Montana Big Sky™ PE4000 Acrylic Urethane Clearcoat

COMPONENTS	PE4000 Clearcoat MP4065, MP4075, MP4085 or MP4095 Hardener
APPLICATION	2-3 coats 10-15 minute flash between coats
MIX RATIO	4 : 1
DRY TIME	Dust Free – 30 minutes To Polish – 8-10 hours To Compound – 12-14 hours
VISCOSITY	N/A
VOC	515 grams / liter 4.3 lbs / gallon

GENERAL

DESCRIPTION

Montana Big Sky PE4000 is an Acrylic Urethane Clearcoat with a 4.3 lbs/gal (515 g/L) VOC. This medium, solids clear is designed to provide an OEM gloss and DOI (Distinction of Image) as well as good leveling and chemical resistance. PE4000 is formulated for excellent UV protection and very good next day buffability. This acrylic urethane clear, works well for general purpose spot repairs, panel repair or complete refinishing.

COMPATIBLE SUBSTRATES

- Refinish basecoat color
- OEM Basecoat and Enamel Finishes properly prepared
- Cured, aged refinishes properly prepared
- **Do not** use over lacquer topcoat color
- Catalyzed Acrylic urethane Topcoats

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

MIXING

COMPONENTS

Mix 4 part PE4000 Acrylic Urethane Clearcoat with 1 part MP4065, MP4075, MP4085 and MP4095 Hardeners.

Component	Volume
Montana Big Sky PE4000 Clearcoat	4
Montana Big Sky MP40X5 Hardener	1

HARDENER SELECTION

- MP4065 Fast 65-75°F / 18-23°C
- MP4075 Medium 75-85°F / 23-29°C
- MP4085 Slow 85-95°F / 29-35°C

SPECIALTY COMPONENTS

- CR22FEE Fisheye Eliminator (only use if needed)
- SP40 Universal Matting base

Accelerator – Not recommended.

Fisheye Eliminator – If needed, add 1 – 2 ounces of CR22FEE per ready-to-spray gallon (or ¼ - ½ ounce per ready-to-spray quart).

POT LIFE

2-3 hours at 75°F/23°C.
Note: Accelerators, reducers and temperature will affect pot life.

APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 - 1.4 mm	8 – 10 PSI	*At the cap
High Efficiency	1.3 - 1.4 mm	27 – 32 PSI	At gauge

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

SURFACE PREPARATION

Properly applied basecoat sprayed in accordance with the manufacture's data sheet.

APPLICATION

Allow basecoat to properly dry according to suggested dry times and spray conditions. Apply one medium- to full-wet coat of clear and allow 10 - 15 minutes flash time or until surface is hand slick. Apply a second full-wet coat. A third coat of clear may be applied to increase depth and DOI or if extensive sanding and polishing is anticipated.

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

Dust Free	30 minutes
To Polish	8-10 hours
To Compound	12-14 hours
Cure	7 days

FORCE DRY

Bake 30 minutes at 140°F/60°C. No purge time is necessary. Allow a 1 – 2 hour cool down prior to assembling or buffing.

PHYSICAL PROPERTIES

Direct Impact	50 ft/lbs
Reverse Impact	25 ft/lbs
Chemical Resistance	MEK pass 100 double rubs, Xylene pass 100 rubs
RTS VOC	4.3 lbs/gallon
RTS Volume Solids	30.70%
RTS Weight Solids	36.50%
DFT per Coat	1.0 ± 0.20
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	515 grams/liter | 4.3 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