





Montana Big Sky™ PS340X 2K 2.1 VOC DTM Primer Surfacers



COMPONENTS

PS340X DTM Primer Surfacers
PA3400M/PA3400S Activator
TH03X Zero VOC Reducer Series



APPLICATION

Primer: 2-3 coats with 5-10 minute flash
Sealer: 1 coat with at least 30 minute flash




MIX RATIO

4 : 1 : 1 or
4 : 1 : 1/2




DRY TIME

To Sand – 45 minutes to 1 hour



VISCOSITY

N/A



VOC

252 grams / liter
2.1 lbs / gallon



GENERAL

DESCRIPTION

Montana Big Sky PS340X 2K 2.1 VOC DTM Primer Surfacers is a non-isocyanate, chromate-free, direct-to-metal (DTM) primer designed to provide optimum adhesion with excellent corrosion protection on bare metals and OEM substrate. These primers may be used as a medium or high build primer-surfacer that easily sands by hand or machine, while offering superior color holdout and gloss retention for fast, high quality finishes. This product meets the most stringent VOC requirement of 2.1 lbs/gallon.

COLOR

- PS3401 White
- PS3403 Gray
- PS3405 Black

COMPATIBLE SUBSTRATES

- Properly cleaned and conditioned steel, stainless, aluminum, galvanized steel, copper, and brass.
- Thoroughly sanded OEM and cured paint.
- Cured and sanded body filler.
- Sanded Fiberglass and SMC.
- Properly prepared Rigid plastic.

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



MIXING

COMPONENTS

As a Normal Build Surfacer/Sealer

Mix 4 parts PS340X with 1 part PA3400M/S DTM Activator and 1 part TH035/36/37 Zero VOC Reducer Series.

- Average per coat film build 1.0 - mils (Mixed 4:1:1)

Component	Volume
Montana Big Sky PS340X 2.1 VOC DTM Primer/Surfacer	4
Montana Big Sky PA3400M/PA3400S DTM Activator (PA3400M Medium, PA3400S Slow)	1
Montana Big Sky TH035/36/37 Zero VOC Reducer Series	1

As a High Build Surfacer

Mix 4 parts PS340X with 1 part PA3400M/S DTM Activator and 1/2-1 part TH035/36/37 Zero VOC Reducer Series.

- Average per coat film build 2.0 mils approximately. (Mixed 4:1:1/2)
- Only two coats are suggested due to increased film builds, or extend dry times for a third coat.

Component	Volume
Montana Big Sky PS340X 2.1 VOC DTM Primer/Surfacer	4
Montana Big Sky PA3400M/PA3400S DTM Activator (PA3400M Medium, PA3400S Slow)	1
Montana Big Sky TH035/36/37 Zero VOC Reducer Series	1/2

- It is recommended to use activators within 14 days of opening to maintain maximum performance. Replace lids on all paint products immediately after use to avoid moisture or oxygen contamination.

TINTING

DTM primers may be blended together to achieve various shades of the gray scale for better coverage. No other tints or toners may be added. Do not mix with paint. See chart below for shading recommendations.

PS3401	PS3401 & PS3403 MIX 2:1	PS3401 & PS3403 MIX 1:2	PS3403	PS3403 & PS3405 MIX 2:1	PS3403 & PS3405 MIX 1:2	PS3405
Light Colors Very LT Colors Light Yellows Whites Silvers	Pastel Green Med. Yellow Light Tan Med. Silver Pastel Blue	Green Dark Silver Med. Light Tan Med. Light Red Med. Light Blue	Med. Red Med. Brown Med. Green Med. Blue Med. Gray	Dark Red Dark Brown Dark Blue Dark Green Med. Dark Gray	Dark Green Dark Blue Dark Brown Dark Red Dark Gray	Deep Dk Red Deep Dk Brown Deep Dk Green Deep Dk Blue Black

POT LIFE

2 hours at 75°F/23°C. Note: Warmer temperatures will shorten pot life. Clean Equipment immediately after use.



