughput and may be polished as soon as 45 minutes - 1 hour.

COMPATIBLE SUBSTRATES

- Refinish basecoat color
- OEM B/C and Enamel Finishes properly prepared
- Cured, aged refinishes properly sanded

Note: Do not use over lacquer topcoat color

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



MIXING

COMPONENTS

Mix 4 parts PE1501 2K 2.1 VOC Speed Clear with 1 part activator.

Component	Volume
Montana Big Sky PE1501 2K 2.1 VOC Speed Clearcoat	4
Montana Big Sky MP1570 or MP1580 Activator	1



ACTIVATOR SELECTION

	<u>Panel</u>	<u>Multi-Panel</u>
MP1570 Medium	60-80°F / 15-26°C	60-75°F / 15-23°C
MP1580 Slow	75-100°F / 23-37°C	75-95°F / 23-35°C

POT LIFE

1 hour at 75°F (24°C)



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 - 1.4 mm	6 – 8 PSI	at the cap
High Efficiency	1.3 - 1.4 mm	22 – 26 PSI	at the gauge

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

SURFACE PREPARATION

PE1501 Clear is designed to be applied over properly sprayed basecoat color.

APPLICATION

Allow basecoat to properly dry according to suggested dry times and spray conditions. Apply one medium to full wet coat of clear and allow 1 – 5 minute flash or until surface is hand slick. Apply a second coat of clear. Do not apply more clearcoat after 1-hour of applying previous coats of clearcoat.

RECOATING

Due to the strength of some reducers, care needs to be taken if new color coat is going to be applied over fresh clearcoat. Allow clearcoat to dry 24 hours at 75°F (24°C) prior to reapplying color coat. If a full break through of clearcoat occurs while making a repair, lightly apply color using a fast flashing reducer. It may be necessary to create a barrier using a catalyzed primer to avoid lifting on the repair edge. Re-clearing may be done as soon as 8 hours or up to 24 hours without having to scuff the clearcoat.

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 Hand Slick	5-10 minutes
Dust Free	10-15 minutes
To Polish	45-60 minutes
To Compound	2-4 hours
Cure	7 days

*Do not expose to rain for the first 24 hours when air dried. Excessive moisture on fresh clearcoat can cause a milky appearance within the film.



FORCE DRY

Do not bake clear prior to outdoor exposure.



PHYSICAL PROPERTIES

Avg. DFT per Coat	1.0 mil ± 0.20
Recommended Total DFT	2.0-2.3
Flash Point	See SDS

STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (49°C).

VOC REGULATED AREAS

All values ready to spray.

VOC	1.911 lbs./gallon (228.99 g/L)
Volume Solids	32.93%
Weight Solids	35.34%
VOC as Applied	230 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:
1.855.6.AXALTA
MontanaBigSky.us

