





# Montana Big Sky™ System 22 Acrylic Urethane Color System




**COMPONENTS**  
System 22 Color  
CR22AF, CR22AM, CR22AS or  
CR22AES Hardener  
TH0800 Series Reducer




**APPLICATION**  
1 medium wet coat + 2 full wet  
coat 15-minute flash between  
coats; if 3<sup>rd</sup> coat, 20-minute  
flash between coats




**MIX RATIO**  
4 : 1 : 1



**DRY TIME**  
Dust Free – 15 – 20 Minutes  
To Handle - 16 – 20 hours  
To Buff/Compound – 24 hours



**VISCOSITY**  
N/A



**VOC**  
599 grams / liter  
5.00 lbs / gallon



## GENERAL

### DESCRIPTION

Montana Big Sky System 22 is a fast drying, user friendly 5.0 lbs/gal VOC single-stage acrylic urethane designed to provide a rich, high gloss finish with excellent durability and chemical resistance.

### COMPATIBLE SUBSTRATES

- Sanded OEM Finishes
- Cured, Aged Finishes
- EZ543 EZ-Fill Acrylic Primer Surfacer (sealed)
- PS3042 / PS3044/ PS3045 Epoxy Prime
- PS5008A/ PS5009A Urethane Primer/Sealer
- PS5011/PS5012A/PS5015 2.1 VOC 2K Primer/Surfacer

Note: These substrates may be directly topcoated: however, we suggest sealing prior to color coating for optimum results.

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



## MIXING

### COMPONENTS

Mix 4 parts System 22 Color to 1 part CR22AF, CR22AM, CR22AS or CR22AES Hardener to 1 part TH0800 Series Reducer.

Component	Volume
Montana Big Sky System 22 Color	4
Montana Big Sky CR22AF/AM/AS/AES Hardener	1
Montana Big Sky TH0800 Series Reducer	1



**HARDENER SELECTION**

- CR22AF Fast 63-78°F / 17-25°C
- CR22AM Medium 75-88°F / 23-31°C
- CR22AS Slow 85-100°F / 29-37°C
- CR22AES Extra Slow 100°F / 37°C

**REDUCER SELECTION**

- 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 Extra Slow 90°F / 32°C

**SPECIALTY COMPONENTS (OPTIONAL)**

- CR22ACC Accelerator
- CR22FEE Fisheye Eliminator
- CRV22 Clearcoat
- TH01000 Edge Blender
- TH0885 Slow Reducer

Accelerator: If needed, use 1 – 2 ounces of CR22ACC Accelerator per ready-to-spray gallon (or ¼ - ½ ounce per ready-to-spray quart). Do not use accelerator when temperature exceeds 90°F/32°C. Over acceleration can cause solvent popping and brittle paint. Do not use accelerator if baking. If temperatures are bordering 68°F/20°C or cooler, we strongly recommend the use of CR22ACC at a level of 1 – 2 ounces per ready-to-spray gallon.

Fisheye eliminator: If needed, add 1 – 2 ounces of CR22FEE per ready-to-spray gallon (or ¼ - ½ ounce per ready-to-spray quart). Only use CR22FEE Fisheye Eliminator as other brands may be incompatible.

**POT LIFE**

4-6 hours @75°F/23°C

Do not try to thin color after thickening has occurred – do not use.

Note: Accelerators, reducers, and temperature will affect pot life.




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**APPLICATION**

**APPLICATION EQUIPMENT**

HVLP Gravity	1.3 - 1.5 mm	8 – 10 PSI	*At the cap
High Efficiency	1.3 - 1.5 mm	27 - 32 PSI	At gauge

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

**SURFACE PREPARATION**

**Overall or Full Panel Repair**

Prior to repair, wash the surface with mild detergent and hot water, making sure to rinse well and dry with a clean dry cloth. Solvent clean with TH5950 Strong Wax & Grease Remover or TH5951 Mild Wax & Grease Remover to remove any contaminants prior to sanding or bodywork. Make all repairs – treat bare metals and prime with appropriate Montana Big Sky primers and sealers. When using a sealer, final sand with P320 grit sandpaper or finer. When topcoating over sanded substrates, finish sand with P400 - P800 grit sandpaper. Final clean with TH5951 Mild Wax & Grease Remover or TH5952 Fast Evaporating Final Cleaner, making sure surface is clean and dry. Final wipe using a tack cloth prior to applying sealer or color.

**Blend Repair Area**

Note: System 22 is designed for overall refinishing but may be blended in some cases. Detergent wash, solvent clean, and thoroughly sand past the blend area using P1500 – P2000 grit sandpaper. The use of a gray nylon scuff pad or scuff gel is also acceptable. Make necessary repairs following product directions. Re-clean using TH5952 Fast Evaporating Final Cleaner before applying color. Final wipe using a tack cloth prior to applying sealer or color.

**APPLICATION****As an overall or full-panel repair**

Allow appropriate dry times for primers and sealers. Confirm color match is appropriate by testing color prior to application. Strain paint prior to application. Apply one medium-wet coat and allow 15-minute flash time or until surface is hand slick. Apply a 2nd full-wet coat. If a 3rd coat is needed, allow 20 minutes flash time between 2nd and 3rd coat. For best results, do not apply more than 3 coats. If metallics are being applied, apply one fog coat immediately after last coat, holding the spray gun back an additional 2" – 3". Raising the air pressure a few pounds will help even out metallics.

