Montana Big Sky™ FE40 Chassis Black Frame Paint

COMPONENTS	FE40 Chassis Black TH5000 Series Synthetic Enamel Reducer Optional: MP2000 Catalyst
APPLICATION	1 medium coat + 1 full wet coat 10 minute flash between coats or until surface is hand slick
MIX RATIO	4 : 1 or 8 : 1 : 2
DRY TIME	To handle – 2 hours
VISCOSITY	N/A
VOC	599 grams / liter 5.0 lbs / gallon

GENERAL

DESCRIPTION

Montana Big Sky FE40 Chassis Black is an economical protective coating for chassis, engine compartments, and miscellaneous parts refinishing. It has excellent adhesion and impact resistance. FE40 is resistant to fuels when thoroughly cured using MP2000 Catalyst.

COMPATIBLE SUBSTRATES

- Bare Steel
- PS3042/PS3044/PS3045 Epoxy Prime

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

MIXING

COMPONENTS

Mix 4 parts FE40 Chassis Black Frame Paint with 1 part TH5000 Series Synthetic Enamel Reducer

Component	Volume
Montana Big Sky FE40 Chassis Black Frame Paint	4
Montana Big Sky TH5000 Series Synthetic Enamel Reducer	1

OPTIONAL MIX BY VOLUME – FOR ADDED DURABILITY & PROTECTION

Montana Big Sky FE40 Chassis Black Frame Paint	8
Montana Big Sky MP2000 Catalyst	1
Montana Big Sky TH5000 Series Reducer	2

REDUCER SELECTION

- TH5800 Fast 60 - 75°F / 16-24°C
- TH5900 Medium 75 -85°F / 24-29°C
- TH5700 Slow 85°F + / 29°C +

POT LIFE

- 4 – 6 hours at 75°F/23°C (if catalyzed with MP2000)
- 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.

APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.4 - 1.6 mm	6 – 10 PSI	*At the cap
High Efficiency	1.4 - 1.6 mm	17 – 32 PSI	At gauge

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

SURFACE PREPARATION

- 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.
- Final sand bare metal with P150 - P220 grit sandpaper. Finish sand painted surfaces using P220 – P320 grit sandpaper.
- Final clean with TH5951 Mild Wax & Grease Remover, making sure surface is clean and dry.
- Final wipe using a tack cloth.

APPLICATION

Allow appropriate dry times for primers and sealers. Strain paint prior to application. Apply one medium-wet coat and allow 10 minute flash or until surface is hand slick. Apply a 2nd full wet coat. For best results, do not apply more than 2 coats.

SPEICAL 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.
- FE40 will be water resistant in 24 hours. **Note:** Do not allow raindrops to dry on a new finish for the first 3 – 4 days to prevent staining.

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

Dust Free	20 minutes (will vary with catalyst and reducer)
To Handle	2 hours

FORCE DRY

FE40 must be catalyzed in order to bake or force dry.
Allow 30 minute purge. Bake 30 minutes – 1 hour at 140°F/60°C. Allow a 2 hour cool down prior to assembling.

PHYSICAL PROPERTIES

Mixed 4:1

Recommended Coats	2
Solvent Resistance	Xylene pass 100 rubs (with MP2000)
VOC as Applied	5.00 lbs./gallon
DFT per Coat	0.80 ± 0.20 mils
Mixed Volume Solids	25%
Theoretical Coverage	402 square feet @ 1 mil DFT
Film Hardness	2H (with MP2000 Catalyst)

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	599 grams/liter | 5.0 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