





# Montana Big Sky™ System 18 Acrylic Enamel Color System




**COMPONENTS**  
System 18 Color  
MP1050 Catalyst  
TH03X Series Zero VOC  
Urethane Reducer




**APPLICATION**  
1 medium wet coat + 1 - 2 full wet coat 15-minute flash between coats; if 3<sup>rd</sup> coat, 20-minute flash between coats




**MIX RATIO**  
8 : 1 : 3



**DRY TIME**  
Dust Free – 60 minutes  
To Handle – Overnight  
To Compound – 24 - 36 hours



**VISCOSITY**  
N/A



**VOC**  
419 grams / liter  
3.50 lbs / gallon



## GENERAL

### DESCRIPTION

This system is a high solids, 3.5 lbs/gal VOC Acrylic Enamel. Montana Big Sky System 18 is an easy-to-use, economical coating designed to provide good gloss and resistance to weathering. System 18 has fast dry times and good coverage – an excellent choice when a quality economical finish is needed.

### COMPATIBLE SUBSTRATES

- Sanded OEM Finishes
- Cured, Aged Finishes
- PS5011/PS5012A/PS5015 2.1 VOC 2K Primer/Surfacer

Note: These substrates may be directly topcoated; however, we suggest sealing prior to color coating for optimum results.

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



## MIXING

### COMPONENTS

Mix 8 parts System 18 Color to 1 part MP1050 Catalyst to 3 parts TH4000 Series Acrylic Enamel Reducer.

Component	Volume
Montana Big Sky System 18 Color	8
Montana Big Sky MP1050 Catalyst	1
Montana Big Sky TH3X Series Zero VOC Urethane Reducer	3



Mix Ratio in Ounces						
<b>Color</b>	8	16	24	32	48	64
<b>Catalyst</b>	1	2	3	4	6	8
<b>Reducer</b>	3	6	9	12	18	24

**REDUCER SELECTION**

- TH035 Fast 65-70°F / 18-21°C
- TH036 Medium 70-85°F / 21-29°C
- TH037 Slow 85°F + / 29°C +

**SPECIALTY COMPONENTS (OPTIONAL)**

- CR22ACC Accelerator
- CR22FEE Fisheye Eliminator

Accelerator: If needed, use 1 – 2 ounces of CR22ACC Accelerator per ready-to-spray gallon (or ¼ - ½ ounce per ready-to-spray quart). Note: System 18 must be activated in order for accelerator to be effective. Do not use accelerator when temperature exceeds 90°F/32°C. Over acceleration can cause solvent popping and brittle paint. Do not use accelerator if baking. If temperatures are boarding 68°F/20°C or cooler, we strongly recommend the use of CR22ACC at a level of 1 – 2 ounces per ready-to-spray gallon.

Fisheye eliminator: If needed, add 1 – 2 ounces of CR22FEE per ready-to-spray gallon (or ¼ - ½ ounce per ready-to-spray quart). Only use CR22FEE Fisheye Eliminator as other brands may be incompatible. Overuse may cause sagging or loss of gloss.

**POT LIFE**

6 hours @75°F/23°C

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.




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**APPLICATION**

**APPLICATION EQUIPMENT**

HVLP Gravity	1.3 - 1.6 mm	8 – 10 PSI	*At the cap
High Efficiency	1.3 - 1.6 mm	27 - 32 PSI	At gauge

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

**SURFACE PREPARATION**

**Overall or Full Panel Repair**

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 TH5950 Strong Wax & Grease Remover, TH5951 Mild Wax & Grease Remover or TH5953 Zero VOC Waterborne Surface Cleaner, to remove any contaminants prior to sanding or bodywork. Make all repairs – treat bare metals and prime with appropriate Montana Big Sky primers and sealers. When using a sealer, final sand with P320 grit sandpaper or finer. When topcoating over sanded substrates, finish sand with P400 - P800 grit sandpaper. Final clean with TH5951 Mild Wax & Grease Remover or TH5952 Fast Evaporating Final Cleaner, making sure surface is clean and dry. Final wipe using a tack cloth prior to applying sealer or color.

