



Montana® Big Sky® Product Information Sheet

Technical Support (800) 328-4892

TDS_BS_PE1900

PE1900™ LightSpeed™ Spot & Panel Clear – 4.2 VOC

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

COMPONENTS



PE1900™ Fast Set Spot & Panel Clear
MP1965™ / MP1975™
MP1985™ / MP1995™ Activators

SPECIALTY COMPONENTS

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

DESCRIPTION:

LightSpeed™ Clearcoat was designed for spot and panel application over properly applied basecoat color. This two component clear has fast setting dust free times and delivers outstanding gloss with low overspray. PE1900™ LightSpeed™ clear increases productivity by maximizing vehicle throughput and may be polished as soon as two hours.

PREPARATION

PE1900™ LightSpeed™ CLEAR IS DESIGNED TO BE APPLIED OVER SPRAYED BASECOAT COLOR

SUBSTRATES

- Refinish basecoat color
- OEM B/C and Enamel Finishes properly prepared
- Cured aged refinishes properly prepared
- ** **Do Not** use over lacquer topcoat color

MIX BY VOLUME



- 4 Parts PE1900™ Clear
- 1 Part Activator (see chart for proper activator selection)

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.

Activator	Temperature Range
MP1965™ Fast	63 – 88°F/17 – 31°C
MP1975™ Medium	75 - 85°F/23 – 29°C
MP1985™ Slow	85°F/29°C +
MP1995™ XSlow	90°F/32°C +

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 ounce per ready-to-spray gallon (or ¼ ounce per ready-to-spray quart).



Fisheye Eliminator – Only if needed.

POT LIFE

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



Equipment Setup



HVLP Gravity
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

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 5 – 10 minute flash or until surface is hand slick.
- Apply a second coat of clear. A 3rd coat may be applied after 5 – 10 minute flash to increase depth or if extensive sanding and polishing is anticipated. More coats will extend dry and polishing times.
- Do not apply more clear after 1-hour of applying previous coats of clear.

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.

RE-COATING

- Allow clear to dry overnight at 75° F/23°C prior to reapplying color coat.
- Re-clearing may be done as soon as 16 hours or up to 72 hours without having to scuff clear. Due to the strength of some reducers, care needs to be taken if a new color-coat is going to be applied over fresh clear.
- Do not expose to Rain for the first 24 hours when air dried. Excessive moisture on fresh clear can cause a milkiness Appearance within the film.

DATA

PE1900™ LightSpeed™ CLEAR MIXED 4:1 USING MP1975™ @ 75° F/23°C			
Mixing by Volume:	Clear : Activator within the film	Dry Time to Polish:	2 hours
RTS VOC:	4.23 lbs./gallon max	Dry Time to Compound:	6 – 8 hours
RTS Weight Solids:	38.10%	Direct Impact:	50 ft/lbs
RTS Volume Solids:	32.00%	Reverse Impact:	25 ft/lbs
Avg. Time to Hand Slick:	3 - 5 minutes	Cure:	7-days
Avg. Dust Free Time:	8 -10 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	Flash Point:	See SDS

WEATHERING DATA

Gloss Meter Angle	Initial Gloss	2100 Hours QUV Exposure
20°	87.20	85.40
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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