**Blending Color**

Use a tack cloth to final wipe repair area. Apply System 22 until hiding. Apply each coat beyond prior coat, keeping within the sanded blend area. Allow proper flash between coats. If a clearcoat is being applied, use over full panel beyond color blend, following clearcoat directions.

**One Gun Method (to reduce blend edge):**

If needed, over-reduce the pre-mixed color 2:1 – this will help extend out the color. Lowering the air pressure while choking the fluid volume can help blend color and reduce overspray.

**Two Gun Method (to reduce blend edge):**

With a second spray gun, apply light coats of blending solvent, or TH0885 Reducer on the paint edge to help melt in the blend. Be sure to stay within the sanded area. Do not over-wet the edge.

**BUFFING – NOT RECOMMENDED FOR METALLIC COLORS****Light Polishing**

For removing minor imperfections, such as fine dust, dirt, or debris. Best used for blend edges, under cured or soft fresh color. The use of accelerator will allow early polishing in approximately 10 – 12 hours at 75°F/23°C. Color may be somewhat soft. Care must be taken when doing early polishing.

**Compounding**

For aggressively removing sand scratches and to flatten and level the paint surface. For use on longer air-dried or fully baked color coats. Air dry: 24 hours at 75°F/23°C then proceed with heavy compounding or buffing. Or use Full Bake Cycle and allow a 1 – 2 hours cool down prior to heavy compounding or buffing. Use P1500 grit sandpaper or finer to nib sand or to reduce orange peel. Finish sand with P2000 grit sandpaper or finer, then use a quality polishing system. Polish within the first 5 days of color application. Polishing Blends: Allow color to cure and dry according to recommendations. Follow with a light buff using a quality polishing system over the blend edge. Do not aggressively compound blend edges. Note: Buff or polish within the first 2 days for easiest results.

**RECOATABILITY**

When clearcoating, do not sand System 22 except for small spots (to remove dirt or debris). Then mist apply color coat – proceed with applying clear following the clearcoat directions. Allow a 24-hour cure time before re-working of clearcoated color. The use of a heat lamp will accelerate the cure cycle for re-repairs. Allow overnight cure before taping area for two-tone work. Re-coating can be done as soon as 16 hours or up to 72 hours without having to scuff unaccelerated System 22.



**COMPATIBLE CLEARCOATS (OPTIONAL)**

CRV22 Acrylic Urethane Universal Clear

Note: System 22 Color may be used in conjunction with CRV22 Clear in the following two ways. Topcoating – Properly activated CRV22 Clear may be applied directly over System 22 Color. Allow solid colors to flash 20 – 30 minutes before clearcoating. Allow metallic colors to flash 30 – 45 minutes before clearcoating, to avoid metallic shift. Mix CRV22 Clear according to directions and apply 2 coats for optimum protection. Allow each coat to flash properly – each coat should be hand slick before applying the next coat of clear.

**Integrated** – Properly activated CRV22 Clear may be mixed up to 100% (1:1) with pre-reduced and activated System 22 Color – this will provide a deep, rich finish with added protection. Apply 2 coats of activated color, allowing appropriate flash times between coats – each coat should be hand slick before applying more color or integrated color and clear. Mix CRV22 according to directions, and mix with remaining pre-activated and reduced color, up to 100% (1:1). Apply final coat of integrated color and clear.

**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. Air pressure dramatically affects the lightness and darkness of metallic colors. System 22 will be water resistant in 24 hours. Do not allow raindrops to dry on a new finish for the first 3 – 4 days to prevent staining. If Muriatic Acid is used to clean painted equipment, use a lead-free formula or clearcoat to avoid staining and for additional protection.



**DRY TIMES**

**AIR DRY**

@ 75°F/23°C

Dust Free	Approximately 15-20 minutes
Dry to Handle	16 – 20 hours
To Polish	See light polishing data
To Buff/Compound	24 hours
Cure	7 days

**FORCE DRY**

Bake 45 minutes at 140°F/60°C (or 30 minutes at 150°F/65°C). Allow a 20-minute purge. Allow a 2-hour cool down prior to assembling or buffing.



**PHYSICAL PROPERTIES**

Direct Impact	80 ft/lbs
Reverse Impact	50 ft/lbs
Solvent Resistance	MEK pass 100 rubs, Xylene pass 100 Rubs
Chemical Resistance	Acid (HCL) 10% – No Effect Sulfuric 5% - No Effect Phosphoric 42.5% - No Effect
RTS VOC	5.00 lbs/gallon (max)
RTS Volume Solids	30.60 – 32.50%
RTS Weight Solids	40.20%
Theoretical Coverage	492 – 544 Sq. Ft.
Film Hardness	2H
DFT per Coat	.60 – 1.00 mils
Flash Point	See SDS

Note: Do not allow raindrops to dry on a new finish for the first 3 – 4 days to prevent staining.



### STORAGE CONDITIONS

Store in a dry, well ventilated area. Storage temperatures should be between -30°F (-34°C) and 120°F (48°C).

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### VOC REGULATED AREAS

VOC as Applied

599 grams/liter | 5.00 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.

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### 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**  
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