





Montana Big Sky™ System 50 SkyBase Acrylic Basecoat Color System



COMPONENTS

System 50 Color
TH07100 Series Basecoat
Reducer




APPLICATION

2 - 3 wet coat 10 -15 minute
flash between coats; Allow final
coat 20 – 30 minute flash prior
to clearcoat



MIX RATIO

1 : 1




DRY TIME

Dust Free – 10 -15 minutes
To Handle –30 minutes



VISCOSITY

N/A



VOC

767 grams / liter
6.40 lbs / gallon



GENERAL

DESCRIPTION

Montana Big Sky System 50 SkyBase Basecoat Color is designed to provide excellent coverage, fast dry times, and great metallic control. This basecoat features easy repairability, excellent color holdout, and strong intercoat adhesion to clearcoats.

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
- 2.1 VOC Montana Big Sky Primers

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 1 part System 50 Basecoat to 1 part TH07100 Series Basecoat Reducer (see chart for proper reducer selection). Be sure to shake basecoat reducer prior to use.

Component	Volume
Montana Big Sky System 50 Basecoat	1
Montana Big Sky TH07100 Series Basecoat Reducer	1



REDUCER SELECTION

- TH07160 Fast 63 – 75°F / 17 – 23°C
- TH07175 Medium 68 – 80°F / 20 – 26°C
- TH07185 Slow 75 – 95°F / 23 – 35°C
- TH07195 Extra Slow 85°F + / 29°C +

POT LIFE

No pot life restrictions for uncatalyzed color. Close container after use. Occasional stirring may be desired to keep a uniform mix. Do not try to thin color after thickening has occurred – do not use. Clean equipment immediately after use. Note: Accelerators, reducers, and temperature will affect pot life.



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 Products primers and sealers. When using a sealer, final sand with P400 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 50 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 making 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 2 – 3 wet coats, allowing 10 – 15 minute flash between coats. Spray System 50 Basecoat to complete hiding while making sure metallics are even prior to clearcoating. Allow final coat to flash for 20 – 30 minutes prior to applying clearcoat. Extended flash times may be necessary for cooler spraying conditions or when using slower evaporating solvents. When two-toning, apply first color and allow 40 – 60 minute flash prior to taping for second color. Make sure the first color is dry before taping to avoid tape tracking.

Blending Color

Use a tack cloth to final wipe repair area. Tack clothes may be used between coats of System 50 Basecoat to eliminate overspray. Basecoat must be dry before re-tacking. Apply System 50 until hiding. Apply each coat beyond prior coat, keeping within the sanded blend area. Allow proper flash between coats. Lowering the air pressure on the last coat helps to blend out the color. Do not dry spray color. Apply clearcoat beyond the basecoat



and within the sanded blend area. For additional information on blending clearcoats, refer to the blending section found on the clearcoat product information sheets.

COMPATIBLE CLEARCOAT (OPTIONAL)

- CRV21 2K 2.1 VOC Urethane Crystal Clear Clearcoat
- CRV22 Urethane Glamour Clearcoat
- EZ317 2K EZ Clear Urethane Clearcoat
- PE1900 LightSpeed Clearcoat
- PE2442 Intense Fast Reaction Clearcoat

RECOATABILITY

Prior to clearcoating, do not sand System 50 except for small spots (to remove dirt or debris). Then re- apply more color coat – proceed with applying clear following the clearcoat directions. Allow a 24 hour cure time before re-working of clearcoated color, unless clear states otherwise. The use of a heat lamp will accelerate the cure cycle for re-repairs. Allow 40 – 60 minute flash before taping area for two-tone work. Make sure the first color is dry before taping to avoid tape tracking.

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. Clearcoated System 50 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.



DRY TIMES

AIR DRY

@ 75°F/23°C

Dust Free	10 – 15 minutes
Dry to Handle	30 minutes (basecoat must be cleared)
Cure	7 days

FORCE DRY

Do not bake until clearcoat has been applied.



PHYSICAL PROPERTIES

RTS VOC	6.40 lbs/gallon (max)
RTS Volume Solids	11.50 – 16.85% (dependant on color)
Theoretical Coverage	184.90 – 271.30 Sq. Ft.
DFT per Coat	0.30 – 0.50 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	767 grams/liter 6.40 lbs/gallon
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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

