



Montana Big Sky™ PE1500 2K 2.1 VOC Speed Clearcoat



COMPONENTS

PE1500 Clearcoat
MP1575 or MP1585 Hardener



APPLICATION

1-2 coats
1-5 minute flash between coats



MIX RATIO

4 : 1



DRY TIME

To Hand Slick – 5-10 minutes
To Polish – 45-60 minutes
To Compound – 2-4 hours



VISCOSITY

N/A



VOC

252 grams / liter
2.1 lbs / gallon



GENERAL

DESCRIPTION

Montana Big Sky PE1500 2K 2.1 VOC Speed Clearcoat may be used for spot and panel application over properly applied basecoat color. This two-component clear is designed for fast setting, dust free dry times and delivers outstanding gloss with low overspray. PE1500 clear increases productivity by maximizing vehicle throughput and may be polished as soon as ¾ - 1 hour.

COMPATIBLE SUBSTRATES

- Refinish basecoat color
- OEM B/C and Enamel Finishes properly prepared
- Cured, aged refinishes properly sanded

Note: Do not use over lacquer topcoat color

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



MIXING

COMPONENTS

Mix 4 parts PE1500 Clear with 1 part hardener. Reduction is not necessary, but can be reduced 10% if desired. To maintain 2.1 VOC use TH035/TH036/TH037 series reducers.

Component

Montana Big Sky PE1500 2K 2.1 VOC Speed Clearcoat
Montana Big Sky MP15X5 Hardener

Volume

4
1



HARDENER SELECTION

	<u>Panel</u>	<u>Multi-Panel</u>
• MP1575 Medium	60-80°F / 15-26°C	60-75°F / 15-23°C
• MP1585 Slow	75-100°F / 23-37°C	75-95°F / 23-35°C

SPECIALTY COMPONENTS

- CR22FEE Fisheye Eliminator (only use if needed)
- SP40 Universal 2.1 VOC Matting base

POT LIFE

1-2 hours at 75°F/23°C



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 - 1.4 mm	6 – 8 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

PE1500 Clear is designed to be applied over properly sprayed basecoat color.

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 1 – 5 minute flash or until surface is hand slick. Apply a second coat of clear. Do not apply more clearcoat after 1-hour of applying previous coats of clearcoat.

RECOATING

Due to the strength of some reducers, care needs to be taken if new color coat is going to be applied over fresh clearcoat. Allow clearcoat to dry 24 hours at 75°F/23°C prior to reapplying color coat. If a full break through of clearcoat occurs while making a repair, lightly apply color using a fast flashing reducer. It may be necessary to create a barrier using a catalyzed primer to avoid lifting on the repair edge. Re-clearing may be done as soon as 8 hours or up to 24 hours without having to scuff the clearcoat.

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

To Hand Slick	5-10 minutes
Dust Free	10-15 minutes
To Polish	45-60 minutes
To Compound	2-4 hours
Cure	7 days

Note: Use of MP1585 hardener will extend the sprayability enabling a larger refinish.

*Do not expose to rain for the first 24 hours when air dried. Excessive moisture on fresh clearcoat can cause a milkiness appearance within the film.

**FORCE DRY**

Do not bake clear prior to outdoor exposure. If weather cold and damp, allow ½ hour dry time then infrared for 10 minutes.



PHYSICAL PROPERTIES

RTS VOC	2.1 lbs./gallon (252 g/L)
RTS Volume Solids	34.5%
RTS Weight Solids	37.0%
Avg. DFT per Coat	1.0 mil ± 0.20
Recommended Total DFT	2.0-2.3
Direct Impact	50 ft/lbs
Reverse Impact	25 ft/lbs
Chemical Resistance	MEK pass 100 double rubs Xylene pass 100 rubs
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 252 grams/liter | 2.1 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.

Revised: May 2019

In the United States and Canada:

1.855.6.AXALTA
montanabigsky.us

