



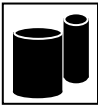
# Montana® Big Sky® Product Information Sheet

Technical Support (800) 328-4892

TDS\_BS\_PE2400

## PE2400™ 4:1 Acrylic Urethane Clear – 4.4 VOC

### COMPONENTS



PE2400™ Clear  
MP2465™ / MP2475™ / MP2485™ Activator

### SPECIALTY COMPONENTS (OPTIONAL)

CR22ACC™ Accelerator  
CR22FEE™ Fisheye Eliminator  
TH035™/36/37 Zero VOC Reducer  
TH01000™ Edge Blender™  
SP40™ Universal 2.1 VOC Matting Base

### DESCRIPTION:

PE2400™ 4.4 VOC Clear was designed to add value to shop profitability by offering easy application and polishing while providing an excellent UV resistance. This clearcoat meets National Rule requirements.

### PREPARATION

- Properly Applied Basecoat in Accordance with Manufacturer's Data Sheet

### COMPATIBLE SUBSTRATES

- Big Sky® System 10™ Acrylic Enamel Single Stage Color (when activated)
- Big Sky® System 50™ SkyBase® Basecoat
- Sky Fleet™ System 12™ Acrylic Enamel Single Stage Color (when activated)
- BASF R-M® Diamont® Basecoat
- Axalta® ChromaBase® Basecoat
- Axalta® ChromaPremier® Basecoat
- Martin Senour® TEC® Base
- Sherwin-Williams® Ultra 7000 Basecoat®
- PPG® Concept DBC®
- Sikkens® Autocryl® Base
- PPG® Deltron DBU®
- Spies Hecker® Permacron®
- PPG® Omni® AU Basecoat
- Valspar® Basecoat

### MIX BY VOLUME



- 4 Parts PE2400™ Clear
- 1 Part MP2465™, MP2475™, or MP2485™ Activator (see chart for proper activator selection)
- Optional 10% reduction with TH035™/36/37 Zero VOC Reducer

Activator	Temperature Range
MP2465™ Fast	63°F – 88°F/17 – 31°C
MP2475™ Medium	75°F - 85°F/23 – 29°C
MP2485™ Slow	85°F/29C +

## SPECIALTY COMPONENTS



**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



- 3 hours at 75°F/23°C.

## EQUIPMENT SETUP



HVLP Siphon  
High Efficiency

1.3 – 1.4mm  
1.3 – 1.4mm

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

## APPLICATION



- Allow basecoat to dry for 30 minutes or longer if manufacturer suggests longer dry times. Single stage colors may require longer flash times, usually 1 – 1 ½ hours longer.
- Apply one medium-wet coat and allow 10 – 15 minutes flash.
- Apply a 2<sup>nd</sup> full wet coat.
- Do not apply more clear after 1 hour of applying previous coats of clear.
- Apply 2 full coats of clear for proper film build and protection (2.0 mils dry film minimum). Excessive amounts of clear will retard drying and curing, and may cause die-back.

## BAKING

**Note:** Do not bake clear when using accelerator.

- No purge time is necessary.
- Bake 30 – 35 minutes at 140°F/60°C.

## RE-WORKING

- Due to the strength of some reducers, care needs to be taken if new color coat is going to be applied over fresh clear.
- Allow clear to dry overnight at 75°F/23°C prior to reapplying color coat. If a full break through of clear is done while making a repair, lightly apply color using a faster flashing reducer.
- 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.
- Re-clearing may be done as soon as 16 hours or up to 72 hours without having to scuff clear.
- If clear is in the first 30 - 45 minutes of dry time, and color needs to be sprayed due to metallic shift or inadequate hiding, apply a light coat of color to achieve desired hide, then re-clear. Avoid excessive film builds.
- PE2400™ 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.
- Urethane coatings take 5 – 7 days to properly cure. Care should be taken during first week of washing. Do not use a pressure washer on fresh clear.
- Stain free body filler is recommended for use under light colors.
- Do not use over lacquer.

**PHYSICAL & WEATHERING DATA**

<b>Mixed 4:1</b>	
<b>Dust Free</b>	Approximately 20 minutes
<b>Dry to Polish</b>	8 hours at 75°F/23°C
<b>Dry to Buff/Compound</b>	10 – 12 hours at 75°F/23°C
<b>Cure</b>	7 days at 75°F/23°C
<b>Direct Impact</b>	60 ft/lbs
<b>Reverse Impact</b>	30 ft/lbs
<b>Chemical Resistance</b>	MEK pass 100 double rubs Xylene pass 1000 rubs
<b>RTS VOC</b>	4.4 lbs/gal (527 g/L)
<b>RTS Volume Solids</b>	33.00%
<b>RTS Weight Solids</b>	39.5%
<b>DFT per Coat</b>	1.00 ± .20
<b>Flash Point</b>	See SDS

**WEATHERING DATA**

<b>Gloss Meter Angle</b>	<b>Initial Gloss</b>	<b>1500 Hours QUV Exposure</b>
20°	89.0	85.0
60°	94.0	93.0

**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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