









# Montana Big Sky™ PS320X 2K DTM Primer Surfacer

 <b>COMPONENTS</b> PS320X DTM Primer Surfacer PA3200M/PA3200S DTM Activator TH0800 Series Urethane Reducer	 <b>APPLICATION</b> Primer: 2-3 coats with 5-10 minute flash Sealer: 1 coat with at least 30 minute flash
 <b>MIX RATIO</b> 4 : 1 : ½ or 4 : 1 : 1	 <b>DRY TIME</b> To Sand – 45 minutes to 1 hour
 <b>VISCOSITY</b> N/A	 <b>VOC</b> 495 – 526 grams / liter 4.13 – 4.39 lbs / gallon



## GENERAL

### DESCRIPTION

Montana Big Sky PS320X DTM Primer Surfacer is a non-isocyanate, chromate-free, direct-to-metal primer that provides optimum adhesion with excellent corrosion protection on bare metals and OEM substrate. These primers are designed for use as a medium or high build primer-surfacer that easily sands by hand or machine, while offering superior color holdout and gloss retention for fast, high quality finishes.

### COLOR

- PS3201 White
- PS3203 Gray
- PS3205 Black

### 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 rigid plastic
- Not recommended for use under waterbase basecoat unless sealed with a compliant 2K urethane sealer

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



## MIXING

### COMPONENTS

#### As a Normal Build Surfacer/Sealer

Mix 4 parts PS320X with 1 part PA3200M/S DTM Activator and 1 part TH0800 Series Urethane Reducer.

- Average per coat film build 1.0 - mils (Mixed 4:1:1)

Component	Volume
Montana Big Sky PS320X 2.1 VOC DTM Primer/Surfacer	4
Montana Big Sky PA3200M/PA3200S DTM Activator (PA3200M Medium, PA3200S Slow)	1
Montana Big Sky TH0800 Series Urethane Reducer	1

#### As a High Build Surfacer

Mix 4 parts PS320X with 1 part PA3200M/S DTM Activator and 1/2 part TH0800 Series Urethane Reducer.

- Average per coat film build 2.0 mils approximately. (Mixed 4:1:1/2)
- Only two coats are suggested due to increased film builds, or extend dry times for a third coat.

Component	Volume
Montana Big Sky PS320X 2.1 VOC DTM Primer/Surfacer	4
Montana Big Sky PA3200M/PA3200S DTM Activator (PA3200M Medium, PA3200S Slow)	1
Montana Big Sky TH0800 Series Urethane Reducer	1/2

- It is recommended to use activators within 14 days of opening to maintain maximum performance. Replace lids on all paint products immediately after use to avoid moisture or oxygen contamination.

### TINTING

DTM primers may be blended together to achieve various shades of the gray scale for better coverage. No other tints or toners may be added. Do not mix with paint. See chart below for shading recommendations.

PS3201	PS3201 & PS3203 MIX 2:1	PS3201 & PS3203 MIX 1:2	PS3203	PS3203 & PS3205 MIX 2:1	PS3203 & PS3205 MIX 1:2	PS3205
Light Colors Very LT Colors Light Yellows Whites Silvers	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

2 hours at 75°F/23°C. Warmer temperatures will shorten pot life. Clean Equipment immediately after use.



## APPLICATION

### APPLICATION EQUIPMENT

HVLP Gravity	1.4 - 1.6 mm	8 – 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

### SURFACE PREPARATION

Be sure to completely remove rust or oxidation prior to applying primer. Rust and oxidation can be removed by media blasting, grinding, or sanding. Properly Clean metal and painted surfaces with Wax & Grease Remover or Zero VOC Waterborne Surface Cleaner.

Steel: Finish sand with 80 - P180 grit sandpaper.

Aluminum, Galvanized, Stainless Steel: Sand with P320 grit sandpaper or scuff using a red scuff pad to remove light oxidation and abrade the surface.

SMC, Fiberglass: Finish sand with P180 to P240 grit sandpaper.

