





Montana Big Sky™ PS304X 2K Epoxy Primer




COMPONENTS

PS304X 2K Epoxy Primer
PA3040E or PA3040V 2K
Epoxy Activator




APPLICATION

Primer: 1-2 single wet coats,
15 minute flash between coats
Sealer: 1 single wet coat, 45-60
minute flash before topcoat



MIX RATIO

Primer - 1 : 1
Sealer - 1 : 1 : 1/4




DRY TIME

Primer – To sand: overnight
Primer – To topcoat: 1 hour per
coat to max 24 hours
Sealer – To topcoat: 45
minutes to 6 hours



VISCOSITY

N/A



VOC

551 grams / liter
4.6 lbs / gallon



GENERAL

DESCRIPTION

Montana Big Sky PS304X Epoxy Primer two-component, chromate-free epoxies are designed for use as medium fill primers that provide optimum adhesion with excellent corrosion protection for bare substrates. Epoxy Primer may also be applied as a sealer to ensure greater inter-coat adhesion, chemical resistance, and color holdout. Epoxy Primer is a full epoxy resin that utilizes a non-induction catalyst, used to increase productivity for automotive and fleet refinishing. If required, Epoxy Primer has a 3.5 lbs/gal VOC catalyst, used for fleet and light industrial applications.

COMPATIBLE SUBSTRATES

- Properly cleaned and conditioned steel, stainless, aluminum, galvanized steel, copper, and brass.
- Thoroughly sanded OEM and cured paint.
- Cured and sanded body filler.
- Sanded Fiberglass and SMC.
- Properly prepared plastic.
- **Do not** use over soluble substrates, DTM, acid etch primer, lacquer primer or lacquer finishes.

COLOR

- PS3042 Light Gray
- PS3044 Dark Gray
- PS3045 Black
- PS3047 Yellow

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



MIXING

COMPONENTS

As a medium build primer: 1 part 2K Epoxy Primer and 1 part 2K Epoxy Activator

Component	Volume
Montana Big Sky PS304X 2K Epoxy Primer	1
Montana Big Sky PA3040E or PA3040V 2K Epoxy Activator	1

As a sealer: 1 Part 2K Epoxy Primer with 1 Part Epoxy Activator and ¼ Part VOC Compliant Urethane Reducer

Component	Volume
Montana Big Sky PS304X 2K Epoxy Primer	1
Montana Big Sky PA3040E or PA3040V 2K Epoxy Activator	1
Montana Big Sky TH03X Zero VOC Urethane Reducer	¼

SPECIALITY COMPONENTS

- PA3040V 2K Epoxy Activator Low VOC
- TH035, TH036, TH037 Zero VOC Urethane Reducer

CATALYST RECOMMENDATIONS

- PA3040E: (Express) Non-induction hardener, providing faster drying properties and no waiting to use once mixed.
- PA3040V: Non-induction, should be used when 3.5 VOC is required.
- It is recommended to use catalysts within 14 days of opening to maintain maximum performance. Replace lids on all paint products immediately after use to avoid moisture or oxygen contamination.

POT LIFE:

16 hours @ 75°F/23°C



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.4 - 1.6 mm	7 - 10 PSI	*At the cap
High Efficiency	1.4 - 1.6 mm	27 - 32 PSI	At gauge

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

PRIMER APPLICATION

Apply in single wet coats, allowing 15 minute, flash between coats. Apply 1 - 2 coats, depending on desired film build. A light coat of body filler may be applied over 1 coat of Epoxy Primer after 2 hours at 75°F/23°C. If two coats of Epoxy Prime are applied, wait overnight before applying filler.

SEALER APPLICATION

Apply 1 single wet coat of Epoxy Prime reduced as a sealer, to create a uniform base. Allow to flash for 45 - 60 minutes at 75°F/23°C before applying topcoats.

COMPATIBLE TOPCOATS

- System 10 Acrylic Enamel Color
- System 20 Synthetic Enamel Color
- System 50 SkyBase Basecoat Color
- Metalux International Basecoat Color
- Polyurethane Topcoats



- System 12 Acrylic Enamel Color
- System 22 Acrylic Urethane Color
- System 28 2.8 VOC Polyurethane Color
- System 35 3.5 VOC Polyurethane Color
- Acrylic Urethane Topcoats
- Acrylic Urethane Primer-Surfacers
- Acrylic Enamels

NOTE: Activated basecoats offer better chemical resistance and inter-coat adhesion.

FLEXIBLE PARTS

We suggest the use of AP200 Plastic Adhesion Promoter prior to priming. Refer to MBS_TDS_AP200 for additional information.

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

DRY TIME TO SAND

Primer Option:

NOTE: As a rule, epoxy primers do not sand well until completely dry.

- Air Dry: Overnight at 75°F/23°C for best results
- Final sand with P400 - P600 grit sandpaper before topcoating

Sealer Option:

- Sealer option does not require sanding if topcoated within maximum recoat time.
- If necessary, Air Dry: 45 - 60 minutes at 75°F/23°C before sanding to remove debris.

TIME TO TOPCOAT

Primer Option:

- Minimum 1-hour dry time per coat and maximum 24 hours at 75°F/23°C.
- Between 24-72 hours, Epoxy Primer must be sanded prior to topcoating.
- After 72 hours, Epoxy Primer must be sanded and recoated with a single coat of Epoxy Primer, prior to topcoating.

Sealer Option:

- Minimum 45 minute, dry time and maximum 6 hours at 75°F/23°C prior to topcoating.
- Between 6 - 24 hours, Epoxy Primer must be sanded prior to topcoating.
- After 24 hours, Epoxy Primer must be sanded and recoated with a single coat Epoxy Primer prior to topcoating.



PHYSICAL PROPERTIES

PRIMER SURFACE/STANDARD CATALYST MIX

Mix 1:1 at 75°F/23°C

Recommended Film Thickness	1.0 ± 0.2 mils per coat
VOC as Applied	4.6 lbs/gallon
Mixed Volume Solids	32.9%
Theoretical Coverage RTS	529 sq. ft. @ 1 mil
Flash Point	See SDS



SEALER WITH VOC COMPLIANT REDUCER

Mix 1:1:1/4

Recommended Film Thickness	0.8 ± 0.2 mils per coat
VOC as Applied	4.6 lbs/gallon
Mixed Volume Solids	29.2%
Theoretical Coverage RTS	469 sq. ft. @ 1 mil
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 551 grams/liter | 4.6 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: July 2019

In the United States and Canada:
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