





Montana Big Sky™ PE1900 2K Lightspeed Clearcoat




COMPONENTS
PE1900 Clearcoat
MP1965, MP1975, MP1985 or
MP1995 Hardener




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




MIX RATIO
4 : 1



DRY TIME
To Hand Slick – 3-5 minutes
To Polish – 2 hours
To Compound – 6-8 hours



VISCOSITY
N/A



VOC
507 grams / liter
4.23 lbs / gallon



GENERAL

DESCRIPTION

Montana Big Sky PE 1900 2K Lightspeed Clearcoat may be used on panel and multi-panel applications over properly applied basecoat color. This two component clear is designed for fast setting, dust free dry times, delivers outstanding gloss with low overspray, and may be polished as soon as two hours.

COMPATIBLE SUBSTRATES

- Refinish basecoat color
- OEM Basecoat and Enamel Finishes properly prepared
- Cured, aged refinishes properly prepared

Note: **Do not** use over lacquer topcoat color

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



MIXING

COMPONENTS

Mix 4 parts PE1900 Clear with 1 part MP1965, MP1975, MP1985 or MP1995 hardener.

Component	Volume
Montana Big Sky PE1900 2K Lightspeed Clearcoat	4
Montana Big Sky MP19X5 Hardener	1

HARDENER SELECTION

- MP1965 Fast 63-75°F / 17-23°C
- MP1975 Medium 76-85°F / 24-29°C
- MP1985 Slow 86°F-99°F / 30-37°C
- MP1995 Extra Slow 100°F + / 38°C +



SPECIALTY COMPONENTS

- Accelerator not recommended except for cool temperatures (68°F/20°C). Not recommended if baking. 1 oz per ready-to-spray gallon (1/4 ounce per ready-to spray quart). Do not bake with accelerator.
- CR22FEE Fisheye Eliminator (only use if needed)
- SP40 Universal Matting base

POT LIFE

2 - 3 hours at 75°F/23°C

Note: Use of accelerator and reducers, and temperature will affect pot life.



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 - 1.4 mm	8 – 10 PSI	*At the cap
High Efficiency	1.3 - 1.4 mm	27 – 32 PSI	At gauge

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

SURFACE PREPARATION

PE1900 2K Lightspeed Clearcoat is designed to be applied over sprayed basecoat color.

APPLICATION

Allow basecoat to properly dry according to suggested dry times and spray conditions. Apply one medium to full wet coat of clear and allow 5 – 10 minute flash or until surface is hand slick. Apply a second coat of clearcoat. A third coat may be applied after 5 – 10 minute flash to increase depth or if extensive sanding and polishing is anticipated. More coats will extend dry and polishing times. Do not apply more clear after 1-hour of applying previous coats of clear.

RECOATING

Allow clearcoat to dry overnight at 75°F/23°C prior to reapplying color coat. Re-clearing may be done as soon as 16 hours. Due to the strength of some reducers, care needs to be taken if a new color-coat is going to be applied over fresh clear.

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*

To Hand Slick	3-5 minutes
Dust Free	8-10 minutes
To Polish	2 hours
To Compound	6-8 hours
Cure	7 days

*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.

FORCE DRY

Bake 30 minutes at 140°F/60°C. No purge time is necessary (when used as basecoat/clearcoat).



PHYSICAL PROPERTIES

RTS VOC	4.23 lbs./gallon (507 g/L)
RTS Volume Solids	32.00%
RTS Weight Solids	38.10%
Avg. DFT per Coat	1.0 mil ± 0.20
Recommended Total DFT	2.0-2.3
Direct Impact	50 ft/lbs
Reverse Impact	25 ft/lbs
Chemical Resistance	MEK pass 100 double rubs Xylene pass 100 rubs
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 507 grams/liter | 4.23 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