**Blend Repair Area**

Note: System 18 is designed for overall refinishing but may be blended in some cases. Detergent wash, solvent clean, and thoroughly sand past the blend area using P1500 – P2000 grit sandpaper. The use of a gray nylon scuff pad or scuff gel is also acceptable. Make necessary repairs following product directions. Re-clean using TH5952 Fast Evaporating Final Cleaner before applying color. Final wipe using a tack cloth prior to applying sealer or color.



## APPLICATION

### As an overall or full-panel repair

Allow appropriate dry times for primers and sealers. Confirm color match is appropriate by testing color prior to application. Strain paint prior to application. Apply one medium-wet coat and allow 15 – 20-minute flash or until surface is hand slick. Apply a 2nd full wet coat. If a 3rd coat is needed, allow 20-minute flash between 2nd and 3rd coat. For best results, do not apply more than 3 coats. If metallics are being applied, apply one fog coat immediately after last coat, holding the spray gun back an additional 2" – 3". Raising the air pressure a few pounds will help even out metallics.

### Blending Color

Use a tack cloth to final wipe repair area.

Apply System 18 until hiding. Apply each coat beyond prior coat, keeping within the sanded blend area. Allow proper flash between coats.

### One Gun Method (to reduce blend edge):

If needed, over-reduce the pre-mixed color 2:1 – this will help extend out the color.

Lowering the air pressure while choking the fluid volume can help blend color and reduce overspray.

### Two Gun Method (to reduce blend edge):

With a second spray gun, apply light coats of blending solvent, or TH4700, or TH0885

Reducer on the paint edge to help melt in the blend. Be sure to stay within the sanded area. Do not over-wet the edge.

## BUFFING

### Compounding / Polishing

For aggressively removing sand scratches and to flatten and level the paint surface. For use on longer air-dried or fully baked color coats. Air dry: 24 - 36 hours at 75°F/23°C then proceed with heavy compounding or buffing. The use of accelerator will reduce buffing times slightly. Or use Full Bake Cycle and allow a 1 – 2 hours cool down prior to heavy compounding or buffing. Use P1500 grit sandpaper or finer to nib sand or to reduce orange peel. Finish sand with P2000 grit sandpaper or finer, then use a quality polishing system. Polish within the first 5 days of color application. Polishing Blends: Allow color to cure and dry according to recommendations. Follow with a light buff using a quality polishing system over the blend edge. Do not aggressively compound blend edges. Note: If System 18 is not catalyzed, buffing cannot be done for 30 days.

## RECOATABILITY (IF CATALYZED WITH MP1050)

Allow a 24 – 36 hour cure time before re-working of color. The use of a heat lamp will accelerate the cure cycle for re-repairs. Allow overnight cure before taping area for two-tone work. Re-coating may be done as soon as 16 hours or up to 72 hours without having to scuff System 18. Un-catalyzed enamels cannot be re-worked for 30 days.

## SPECIAL NOTES

Use in shop temperatures that are maintained above 75°F/ 23°C 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. Air pressure dramatically affects the lightness and darkness of metallic colors. Catalyzed System 18 will be water resistant in 24 hours. Do not allow raindrops to dry on a new finish for the first 3 – 4 days to prevent staining.

If Muriatic Acid is used to clean painted equipment, use a lead-free formula or clearcoat to avoid staining and for additional protection. The use of MP1050 is not necessary – reduce System 18 by 25% - 35% and apply according to application directions. This will reduce durability, chemical resistance, and re-work properties. If early sun exposure is expected, MP1050 Catalyst should be used to avoid wrinkling.



## DRY TIMES

### AIR DRY

@ 75°F/23°C

Dust Free	60 minutes
Dry to Handle	Overnight
To Buff/Compound	24 - 36 hours
Cure	7 days

### FORCE DRY

System 18 must be catalyzed in order to bake or force dry. Allow 30 minutes purge. Bake 30 minutes – 1 hour at 130°F/54°C. Allow a 2 hour cool down prior to assembling or buffing.



## PHYSICAL PROPERTIES

Direct Impact	30 ft/lbs
Reverse Impact	15 ft/lbs
Solvent Resistance	MEK pass 50 rubs
RTS VOC	3.50 lbs/gallon (max)
RTS Volume Solids	35.00 – 40.00%
Theoretical Coverage	562 Sq. Ft.
Film Hardness	2H
DFT per Coat	1 mil + .20
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 419 grams/liter | 3.50 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.

Revised: May 2019

In the United States and Canada:

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

