





Montana Big Sky™ PE2100 2K EuroSpeed Acrylic Urethane Clearcoat



COMPONENTS
PE2100 Clearcoat
MP2165, MP2175, MP2185
or MP2195 Hardener



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




MIX RATIO
2 : 1



DRY TIME
Dust Free – 30 minutes
To Polish – 4 hours
To Compound – 12 - 16 hours



VISCOSITY
N/A



VOC
515 grams / liter
4.30 lbs / gallon



GENERAL

DESCRIPTION

Montana Big Sky PE2100 2K EuroSpeed Acrylic Urethane Clearcoat is designed to provide a deep rich gloss with premium durability. Using the latest European technology, PE2100 offers the versatility needed for spot, multi-panel and overall refinishing, while providing quick delivery and ease of use.

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 2 Parts PE2100 Clear with 1 Part MP2165, MP2175, MP2185, or MP2195 Hardener. Optional 10% reduction with TH035, TH036 or TH037 Zero VOC Urethane Reducer

Component	Volume
Montana Big Sky PE2100 EuroSpeed Acrylic Urethane Clear	2
Montana Big Sky MP21X5 Hardener	1



HARDENER SELECTION

- MP2165 Fast 63-88°F / 17-31°C
- MP2175 Medium 75-85°F / 23-29°C
- MP2185 Slow 85°F + / 29°C
- MP2195 Extra Slow 95°F + / 35°C+

SPECIALTY COMPONENTS

- CR22FEE Fisheye Eliminator
- TH03X Zero VOC Urethane Reducer
- TH01000 Edge Blender
- SP40 Universal Matting Base

Accelerator – Not recommended.

Fisheye Eliminator – If needed, add 1 – 2 ounces of CR22FEE per ready-to-spray gallon (or ¼ - ½ ounce per ready-to-spray quart).

POT LIFE

2 hours at 75°F/23°C.

Note: Accelerators, 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

Apply over properly applied base coat after proper flash time in accordance with the manufacturer’s recommendations.

APPLICATION

Allow basecoat to dry for 30 minutes or longer if manufacturer suggests longer dry times. Single stage colors may require longer flash times, usually 1 – 1 ½ hours longer. Apply one medium-wet coat and allow 5 – 10 minute flash. Apply a second full wet coat. Apply 2 full coats of clear for proper film build and protection (2.0 mils dry film minimum).

RECOATING

Allow clear to dry overnight at 75°F/23°C prior to reapplying color coat.

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	30 minutes
To Polish	4 hours
To Compound	12-16 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 milkiness appearance within the film.



FORCE DRY

Bake 30-35 minutes at 140°F/60°C. No purge time is necessary.



PHYSICAL PROPERTIES

RTS VOC	4.2- 4.3 lbs./gallon
RTS Volume Solids	37.00%
RTS Weight Solids	43-44%
DFT per Coat	1.0 mil ± 0.20
Direct Impact	60 ft/lbs
Reverse Impact	30 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 515 grams/liter | 4.30 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

