



Montana® Big Sky® Product Information Sheet

Technical Support (800) 328-4892

TDS_BS_FE40

FE40™ Chassis Black

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

COMPONENTS (REQUIRED)



- FE40™ Chassis Black
- TH5000™ Series Synthetic Enamel Reducer

SPECIALTY COMPONENTS (OPTIONAL)

- MP2000™ Catalyst

DESCRIPTION:

FE40™ Chassis Black is an economical protective coating for chassis, engine compartments, and miscellaneous parts refinishing. It has excellent adhesion and impact resistance. FE40™ is resistant to fuels when thoroughly cured using MP2000™ Catalyst.

PREPARATION

- 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.
- Final sand bare metal with P150 - P220 grit sandpaper. Finish sand painted surfaces using P220 – P320 grit sandpaper.
- Final clean with TH5951™ Mild Wax & Grease Remover, making sure surface is clean and dry.
- Final wipe using a tack cloth.

COMPATIBLE SUBSTRATES

- Bare Steel
- PS3042™/PS3044™/PS3045™ Epoxy Prime™

MIX BY VOLUME



- 4 Parts FE40™ Chassis Black
- 1 Part TH5000™ Series Reducer (see chart for proper reducer selection)

Proper Reducer Selection	
TH5800™ Fast	63°F – 88°F/17°C – 31°C
TH5900™ Medium	85°F - 105°F/29°C – 40°C
TH5700™ Slow	85°F - 105°F/29°C – 40°C

OPTIONAL MIX BY VOLUME – FOR ADDED DURABILITY & PROTECTION

- 8 Parts FE40™ Chassis Black
- 1 Part MP2000™ Catalyst
- 2 Parts TH5000™ Series Reducer

POT LIFE



- 4 – 6 hours at 75°F/23°C (if catalyzed with MP2000™)
- 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.

EQUIPMENT SETUP



HVLP
High Efficiency

Fluid Tip
1.4 – 1.6mm
1.4 – 1.6mm

Air Pressure
6 – 10 PSI at the cap
17-32 (PSI) Inlet Pressure

APPLICATION



- Allow appropriate dry times for primers and sealers.
- Strain paint prior to application.
- Apply one medium-wet coat and allow 10 minute flash or until surface is hand slick.
- Apply a 2nd full wet coat.
- For best results, do not apply more than 2 coats.

BAKING – FE40™ MUST BE CATALYZED IN ORDER TO BAKE OR FORCE DRY.

- Allow 30 minute purge.
- Bake 30 minutes – 1 hour at 140°F/60°C.
- Allow a 2 hour cool down prior to assembling.

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.
- Ensure proper metal conditioning/preparation procedures in early stages are followed.
- Use a mixing cup for accurate volume measurements.
- FE40™ will be water resistant in 24 hours. **Note:** Do not allow raindrops to dry on a new finish for the first 3 – 4 days to prevent staining.

PHYSICAL & WEATHERING DATA

Mixed 4:1	
Dust Free	20 minutes (will vary with catalyst & reducer)
Dry to Handle	2 hours
Recommended Coats	2
Solvent Resistance	Xylene pass 100 rubs (With MP2000)
VOC as Applied	5.00 lbs./gallon
DFT per Coat	.80 ± .20 mils
Mixed Volume Solids	25.00%
Theoretical Coverage	402 square feet @ 1 mil DFT
Film Hardness	2H (with MP2000™ Catalyst)

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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