





Montana Big Sky™ PE2600 2K Acrylic Urethane Clearcoat




PE2600 Clearcoat
MP26X5 Hardener

COMPONENTS



1 medium coat + 1 full wet coat
10-15 minute flash between coats

APPLICATION




2 : 1

MIX RATIO




Dust Free – 20 minutes
To Polish – 8 hours
To Compound 12 - 16 hours

DRY TIME



N/A

VISCOSITY



503-515 grams / liter
4.2-4.3 lbs / gallon

VOC



GENERAL

DESCRIPTION

Montana Big Sky PE2600 2K Acrylic Urethane Clearcoat is designed to provide a deep rich gloss with premium durability. Using quality urethane technology, PE2600 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 PE2600 with 1 part MP2665, MP2675, or MP2685 Hardener. Optional 10% reduction with TH035, TH036 or TH037 Zero VOC Urethane Reducer

Component	Volume
Montana Big Sky PE2600 Clearcoat	2
Montana Big Sky MP26X5 Hardener	1



HARDENER SELECTION

- MP2665 Fast 63-78°F / 17-26°C
- MP2675 Medium 75-85°F / 23-29°C
- MP2685 Slow 85°F + / 29°C +

SPECIALTY COMPONENTS

- CR22FEE Fisheye Eliminator
- TH035, TH036 or TH037 Zero VOC Urethane Reducer
- TH01000 Edge Blender

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: 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

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

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 60 – 90 minutes longer. Apply one medium-wet coat and allow 10 – 15 minute flash. Apply a second full-wet coat. 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 and 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.

SPECIAL 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.
- Use a mixing cup for accurate volume measurements.



- PE2600 will be water resistant in 24-hours. Note: 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.
- 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	Approximately 20 minutes
To Polish	8 hours
To Compound	12 -16 hours
Cure	7 days

FORCE DRY

Bake 35-45 minutes at 140°F/60°C. No purge time is necessary (when used as basecoat/clear). Allow 1 – 2 hour cool down prior to assembly or buffing.



PHYSICAL PROPERTIES

RTS VOC	4.2- 4.3 lbs./gallon
RTS Volume Solids	36.00%
RTS Weight Solids	43.00-44.00%
DFT per Coat	1.0 mil ± 0.20
Flash Point	See SDS
Direct Impact	60 ft/lbs
Reverse Impact	30 ft/lbs
Chemical Resistance	MEK pass 100 double rubs Xylene pass 100 rubs

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	503-515 grams/liter 4.2-4.3 lbs/gallon
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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

