



Montana® Big Sky® Product Information Sheet

Technical Support (800) 328-4892

TDS_BS_PE2600

PE2600™ 2:1 Acrylic Urethane Clear – 4.3 VOC

COMPONENTS



PE2600™ Clear
MP2665™ / MP2675™ / MP2685™ Activator

SPECIALTY COMPONENTS (OPTIONAL)

CR22ACC™ Accelerator
CR22FEE™ Fisheye Eliminator
TH035™/36/37 Zero VOC Reducer
TH01000™ Edge Blender™

DESCRIPTION:

PE2600™ Clear Shot™ Acrylic Urethane Clear provides a deep rich gloss with premium durability. Using quality urethane technology, PE2600™ offers the versatility needed for spot, multi-panel and overall refinishing, while providing quick delivery and ease of use.

PREPARATION PROPERLY APPLIED BASECOAT IN ACCORDANCE WITH THE 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



- 2 Parts PE2600™ Clear
- 1 Part MP2665™, MP2675™, or MP2685™ Activator (see chart for proper activator selection)
- Optional 10% reduction with TH035™/36/37 Zero VOC Reducer

Activator	Temperature Range
MP2665™ Fast	63°F – 88°F/17°C – 31°C
MP2675™ Medium	75°F - 85°F/23°C – 29°C
MP2685™ Slow	85°F – 29°C +

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.
- 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

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 minute flash.
- Apply a 2nd 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.

Full Bake Cycle

- No purge time is necessary.
- Bake 30 – 35 minutes at 140°F/60°C.
- Allow a 1 – 2 hour cool down prior to assembling or buffing.

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.

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.
- Use a mixing cup for accurate volume measurements.
- PE2600™ will be water resistant in 24-hours. **Note:** 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.
- 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

Mixed 2:1	
Dust Free	Approximately 20-minutes
Dry to Polish	8-hours at 75°F/23°C
Dry to Buff/Compound	12 – 16 hours at 75°F-232°C(Overnight)
Cure	7-days at 75°F/23°C
Direct Impact	60 ft/lbs
Reverse Impact	30 ft/lbs
Chemical Resistance	MEK pass 100 double rubs Xylene pass 1000 rubs
RTS VOC	4.2 – 4.3 lbs/gal (503 - 515 g/L) (varies with activator)
RTS Volume Solids	36.00%
RTS Weight Solids	43 - 44%
DFT per Coat	1.00 ± .20
Flash Point	See SDS

WEATHERING DATA

Gloss Meter Angle	Initial Gloss	2500 Hours QUV Exposure
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

ChemSpec USA, LLC.
9287 Smucker Road
Orrville, Ohio 44667
Toll Free: (800) 328-4892
Fax: (330) 669-3965
Website: www.chemspecpaint.com