Montana Big Sky™ System 28 Polyurethane Color System

COMPONENTS	System 28 Color PO28AN Hardener Opt: TH03X Zero VOC Urethane Reducer
APPLICATION	1 medium wet coat + 2 full wet coat 20-minute flash between coats; if 3rd coat, 20-minute flash between coats
MIX RATIO	3 : 1
DRY TIME	Dust Free – 60 – 90 Minutes To Handle - Overnight To Buff/Compound – 24 - 72 hours
VISCOSITY	N/A
VOC	336 grams / liter 2.80 lbs / gallon

GENERAL

DESCRIPTION

Montana Big Sky System 28 is a 2.8 lbs/gal VOC compliant single-stage polyurethane coating designed for durability and excellent chemical resistance. With a deep glamorous finish, it offers superior high gloss, excellent flow, optimal UV protection, and is flexible and impact-resistant.

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
- Montana Big Sky 2.1 VOC 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 3 parts System 28 Color to 1 part PO28AN Hardener.

Component	Volume
Montana Big Sky System 28 Color	3
Montana Big Sky PO28AN Hardener	1

HARDENER SELECTION
- PO28AN Hardener

REDUCER SELECTION
- Optional ½ part reduction with TH03X Zero VOC Urethane Reducer

SPECIALTY COMPONENTS (OPTIONAL)
- PE35ACC Accelerator
- CR22FEE Fisheye Eliminator
- TH03X Zero VOC Urethane Reducer

Accelerator: If needed, use 1 – 2 ounces of PE35ACC 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. Do not use accelerator if baking. The use of PE35ACC will extend pot life and increase cure rate by approximately 4 hours.

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
1-2 hours @75°F/23°C
We suggest mixing only enough product for a single coat. Note: Accelerators, reducers and temperature will affect pot life. Do not try to thin color after thickening has occurred – do not use.

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.

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 20-minute flash or until surface is hand slick. Apply a 2nd full wet coat.
If a 3rd coat is needed, allow 20-minute flash 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.

BUFFING

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 (Not recommended for metallic colors)

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 – 72 hours at 75°F/23°C then proceed with heavy compounding or buffing. Or use Full Bake Cycle and allow a 4 hour 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.

RECOATABILITY

Allow a 24 hour cure time before re-working of 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 may be done as soon as 16 hours or up to 72 hours without having to scuff unaccelerated System 28.

SPECIAL NOTES

Use in shop temperatures that are maintained above 75°F/23°C for the first 24 hours of the cure cycle. System 28 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 Muratic 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	60-90 minutes
Dry to Handle	Overnight
To Polish	See polishing data
To Buff/Compound	24 hours
Cure	7 days

FORCE DRY

Bake 60 minutes at 145°F/62°C. Allow a 10-15-minute purge. Allow a 4-hour cool down prior to assembling or buffing. Do not bake color when using accelerator.

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	2.80 bs/gallon (max)
Mixed Volume Solids	48.50 – 51.00% (dependant on color)
Theoretical Coverage	804 Sq. Ft.
Film Hardness	2H
DFT per Coat	1.00 – 1.50 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).

VOC REGULATED AREAS

VOC as Applied	336 grams/liter | 2.80 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