





# Montana Big Sky™ PE2442 2K Intense Fast Reaction Clearcoat




**COMPONENTS**  
 PE2442 Clearcoat  
 MP2444 or MP2445  
 Hardeners  
 TH0800 Series Reducers




**APPLICATION**  
 2 coats  
 15 minute flash between coats




**MIX RATIO**  
 4 : 1 : 1



**DRY TIME**  
 Dust Free – 15 minutes  
 To Polish – 5 hours  
 To Compound – 7-8 hours



**VISCOSITY**  
 N/A



**VOC**  
 503 grams / liter  
 4.2 lbs / gallon



## GENERAL

### DESCRIPTION

Montana Big Sky PE2442 2K Intense Fast Reaction Clearcoat is a 4.2 lbs/gal VOC fast curing, high solids, universal acrylic urethane clearcoat designed for maximum speed, fast build (2 coat maximum), and extreme productivity. PE2442 can be used as a baking or air-dry clear, and dries to an intense, high-gloss with excellent UV protection and weathering. MP2445 Hardener was developed for hot environments (90°F+/32°C+) to increase flow out. This hardener will not provide the fast bake performance of the MP2444.

### 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 PE2442 Clear with 1 part MP2444 or MP2445 to 1 part TH0800 Series Reducer.

Component	Volume
Montana Big Sky PE2442 2K Fast Reaction Clearcoat	4
Montana Big Sky MP244X Hardener	1
Montana Big Sky TH0800 Series Reducer	1



**HARDENER SELECTION**

- MP2444 Fast 63-89°F / 17-32°C
- MP2445 Slow 90°F + / 32°C +

**REDUCER SELECTION**

- TH0860 Fast 60-70°F / 15-21°C
- TH0870 Medium 70-80°F / 21-26°C
- TH0885 Slow 80-90°F / 26-32°C
- TH0895 Hot Temp 90°F / 32°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**

1 hour at 75°F/23°C




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**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 20 minutes or longer according to manufacturers suggested dry times and spray conditions. Single stage colors may require longer flash times, usually 60 – 90 minutes longer. Apply one medium-wet coat of clear and allow 15 minute flash or until surface is hand slick. Apply a second medium- to full-wet coat of clear. Do not apply more clear after 1 hour of applying previous coats of clear. Use only 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.

**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	15 minutes
To Polish	5 hours
To Compound	7-8 hours
Cure	7 days

### FORCE DRY

Bake 35-40 minutes at 140°F/60°C. No purge time is necessary. Quick Bake (for light polishing or out of dust (MP2444 ONLY): 15-20 minutes at 140°F/60°C. Allow 1-2 hours to cool down.



## PHYSICAL PROPERTIES

RTS VOC	4.2 lbs./gallon (503 g/L)
RTS Volume Solids	38.70%
RTS Weight Solids	45.60%
Avg. DFT per Coat	1.3 mil ± 0.20
Recommended Total DFT	2.0 +
Direct Impact	+80 ft/lbs
Reverse Impact	50 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 503 grams/liter | 4.2 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**  
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