



Montana® Big Sky® Product Information Sheet

Technical Support (800) 328-4892

TDS_BS_PE4000

PE4000™ C.A.C.™ Acrylic Urethane Clearcoat 4.3 VOC

READ ENTIRE PRODUCT INFORMATION SHEET PRIOR TO USE. IF ANY QUESTIONS ARISE, PLEASE CALL TECHNICAL SUPPORT.

COMPONENTS (REQUIRED)



- PE4000™ Clear
- MP4065™ Fast Activator
- MP4075™ Medium Activator
- MP4085™ Slow Activator
- MP4095™ Extra Slow Activator

SPECIALTY COMPONENTS

- CR22ACC™ Accelerator
- CR22FEE™ Fisheye Eliminator
- SP40™ Universal 2.1 VOC Matting Base

DESCRIPTION:

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

PREPARATION

Properly applied Basecoat sprayed in accordance with the Manufacturer's data sheet

COMPATIBLE SUBSTRATES

- Refinish Basecoat Color
- Catalyzed Acrylic Urethane Topcoats
- Cured Aged Finishes
- OEM Basecoat and Enamel Finishes
- Catalyzed Acrylic Enamels

Note: Do Not Use Over Lacquer

MIX BY VOLUME



- 4 Parts PE4000™ Clear
- 1 Part MP4065™, MP4075™, MP4085™ or MP4095™ Activator

Note: We recommend using activators within 14 days of opening to maintain maximum performance. Replace lids on all paint products immediately after use to avoid moisture or oxygen contamination.

SPECIALTY COMPONENTS



Accelerator – Not recommended except for use in cool temperatures.

- Do not use accelerator if baking.
- If temperatures are bordering 68°F/20°C or cooler, CR22ACC™ may be added at a level of 1 - 2 ounce per ready-to-spray gallon (or ¼ - ½ ounce per ready-to-spray quart).



Fisheye Eliminator – Only 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.

EQUIPMENT SETUP



HVLP
High Efficiency

Fluid Tip
1.3 – 1.4mm
1.3 – 1.4mm

Air Pressure
8 – 10 PSI at the cap
27 – 32 (PSI) Inlet Pressure

Note: These are starting points for spray gun recommendations. Refer to spray gun manufacturers recommendations for proper setup and operation. Additional adjustments may be necessary.

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 or until surface is hand slick.
- Apply a 2nd full wet coat.
- A 3rd coat of clear may be applied to increase depth and DOI or if extensive sanding and polishing is anticipated.

BAKING

Note: Do not bake clear when using accelerator.

Full Bake Cycle

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

RE-COATING

- Allow clear to dry overnight at 75° F/23°C prior to reapplying color coat.
- In temperatures below 75° F/23°C, the use of a heat lamp will help cure the break through edge so lifting will be minimized.

PERFORMANCE TIPS

- Shop and surface temperatures should be maintained at or above 75°F/23°C for the first 24 hours of the cure cycle. Cooler temperatures may result in slower drying, curing and overall performance.
- Clear will be water resistant in 24-hours. **Note:** Do not allow raindrops to dry on any new finish for the first 3 – 4 days to prevent staining.
- Urethane coatings take an average 5 – 7 days at 75° F/23°C to properly cure. Care should be taken during first week of washing. DO NOT pressure wash fresh clear. DO NOT wax or seal for 60 days.
- Exercise caution when placing vehicles in direct intense sunlight shortly after applying color or clear.

PHYSICAL DATA

PE4000™ C.A.C.™ Acrylic Urethane Clear			
Mixing by Volume:	Clear : Activator	Dry to Polish:	8 -10 hours @ 75° F/ 23°C
RTS VOC:	4.3 lbs/gal (515 g/L)	Dry to Compound:	12 -14 hours @ 75° F/ 23°C
RTS Weight Solids:	36.5%	Direct Impact:	50 ft/lbs
RTS Volume Solids:	30.7%	Reverse Impact:	25 ft/lbs
Avg. Time to Hand Slick:	3 to 5 minutes	Cure:	7 days@ 75° F/23°C
Avg. Dust Free Time:	30 minutes	Chemical Resistance:	MEK pass 100 double rubs
Avg. DFT per Coat:	1.0 mil + .20		Xylene pass 100 rubs
Recommended Total DFT:	2.0-2.3 mils of Clear	Flash Point:	See SDS
Theoretical Coverage @ 1 mil	495 sq ft.		

WEATHERING DATA

Gloss Meter Angle	Initial Gloss	1000 Hours QUV Exposure	Chemical Resistance	Impact Test Forward	Impact Test Reverse
20°	87.20	85.40	100 MEK Double Rubs. Pass	45 lbs. Pass	25 lbs. Pass
60°	94.20	92.00			

CLEAN-UP

Clean spray equipment immediately following application with a quality thinner or spray gun cleaner.

DISPOSAL

Dispose of all paint and paint related materials in accordance with state and local regulations.

SAFETY & HEALTH

Read and follow all technical product information, labels, and SDS prior to application. Keep product out of reach of children and animals. Always wear proper safety equipment (respirator, gloves, eye, and clothing protection) when using this product.

COMPANY INFORMATION

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