





Montana Big Sky™ EZ543 EZ-Fill Acrylic Primer Surfacers



COMPONENTS
EZ543 Acrylic Primer Surfacers
TH03X Zero VOC Reducer




APPLICATION
2-3 medium coats
5-10 minute flash between coats




MIX RATIO
1 : 1-1¼



DRY TIME
To Sand – 20-30 minutes



VISCOSITY
N/A



VOC
549 grams / liter
4.58 lbs / gallon



GENERAL

DESCRIPTION

Montana Big Sky EZ-Fill Acrylic Primer Surfacers offers high build, fast dry times and easy sanding characteristics. EZ-Fill EZ543 is designed to provide good color holdout, minimal shrinkage, and powerful adhesion to properly prepared substrates.

COLOR

- EZ543 Gray

COMPATIBLE SUBSTRATES

- Properly cleaned and conditioned steel, aluminum, and galvanized steel
- Thoroughly sanded and cured paint
- Cured body filler (The use of stain free body fillers on light colors will reduce the chance of yellowing.)
- Montana Big Sky branded Metal Etch Primers

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



MIXING

COMPONENTS

Mix 1 part EZ543 Acrylic Primer Surfacers with 1-1¼ parts TH03X Zero VOC Reducer

Component	Volume
Montana Big Sky EZ543 Acrylic Primer Surfacers	1
Montana Big Sky TH035/36/37 Zero VOC Reducer	1-1¼



SOLVENT SELECTION

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

POT LIFE

No pot life restrictions. Occasional stirring may be needed to keep a uniform mix. Keep lid on container to prevent solvent evaporation.



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.6 - 1.8 mm	6 – 8 PSI	*At the cap
High Efficiency	1.6 - 1.8 mm	17 – 19 PSI	At gauge

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

SURFACE PREPARATION

NOTE: Be sure to completely remove all rust or oxidation prior to applying primer. Rust and/or oxidation can be removed by sand blasting, grinding, or sanding.

- Solvent clean with TH5950 Strong Wax & Grease Remover or TH5951 Mild Wax & Grease Remover.
- Sand area to be primed with P180 - P320 grit sandpaper as required for a proper repair.
- Re-clean to remove sanding residue with TH5950 Strong Wax & Grease Remover.
- TH5950 Strong Wax & Grease Remover and a red scuff pad may be used to remove light surface oxidation on aluminum. Follow by re-cleaning the aluminum to remove sanding residue with TH5950 Strong Wax & Grease Remover.

APPLICATION

Apply over properly prepared surfaces. Apply 2 – 3 medium coats, allowing 5 – 10-minute flash between coats. For best results, do not apply more than 3 coats before sanding, then reapply if needed.

Brushable/Rollable Option (small repair areas)

Mix per directions. Apply 1 even coat of EZ543 Acrylic Primer Surfacer, making sure to cover the repair area completely into the featheredge. If a second coat is applied, allow a 5 - 10 minute flash between coats. Apply the second coat within ¾ inch of the first coat’s outer edge. For best results, do not apply more than 3 coats.

COMPATIBLE TOPCOATS

- Acrylic Urethanes
- Sealer
- Basecoat Color
- Acrylic Enamels
- Synthetic Enamels * (recommend sealing first)
- Polyurethane Color

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

20-30 Minutes

To Topcoat

Must be sanded first

NOTE: Recommended minimum dry film thickness after sanding is 2.0 – 2.5 mils.



PHYSICAL PROPERTIES

Film Thickness	1.1 ± 0.2 mils per coat
Volume Solids	18%
VOC Applied	4.58 lbs/gal (549 g/L)
# of Coats	2
Flash Point	See SDS
Theoretical Coverage	289.5 sq ft/gallon

NOTE: Do not expose to rain for the first 24 hours when air dried. Excessive moisture on fresh clear can cause a milky 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).

VOC REGULATED AREAS

VOC as Applied 549 grams/liter | 4.58 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
montanabigsky.us

