






# Montana Big Sky™ PE2300 2K 2.1 VOC Acrylic Urethane Clearcoat



**COMPONENTS**  
PE2300 Clearcoat  
MP2365, MP2375, MP2385  
or MP2395 Hardener



**APPLICATION**  
2 - 3 coats  
10-15 minute flash  
between coats




**MIX RATIO**  
2 : 1



**DRY TIME**  
To Polish – 6-8 hours  
To Compound – 10-12 hours



**VISCOSITY**  
N/A



**VOC**  
252 grams / liter  
2.1 lbs / gallon



## GENERAL

### DESCRIPTION

Montana Big Sky PE2300 2K 2.1 VOC Acrylic Urethane Clearcoat is designed to provide a deep rich gloss with premium durability. Using quality urethane technology, this clearcoat offers the versatility needed for spot, multi-panel and overall refinishing, while providing quick delivery and ease of use.

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



## MIXING

### COMPONENTS

Mix 2 parts PE2300 Clearcoat with 1 part MP23X5 Hardener. Optional 10% reduction with TH035, TH036 or TH037 Zero VOC Urethane Reducer

Component	Volume
Montana Big Sky PE2300 2.1 VOC Clearcoat	2
Montana Big Sky MP23X5 Hardener	1

### HARDENER SELECTION

- MP2365 Fast 63-75°F / 17-23°C
- MP2375 Medium 75-85°F / 23-29°C
- MP2385 Slow 85°F + / 29°C +
- MP2395 Extra Slow 95°F + / 35°C +



**SPECIALTY COMPONENTS**

- CR22FEE Fisheye Eliminator
- TH035, TH036 or TH037 Zero VOC Urethane Reducer
- TH01000 Edge Blender
- SP40 Universal Matting Base

**Accelerator** – Not recommended.

**Fisheye Eliminator** – If needed, add 1 – 2 ounces of CR22FEE per ready-to-spray gallon (or ¼ - ½ ounce per ready-to-spray quart).

**POT LIFE**

3 hours at 75°F/23°C




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**APPLICATION**

**APPLICATION EQUIPMENT**

HVLP Gravity	1.3 - 1.4 mm	8 – 10 PSI	*At the cap
High Efficiency	1.3 - 1.4 mm	27 – 32 PSI	At gauge

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

**SURFACE PREPARATION**

Properly applied basecoat.

**APPLICATION**

Allow basecoat to dry for 30 minutes or longer if manufacturer suggests longer dry times. Single stage colors may require longer flash times, usually 1 – 1 ½ hours longer. Apply one medium-wet coat and allow 10 – 15 minute flash. Apply 2 medium coats. Do not apply more clear after 1 hour of applying previous coats of clear. Apply 2 full coats of clear for proper film build and protection (2.0 mils dry film minimum). Excessive amounts of clear will retard drying, curing, and may cause die-back.

**RECOATING**

Due to the strength of some reducers, care needs to be taken if new color coat is going to be applied over fresh clear. Allow clear to dry overnight at 75°F/23°C prior to reapplying color coat. If a full break through of clear is done while making a repair, lightly apply color using a faster flashing reducer. In temperatures below 75°F/23°C, the use of a heat lamp will help cure the break through edge so lifting will be minimized. Re-clearing may be done as soon as 16 hours or up to 72 hours without having to scuff clear. If clear is in the first 30 - 45 minutes of dry time, and color needs to be sprayed due to metallic shift or inadequate hiding, apply a light coat of color to achieve desired hide, then re-clear. Avoid excessive film builds.

**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.




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**DRY TIMES**

**AIR DRY**

**@75°F/23°C**

Dust Free	20 minutes
To Polish	6-8 hours
To Compound	10-12 hours
Cure	7 days



**FORCE DRY**

Bake 30 – 35 minutes at 140°F/60°C. No purge time is necessary.

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**PHYSICAL PROPERTIES**

RTS VOC	2.1 lbs./gallon (252 g/L)
RTS Volume Solids	33%
RTS Weight Solids	36%
DFT per Coat	1.0 mil ± 0.20
Direct Impact	60 ft/lbs
Reverse Impact	30 ft/lbs
Chemical Resistance	MEK pass 100 double rubs Xylene pass 100 rubs
Flash Point	See SDS

**WEATHERING DATA**

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

**STORAGE CONDITIONS**

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

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**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.

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**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:  
**1.855.6.AXALTA**  
**montanabigsky.us**

