





Montana Big Sky™ PS305X 2K Performa-Seal Urethane Sealer




COMPONENTS PS305X 2K Performa-Seal Urethane Sealer
PA3050F/PA3050M Hardener
TH0800 Series Urethane Grade




APPLICATION 1-2 coats
10 minute flash between coats
or 15-20 minute flash for a single coat




MIX RATIO 4 : 1 : 1



DRY TIME To Hand Slick – 5-10 minutes
To Topcoat – 15-20 minutes



VISCOSITY N/A



VOC 4.60 lbs / gallon
551 grams / liter



GENERAL

DESCRIPTION

Montana Big Sky Performa-Seal is a non-sanding acrylic urethane sealer that applies smoothly and maintains superior color and gloss retention for high quality finishes. Performa-Seal allows for increased inter-coat adhesion while providing a uniform ground coat over repairs. All 3 shades of sealer may be intermixed to provide the painter with a variety of undercoat shades.

COMPATIBLE SUBSTRATES

- Thoroughly sanded or scuffed OEM E-coat
- Properly sanded cured OEM and refinished paint
- Properly dried and sanded Montana branded primer surfacers

NOTE: Do not use directly over cracked or deteriorated finishes

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



MIXING

COMPONENTS

Mix 4 parts PS305X Performa-Seal Sealer with 1 part PA3050F/PA3050M Hardener and 1 part TH0800 Series Urethane Grade Reducer.

NOTE: Performa-Seal Sealer is NOT a high build product. Proper repair and finish procedures must be practiced to insure a quality finish. Sealers are not a substitute for improper sanding techniques. Sealer is not intended to fill coarse sand scratch



Component	Volume
Montana Big Sky PS305X Performa-Seal Sealer	4
Montana Big Sky PA3050F/PA3050M Hardener	1
Montana Big Sky TH0800 Series Urethane Grade Reducer	1

PRIMER SEALER SELECTION

- PS3051 2K Performa-Seal Urethane Sealer White
- PS3053 2K Performa-Seal Urethane Sealer Gray
- PS3055 2K Performa-Seal Urethane Sealer Blac

REDUCER SELECTION

- TH0860 Fast Urethane Grade Reducer 60 - 70°F/15 - 21°C
- TH0870 Medium Urethane Grade Reducer 70 - 80°F/21 - 26°C
- TH0885 Slow Urethane Grade Reducer 80 - 90°F/26 - 32°C
- TH0895 Extra Slow Urethane Grade Reducer 90°F/32°C

SPECIALTY COMPONENTS

- TH035 Fast Zero VOC Urethane Reducer 65-70°F / 18-21°C
- TH036 Fast Zero VOC Urethane Reducer 70-85°F / 21-29°C
- TH037 Fast Zero VOC Urethane Reducer 85°F + / 29°C +

SHADING

- Performa-Seal™ Sealers may be blended together to achieve various shades of the gray scale.
- No other tints or toners may be added. Do not mix with paint.
- See chart below for shading recommendations depending upon color family of the topcoat.

PS3051	PS3051 & PS3053 MIX 2:1	PS3051 & PS3053 MIX 1:2	PS3053	PS3053 & PS3055 MIX 2:1	PS3053 & PS3055 MIX 1:2	PS3055
Light Colors Very LT Colors Light Yellows Whites Sivers	Pastel Green Med. Yellow Light Tan Med. Silver Pastel Blue	Green Dark Silver Med. Light Tan Med. Light Red Med. Light Blue	Med. Red Med. Brown Med. Green Med. Blue Med. Gray	Dark Red Dark Brown Dark Blue Dark Green Med. Dark Gray	Dark Green Dark Blue Dark Brown Dark Red Dark Gray	Deep Dk Red Deep Dk Brown Deep Dk Green Deep Dk Blue Black

POT LIFE

8 hours at 75°F/23°C.

NOTE: Extreme warm temperatures will shorten 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

Wash the surface with mild detergent and warm water, making sure to rinse well and dry with a clean, dry cloth. Solvent clean with TH5950 Strong Wax & Grease Remover, TH5951 Mild Wax & Grease Remover or TH5953 Zero VOC Urethane Reducer. Sand panel using P400 or finer grit sandpaper. Re-clean repairs with surface cleaner to remove sanding



residue before priming. Performa-Seal is Not designed as a primer for large areas of bare metal or plastics.

APPLICATION

Apply 1 single, even wet coat of properly mixed sealer, to create a uniform base. If desired, apply a second coat after a 10 minute flash. Extend dry time in temperatures below 75°F/23°C. Allow a single coat to flash for 15 - 20 minutes at 75°F/23°C before applying topcoats. Multiple coats will require a longer flash time. Apply topcoats within 12 hours of sealer application. After 12 hours, scuff using gray scuff pad or P800-P1000 grit sandpaper. Re-clean and apply topcoat.

COMPATIBLE TOPCOATS

- Acrylic Urethanes
- Acrylic Enamels
- Polyurethane Color
- Basecoats

NOTE: Do not use lacquer type products

SPECIAL NOTES

Shop and surface temperatures should be maintained at or above 75°F/23°C for the first 24 hours of the cure cycle. Cooler temperatures will result in slower drying, curing and poor performance.

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	10-15 minutes
Hand Slick	5-10 minutes

DRY TIME TO SAND

Sealer does not require sanding if topcoated within 12 hours. If necessary, Air Dry: 30 - 45 minutes at 75°F/23°C to remove debris.

DRY TIME TO TOPCOAT

15 - 20 minutes @ 75°F/23°C prior to topcoating for a single coat.



PHYSICAL PROPERTIES

RTS VOC	4.60 lbs./gallon (551 g/L)
RTS Volume Solids	34.5%
RTS Weight Solids	52.6%
Avg. DFT per Coat	0.75 mil ± 0.2
Recommended Minimum DFT	0.5 mils
Theoretical Coverage @ 1 mil	482 sq ft.
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 | 4.60 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

