





# Montana Big Sky™ System 35 Polyurethane Color System



**COMPONENTS**

System 35 Color  
PO35AN or PO35AS Hardener  
Opt: TH03X Zero VOC  
Urethane Reducer




**APPLICATION**

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




**MIX RATIO**

3 : 1




**DRY TIME**

Dust Free – 60 – 90 Minutes  
To Buff/Compound – 24 - 72 hours



**VISCOSITY**

N/A



**VOC**

419 grams / liter  
3.50 lbs / gallon



## GENERAL

### DESCRIPTION

Montana Big Sky System 35 is a 3.5 lbs/gal VOC compliant high-solids single-stage polyurethane coating designed for durability and excellent chemical resistance. With a deep high gloss finish, System 35 provides excellent flow, leveling and flexibility, good color holdout, and is both impact and UV resistant – it even stands up to Skydrol®.

### COMPATIBLE SUBSTRATES

- Sanded OEM Finishes
- Cured, Aged Finishes
- EZ543 EZ-Fill Acrylic Primer Surfacer (sealed)
- PS3042/ PS3044 / PS3045 Epoxy Prime
- PS5008A / PS5009A Urethane Primer/Sealer
- 2.1 VOC Montana Big Sky Primers

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 3 parts System 35 Color to 1 part PO35AN or PO35AS Hardener.  
Optional ½ part reduction with TH03X Zero VOC Urethane Reducer

Component	Volume
Montana Big Sky System 35 Color	3
Montana Big Sky PO35AN or PO35AS Hardener	1



Mix Ratio in Ounces						
<b>Color</b>	3	9	12	15	24	48
<b>Activator</b>	1	3	4	5	8	16
<b>Reducer</b>	0.5	1.5	2	2.5	4	8

**HARDENER SELECTION**

- PO35AN Hardener
- PO35AS Hardener

**REDUCER SELECTION**

- Optional 1/2 part reduction with TH03X Zero VOC Urethane Reducer

**SPECIALTY COMPONENTS (OPTIONAL)**

- PE35ACC Accelerator
- CR22FEE Fisheye Eliminator
- TH03X Zero VOC Urethane Reducer

Accelerator: Do not use accelerator when temperatures exceed 90°F/32°C. If temperatures are bordering 68°F/20°C or cooler, we strongly recommend the use of PE35ACC at a level of 1 – 2 ounces per ready-to-spray gallon. The use of PE35ACC will extend pot life and increase cure rate by approximately 4 hours.

Fisheye eliminator: If needed, add 1 – 2 ounces of CR22FEE per ready-to-spray gallon (or 1/4 - 1/2 ounce per ready-to-spray quart). Only use CR22FEE Fisheye Eliminator as other brands may be incompatible.

**POT LIFE**

1-2 hours @75°F/23°C

We suggest mixing only enough product for a single coat. Clean equipment immediately.

Note: Accelerators, reducers and temperature will affect pot life.




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**APPLICATION**

**APPLICATION EQUIPMENT**

HVLP Gravity	1.3 - 1.5 mm	8 – 10 PSI	*At the cap
High Efficiency	1.3 - 1.5 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 or TH5951 Mild Wax & Grease Remover 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.

**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 20 minute flash. Apply a 2nd full wet coat. If a 3rd coat is needed, for color hiding, allow 20 minute flash between 2nd and 3rd coat, and apply a light 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 35 until hiding. Apply each coat beyond prior coat, keeping within the sanded blend area. Allow proper flash between coats. If a clearcoat is being applied, use over full panel beyond color blend, following clearcoat directions.

#### **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 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**

**Note:** Due to variations in compounds, polishes, and buffing pads, refer to the product manufacturer for suggested use of their products. Always use a quality color coat polishing system.

#### **Light Polishing**

For removing minor imperfections, such as fine dust, dirt, or debris. Best used for blend edges, under cured or soft fresh color. The use of accelerator will allow early polishing in approximately 10 – 12 hours at 75°F/23°C. Color may be somewhat soft. Care must be taken when doing early polishing.

#### **Compounding (not recommended for metallic colors)**

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 – 72 hours at 75°F/23°C then proceed with heavy compounding or buffing. Or use Full Bake Cycle and allow a 4 hour 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.

#### **RECOATABILITY**

When clearcoating, do not sand System 35 except for small spots (to remove dirt or debris). Then re-apply another light color coat – proceed with applying clear following the clearcoat directions. Allow a 24 hour cure time before re-working of clearcoated 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 un-accelerated System 35.

#### **COMPATIBLE CLEARCOATS (OPTIONAL)**

In conjunction with a good, quality Polyurethane Clearcoat. Top coating – Properly activated Polyurethane Clear may be applied directly over System 35 Color. Allow solid colors to flash 20 – 30 minutes before clearcoating. Allow metallic colors to flash 30 – 45 minutes before clearcoating, to avoid metallic shift. Follow manufacturer's directions for application

#### **SPECIAL NOTES**

Use in shop temperatures that are maintained above 75°F/23°C for the first 24 hours of the cure cycle. System 35 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 Muratic Acid is used to clean painted equipment, use a lead free formula or clearcoat to avoid staining and for additional protection.



## DRY TIMES

### AIR DRY

@ 75°F/23°C

Dust Free  
Dry to Handle  
To Polish  
To Buff/Compound  
Cure

Approximately 60-90 minutes  
Overnight  
See light polishing data  
24 hours  
7 days

### FORCE DRY

Bake 60 minutes at 145°F/62°C. Allow a 10-15 minute purge. Allow a 4-hour cool down prior to assembling or buffing. Do not bake color when using accelerator.



## PHYSICAL PROPERTIES

Direct Impact	80 ft/lbs
Reverse Impact	50 ft/lbs
Solvent Resistance	MEK pass 100 rubs, Xylene pass 100 Rubs
Chemical Resistance	Acid (HCL) 10% – No Effect Sulfuric 5% - No Effect Phosphoric 42.5% - No Effect
RTS VOC	3.50 bs/gallon (max)
Mixed Volume Solids	48.50 – 52.00% (dependant on color)
Theoretical Coverage	800 Sq. Ft.
Film Hardness	2H
DFT per Coat	1.00 – 1.50 mils
Flash Point	See SDS
Skydrol (24 hour submersion)	500 B-4 – No Effect

Note: Do not allow raindrops to dry on a new finish for the first 3 – 4 days to prevent staining.

### 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.



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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  
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