Montana Big Sky™ PS500XA 2K Urethane Primer

COMPONENTS	PS500XA Primer PS5008B 2K Urethane Primer Hardener
APPLICATION	Primer: 2 coats with 5-10 minute flash Sealer: 1 coat with 30-45 minute flash
MIX RATIO	4 : 1 or 4 : 1 : 2
DRY TIME	Primer: To sand – 1 - 1 ½ hours Primer: To Topcoat 4-6 hours Sealer: To topcoat – 20-30 minutes
VISCOSITY	N/A
VOC	539 grams / liter < 4.50 lbs / gallon

GENERAL

DESCRIPTION

PS500XA are two-component urethane primers designed to offer high film build, quick and easy sanding, while maintaining superior gloss and DOI. Both meet the National Rule requirement of 4.80 lbs/gal VOC (575 g/L) for primers.

COLOR

- PS5008A Beige
- PS5009A Gray

COMPATIBLE SUBSTRATES

- Properly cleaned steel, aluminum, and galvanized steel
- PS304X Epoxy Primer - allow epoxy to flash for 1 hour prior to applying PS500XA
- PS3008 ViperGrip II Metal-Etch Primer
- Thoroughly sanded OEM and cured paint
- Sanded fiberglass / SMC
- Cured body filler

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

MIXING

COMPONENTS

As a Primer
Mix 4 parts PS500XA 2K Urethane Primer to 1 part PS5008B Urethane Primer Activator.
¾ optional reduction with TH0800 Urethane Series Reducer.

- 4:1 mix yields a heavy build of 2.5 mils ± 0.5 per coat
- A 10% reduction, using Zero Voc Reducer series, may be desired for better level & flow.

Component	Volume
Montana Big Sky PS500XA 2K Urethane Primer	4
Montana Big Sky PS5008B 2K Urethane Primer Hardenerr	1
Optional reduction TH0800 Urethane Series Reducer	¾

REDUCER

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 +

As a Sealer
Mix 4 parts 2K Urethane Primer to 1 part PS5008B Urethane Primer Activator to 2 parts TH03X Zero VOC Reducer.

Component	Volume
Montana Big Sky PS500XA 2K Urethane Primer	4
Montana Big Sky PS5008B Urethane Primer Activator	1
Montana Big Sky TH03X Zero VOC Reducer Series	2

REDUCER

TH035 Fast	65 - 70°F / 18 - 21°C
TH036 Medium	70 - 85°F / 21 - 29°C
TH037 Slow	85°F + / 29°C +

POT LIFE

Catalyzed Primer: 1 hour at 75°F/23°C
Sealer: 2 hours at 75°F/23°C

Accelerator, reducer, and temperature will affect pot life. Clean equipment immediately after use.

APPLICATION

APPLICATION EQUIPMENT

Primer

HVLP Gravity	1.4 - 1.6 mm	6 – 10 PSI	*At the cap
High Efficiency	1.4 - 1.6 mm	17 – 32 PSI	At gauge

Sealer

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

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

SURFACE PREPARATION

Be sure to completely remove all rust or oxidation prior to applying primer.

Solvent clean with TH05950 Strong Wax & Grease Remover. Featheredge with P180- P320 grit sandpaper. Sand the existing areas with P400 grit sandpaper. Large bare Metal areas should be sprayed with etch primer prior to priming. TH5950 Strong Wax & Grease Remover and a red scuff pad may be used to remove light surface oxidation on aluminum. Follow by re-cleaning the aluminum to remove sanding residue with TH5950 Strong Wax & Grease Remover.

Sealer Option:
Solvent clean with TH5950 Strong Wax & Grease Remover.
Sand repair areas, finishing with P400 grit sandpaper or finer.
Re-clean repair with TH5951 Mild Wax & Grease Remover to remove sanding residue before sealing.

APPLICATION

PRMER
Apply over properly prepared surfaces. Apply in single full wet coats, allowing 5 – 10 minute flash between coats. For best results, do not apply more than 3 coats.

BRUSHABLE / ROLLABLE OPTION

Mix according to directions. A small amount of reducer will improve flow. Apply 1 even coat of PS500XA Urethane Primer, making sure to cover the repair area completely into the featheredge. If a second coat is applied, allow a 5 -10 minute flash between coats. Apply the second coat within the first coats' outer edge. For best results, do not apply more than 3 coats.

SEALER
Apply 1 single wet coat of properly mixed PS500XA as a sealer to create a uniform base. Allow to flash for 30 – 45 minutes before applying topcoats.

COMPATIBLE TOPCOATS

- Acrylic Urethanes
- Acrylic Enamels
- Polyurethane Color
- Basecoat Color
- Synthetic Enamels

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	Primer: 1 – 1 ½ hours per coat Sealer: does not require sanding
To Topcoat	Primer: within 4-6 hours after sanding Sealer: 20-30 minutes

DRY TIME TO SAND

Primer Option
Primer must be sanded prior to topcoating. Air Dry: 1 ½ - 2 hours at 75°F/23°C per coat before sanding. If 3 coats are applied, allow to dry overnight. Baking: Allow a 15 minute flash, then bake at 150°F/65°C for 45 minutes. Allow to cool before sanding. Infrared: Allow a 15 minute flash, then bake at 140°F/60°C for 20 minutes. Allow to cool before sanding

Sealer Option
Does not require sanding prior to topcoat unless 2.1 VOC urethane primer has dried for longer than the recommended recoat time. If not topcoated within 4 hours, scuff with gray scuff pad or P600 grit sandpaper. Then clean and apply color.

DRY TIME TO TOPCOAT

Primer / Surfacer Option:
Primer must be sanded before topcoating.
Topcoat within 4 - 6 hours after sanding.
If PS500XA has dried longer than the recommended recoat time, scuff with P400 - P600 grit sandpaper or finer.

Sealer Option:
20 – 30 minutes at 75°F/23°C prior to topcoating

Flexible Parts (See AP200 TDS for further Information)
Clean the surface with a Flexible Parts Cleaner using a clean and dry, lint-free cloth. Completely scuff the repair and refinish area using a gray scuff pad and/or scuff gel and re-clean. Apply 2 single coats of AP200 allowing 5 minute flash time between coats.
Apply primer mixed 4:1:1 within 30 minutes of applying AP200. Apply only 1 – 2 coats of primer. Avoid excessive film builds.

SPECIAL NOTES:

Ensure shop and repair surface temperatures are maintained above 75°F/23°C prior to work. Ensure proper flash times, dry times, sanding procedures, and all directions for topcoats are followed. Use a mixing cup for accurate volume measurements.

PHYSICAL PROPERTIES

Mix 4:1

Film Thickness	2.2 ± 0.3 mils per coat
Volume Solids	40.6%
VOC Applied	4.49 (538 g/L)
Theoretical Coverage RTS	642 sq. ft. @ 1 mil DFT
# of Coats	3

Mix 4:1:2

Film Thickness	+ 0.5 mils per coat
Volume Solids	28.5%
VOC Applied	<4.50 (539 g/L)
Theoretical Coverage RTS	458.28 sq. ft. @ 1 mil DFT
# of Coats	1

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	539 grams/liter | <4.50 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:
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