Bare Rigid Plastic: Use AP100 Flexible Parts Cleaner and AP200 Plastic Adhesion Promoter.

Repairs: sand repair area and featheredge as needed, finish the featheredge with P320 grit sandpaper. Final sand the area surrounding the repair and featheredge using P400 or finer. Existing finishes: sand with P220 to P320 grit sandpaper to remove oxidation before priming.

Tech Tip: Check for solubility by rubbing the E-coat with a rag and thinner or urethane reducer several times. If the E-coat dissolves with solvent, we recommend removing it prior to refinishing.

### IN ALL CASES RE-CLEAN REPAIRS WITH APPROPRIATE SURFACE CLEANER TO REMOVE SANDING RESIDUE BEFORE PRIMING

### APPLICATION

#### As a Primer:

Apply in single wet coats, allowing 5 - 10-minute flash at 75°F/23°C between coats. For normal build, apply 2 - 3 coats, depending on desired film build. For high build, we suggest 2 coats maximum. If three coats are applied, allow for overnight drying. Body filler may be applied 1 hour after a single coat of PS3201/PS3203/PS3205 has been applied. Additional heat may be applied to speed curing and drying. Allow to cool before sanding.

#### BRUSHABLE/ROLLABLE OPTION

Mix according to directions. The use of slower reducers will increase flow and leveling. Apply 1 even coat of PS3201/PS3203/PS3205, making sure to cover the repair area completely into the featheredge. Before the second coat is applied, allow a 10 minute flash between coats. Apply the second coat within the previous coats' outer edge. For best results, do not apply more than 3 coats.

#### COMPATIBLE TOPCOATS

- Properly cleaned steel, aluminum, galvanized steel, fiberglass and SMC.
- Thoroughly scuffed OEM E-coat and sanded cured paint.
- Cured, sanded body filler.
- Properly prepared rigid plastic.

**Note: Do not use over lacquer primer or lacquer finishes.**

#### 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

@75°F/23°C

To Sand

45 minutes to 1 hour

To Topcoat

Primer: 45-60 minutes to 3 hours

Sealer: 30 minutes to 3 hours

### DRY TIME TO SAND

**Primer Option (Allow for proper flash time between coats during application)**

Air Dry: 45 minutes to 1 hour per coat at 75°F/23°C. Overnight for 3 coats using high build 4:1 mix.

Bake: 20 minute flash followed with 140°F/60°C for 15 – 20 minutes.

Infrared short wave: Allow to flash 20 minutes then 5 minute per coat air dry or low power heat), followed by a 5 minute per coat bake using full power @ 150°F/66°C. Final sand with P400 - P600 grit sandpaper and topcoat within 24 hours.

### DRY TIME TO TOPCOAT

After sanding should be topcoated within 4 – 6 hours @75°F/23°C.

### PLASTIC (RIGID) PARTS ONLY

- For bare plastic repair, use AP200 Plastic Adhesion Promoter. Refer to AP200 Technical Data Sheet for information and product use.
- Applying PS3201/PS3203/PS3205 mixed at a 4:1:1 ratio is recommended.
- Apply only 1 – 2 coats of primer over the repair area. Avoid excessive film builds

### 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 may result in slower drying, curing and overall performance. Ensure proper metal conditioning/preparation procedures in early stages are followed. Ensure proper flash times, dry times, sanding procedures, and all directions are followed. Maintain accurate measuring during mixing.



## PHYSICAL PROPERTIES

### Mix 4:1:1/2

Film Thickness

2.0 ± 0.5 mils per coat

Volume Solids

43%

VOC Applied

4.13 lbs/gal (495 g/L)

Theoretical Coverage RTS

691sq. ft. @ 1 mil DFT

Flash Point

See SDS

### Mix 4:1:1

Film Thickness

1.5 ± 0.4 mils per coat

Volume Solids

39.5%

VOC Applied

4.39 lbs/gal (526 g/L)

Theoretical Coverage RTS

635 sq. ft. @ 1 mil DFT

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).

