



# Montana® Big Sky® Product Information Sheet

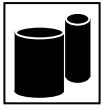
TECHNICAL SUPPORT (800) 328-4892

TDS\_BS\_PS3042-44-45

## PS3042™ (Lt. Gray) PS3044™ (Dk. Gray) PS3045™ (Black) Epoxy Prime™ Primer/Sealer

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

### COMPONENTS



PS3042™ Light Gray Epoxy Primer  
PS3044™ Dark Gray Epoxy Primer  
PS3045™ Black Epoxy Primer  
PA3040E™ Epoxy Catalyst (Express)

### SPECIALTY COMPONENTS

PA3040V™ Low 3.5 VOC Catalyst  
TH035™/ 36 / 37 Zero VOC Reducer

### DESCRIPTION:

Epoxy Prime™ two-component, chromate-free epoxies are designed for use as medium fill primers that provide optimum adhesion with excellent corrosion protection for bare substrates. Epoxy Prime™ may also be applied as a sealer to ensure greater inter-coat adhesion, chemical resistance, and color holdout. Epoxy Prime™ is a full epoxy resin that utilizes a non-induction catalyst, used to increase productivity for automotive and fleet refinishing. If required, Epoxy Prime™ has a 3.5 VOC catalyst, used for fleet and light industrial applications.

### COMPATIBLE SUBSTRATES

- Properly cleaned and conditioned steel, stainless, aluminum, galvanized steel, copper, and brass.
- Thoroughly sanded OEM and cured paint.
- Cured and sanded body filler.
- Sanded Fiberglass and SMC.
- Properly prepared plastic.

**Note:** Do Not use over soluble substrates, DTM, Acid Etch Primer™, lacquer primer or lacquer finishes.

### MIX BY VOLUME



#### As a Medium Build Primer

- 1 Part Epoxy Prime™
- 1 Part Epoxy Catalyst



#### As a Sealer

- 1 Part Epoxy Prime™
- 1 Part Epoxy Catalyst
- ¼ Part VOC Compliant Urethane Reducer

#### Catalyst Recommendations:

**PA3040E™:** (Express) Non-induction hardener, providing faster drying properties and no waiting to use once mixed.

**PA3040V™:** Non-induction, should be used when 3.5 VOC is required.

**Note:** We recommend using catalysts within 14 days of opening to maintain maximum performance. Replace lids on all paint products immediately after use to avoid moisture or oxygen contamination.

## POT LIFE



- 16-hours at 75°F/23°C.
- Clean equipment immediately after use.

## EQUIPMENT SETUP

### Fluid Tip

### Air Pressure



HVLP  
High Efficiency

1.4 – 1.6mm  
1.4 – 1.6mm

7 – 10 PSI at the cap  
27– 32 (PSI) Inlet Pressure

**Note:** These are starting points for spray gun recommendations. Refer to spray gun manufacturers recommendations for proper setup and operation. Additional adjustments may be necessary.

## PRIMER APPLICATION



- Apply in single wet coats, allowing 15 minute, flash between coats.
- Apply 1 - 2 coats, depending on desired film build.
- A light coat of body filler may be applied over 1 coat of Epoxy Prime™ after 2 hours at 75°F/23°C. If two coats of Epoxy Prime™ are applied, wait overnight before applying filler.

## SEALER APPLICATION

- Apply 1 single wet coat of Epoxy Prime™ reduced as a sealer, to create a uniform base.
- Allow to flash for 45 - 60 minutes at 75°F/23°C before applying topcoats.

## DRY TIME TO SAND

### Primer Option:

**Note:** As a rule, epoxy primers do not sand well until completely dry.

- Air Dry: Overnight at 75°F/23°C for best results
- Final sand with P400 - P600 grit sandpaper before topcoating.

### Sealer Option:

- Sealer option does not require sanding if topcoated within maximum recoat time.
- If necessary, Air Dry: 45 - 60 minutes at 75°F/23°C before sanding to remove debris.

## TIME TO TOPCOAT

### Primer Option:

- Minimum 1-hour dry time per coat and maximum 24 hours at 75°F/23°C.
- Between 24-72 hours, Epoxy Prime™ must be sanded prior to topcoating.
- After 72 hours, Epoxy Prime™ must be sanded and recoated with a single coat of Epoxy Prime™, prior to topcoating.

### Sealer Option:

- Minimum 45 minute, dry time and maximum 6 hours at 75°F/23°C prior to topcoating.
- Between 6 - 24 hours, Epoxy Prime™ must be sanded prior to topcoating.
- After 24 hours, Epoxy Prime™ must be sanded and recoated with a single coat Epoxy Prime prior to topcoating.

## FLEXIBLE PARTS

- We suggest the use of AP200™ Plastic Adhesion Promoter prior to priming. Refer to TDS\_BS\_AP200 for additional information on AP200™.
- Refer to Information Bulletin #MC31 for further information about plastic refinishing.

## COMPATIBLE TOPCOATS

- System 10™ Acrylic Enamel Color
- System 20™ Synthetic Enamel Color
- System 28™ 2.8 VOC Polyurethane Color
- System 50™ SkyBase® Basecoat Color
- Metalux® International Basecoat Color
- Polyurethane Topcoats
- System 12™ Acrylic Enamel Color
- System 22™ Acrylic Urethane Color
- System 35™ 3.5 VOC Polyurethane Color
- Acrylic Urethane Topcoats
- Acrylic Urethane Primer-Surfacers
- Acrylic Enamels

√ **Tech Tip:** Activated basecoats offer better chemical resistance and inter-coat adhesion.

## PHYSICAL DATA

Primer Surfacer/Standard Catalyst (Mix 1:1) at 75°F/23°C		Sealer (Mix Ratio 1:1:1/4) with VOC Compliant Reducer	
Dry to Sand	Best Overnight	Dry to Topcoat	30 - 45 minutes (single coat)
Film Thickness	1.0 ± 0.2 mils per coat	Film Thickness	.8 ± 0.2 mils per coat
Volume Solids	32.9	Volume Solids	29.2
VOC Applied	4.6 (551 g/L)	VOC Applied	4.6 (551 g/L)
Theoretical Coverage RTS	529sq. ft. @ 1 mil	Theoretical Coverage RTS	469 sq. ft. @ 1 mil
Flash Point	See SDS	Flash Point	See SDS

## 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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