





Montana Big Sky™ PE2400 2K Acrylic Urethane Clearcoat



PE2400 Clearcoat
MP2465, MP2475 or MP2485
Hardeners

COMPONENTS




2 coats
10-15 minute flash between coats

APPLICATION




4 : 1

MIX RATIO




Dust Free - 20 minutes
To Polish – 8 hours
To Compound – 10-12 hours

DRY TIME



N/A

VISCOSITY



527 grams / liter
4.4 lbs / gallon

VOC



GENERAL

DESCRIPTION

Montana Big Sky PE2400 2K Acrylic Urethane Clearcoat is designed to offer easy application and polishing while providing an excellent UV resistance. This clearcoat meets National Rule VOC requirements.

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 PE2400 Clear with 1 part MP2465, MP2475 or MP2485 Hardener.

| Component | Volume |
|--|--------|
| Montana Big Sky PE2400 2K Acrylic Urethane Clearcoat | 4 |
| Montana Big Sky MP24X5 Hardener | 1 |
| Optional: 10% reduction with TH035, TH036 or TH037 Zero VOC Urethane Reducer | |



HARDENER SELECTION

- MP2465 Fast 63-75°F / 17-23°C
- MP2475 Medium 75-85°F / 23-29°C
- MP2485 Slow 85°F + / 29°C

SPECIALTY COMPONENTS

- CR22FEE Fisheye Eliminator (only use if needed)
- 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

3 hours at 75°F/23°C

Note: Accelerator, reducer and temperature can 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

Properly applied basecoat in accordance with manufacturer’s data sheet.

APPLICATION

Allow basecoat to properly dry 30 minutes or longer according to manufacturers suggested dry times and spray conditions. Single stage colors may require longer flash times, usually 1 – 1-1/2 hours longer. Apply one medium wet coat of clear and allow 10 – 15 minute flash or until surface is hand slick. Apply a second full wet-coat of clear. Do not apply more clear after 1 hour of applying previous coats of clear. Apply 2 full coats of clear for proper film build and protection (2.0 mils dry film minimum). Excessive amounts of clear will retard drying, curing and may cause die-back.

RECOATING

Due to the strength of some reducers, care needs to be taken if new color coat is going to be applied over fresh clear. Allow clear to dry overnight at 75°F/23°C prior to reapplying color coat. If a full break through of clear is done while making a repair, lightly apply color using a faster flashing reducer. In temperatures below 75°F/23°C the use of a heat lamp will help cure the break through edge so lifting will be minimized. Re-clearing may be done as soon as 16 hours or up to 72 hours without having to scuff clear. If clear is in the first 30 - 45 minutes of dry time, and color needs to be sprayed due to metallic shift or inadequate hiding, apply a light coat of color to achieve desired hide, then re-clear. Avoid excessive film builds. PE2400™ 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. Urethane coatings take 5 – 7 days to properly cure. Care should be taken during first week of washing. Do not use a pressure washer on fresh clear. Stain-free body filler is recommended for use under light colors. Do not use over lacquer.



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 |
| To Polish | 8 hours |
| To Compound | 10-12 hours |
| Cure | 7 days |

FORCE DRY

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



PHYSICAL PROPERTIES

| | |
|-----------------------|--|
| RTS VOC | 4.4 lbs./gallon (527 g/L) |
| RTS Volume Solids | 33.00% |
| RTS Weight Solids | 39.50% |
| Avg. DFT per Coat | 1.0 mil ± 0.20 |
| Recommended Total DFT | 2.0 - 2.3 |
| 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 527 grams/liter | 4.4 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