APPLICATION

APPLICATION EQUIPMENT

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

Be sure to completely remove rust or oxidation prior to applying primer. Rust and oxidation can be removed by media blasting, grinding, or sanding. Liquid metal cleaners may be used followed by the appropriate metal conditioner for optimum adhesion and corrosion protection. Be sure all surfaces are free of waxes, oils, grease or other contaminants. Wash painted surfaces and plastic parts with detergent and hot water. Clean metal and painted surfaces with a Wax & Grease Remover or Zero VOC Waterborne Surface Cleaner. Clean bare plastics with AP100 Plastic Cleaner before sanding; Steel: Finish sand with 80 - P180 grit sandpaper. Aluminum, Galvanized, Stainless Steel: Sand with P320 grit sandpaper or scuff using a red scuff pad to remove light oxidation and abrade the surface. Due to certain metal inconsistencies, we suggest using the appropriate metal conditioner for optimum adhesion. SMC, Fiberglass: Finish sand with P180 to P240 grit sandpaper. Bare Plastic: Use a gray or red scuff pad with a scuffing agent. Rinse with water to remove residue. Re-clean all sanded substrates with their appropriate plastic cleaners and apply adhesion promoter before applying primer. Pre-painted Substrates: After proper cleaning; Sand repair area and featheredge as needed, finish the featheredge with P320 grit sandpaper. Final sand the area surrounding the repair and featheredge using P400 or finer sandpaper. Re-clean repair with the appropriate surface cleaner to remove sanding residue before priming.

APPLICATION

As a Primer:

Apply in single wet coats, allowing 5 - 10-minute flash at 75°F/23°C between coats. For normal build, apply 2 - 3 coats, depending on desired film build. For high build, we suggest 2 coats maximum. If three coats are applied, allow for overnight drying. Body filler may be applied 2 hours after a single coat of PS3401/PS3403/PS3405 has been applied. 2 mils minimum final film is needed to provide good corrosion protection

Do not use over soluble substrates, Etch primers, lacquer primer or lacquer finishes.

As a Sealer:

Apply single coat and allow to flash for a MINIMUM of 30 minutes and apply colorcoat. Topcoat must be applied within a 3-hour timeframe or it must be sanded and recoated with the same product or sanded. Do not Bake

BRUSHABLE/ROLLABLE OPTION

Mix according to directions. Note: The use of slower reducers will increase flow and leveling. Apply 1 even coat of PS3401/PS3403/PS3405, making sure to cover the repair area completely into the featheredge. Before the 2nd coat is applied, allow a 10 minute flash between coats. Apply the 2nd coat within the previous coats outer edge. For best results, do not apply more than 3 coats.

COMPATIBLE TOPCOATS

- Properly cleaned steel, aluminum, galvanized steel, fiberglass and SMC.
- Thoroughly scuffed OEM E-coat and sanded cured paint.
- Cured, sanded body filler.
- Properly prepared rigid plastic.

Note: Do not use over lacquer primer or lacquer finishes.



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	45 minutes to 1 hour
To Topcoat	Primer: 45-60 minutes to 3 hours Sealer: 30 minutes to 3 hours

DRY TIME TO SAND

Primer Option (Allow for proper flash time between coats during application). Air Dry: 45 minutes to 1 hour per coat at 75°F/23°C. Overnight for 3 coats using high build 4:1:1/2 mix. Bake: 20 minute flash followed with 140°F/0°C for 15 - 20 minutes. Infrared short wave: Allow to flash 20 minutes then 5 minute per coat air dry or low power heat, followed by a 5 minute per coat bake using full power @ 150°F/65°C. Final sand with P400 to P600 grit sandpaper and topcoat within 24 hours. If Primer or sealer stands for more than 3 hrs product must be sanded. If Baking occurs, primer **MUST** be sanded prior to topcoat followed by application of 2K urethane sealer.

DRY TIME TO TOPCOAT

After sanding and cleaning steps are completed. As Sealer - 30 minutes up to 3 hours. After 3 hours, product must be sanded. As a Primer - 1 coat 45 - 60 minutes up to 3 hours without sanding if desired. Topcoat within 4 -6 hours after sanding. Longer time requires a re-scuff. Not recommended for use on plastic.



PHYSICAL PROPERTIES

Mix 4:1:1/2

Film Thickness	2.0 ± 0.5 mils per coat
Volume Solids	40.2%
VOC Applied	2.10 (252 g/L)
Theoretical Coverage RTS	646 sq. ft. @ 1 mil DFT
Flash Point	See SDS

Mix 4:1:1

Film Thickness	1.5 ± 0.4 mils per coat
Volume Solids	36.8%
VOC Applied	2.10 (252 g/L)
Theoretical Coverage RTS	392 sq. ft. @ 1 mil DFT
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 (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:
1.855.6.AXALTA
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