



Montana Big Sky™ 3.5 Low VOC Basecoat



COMPONENTS

3.5 Low VOC Basecoat
LR65/LR75/LR85/LR95 Basemaker



APPLICATION

2-3 coats
5-10 minute flash between coats



MIX RATIO

1 : 1



DRY TIME

Dust free – 10-15 minutes
To handle – 30 minutes



VISCOSITY

N/A



VOC

420 grams / liter
3.5 lbs / gallon



GENERAL

DESCRIPTION

Montana Big Sky™ 3.5 Low VOC Basecoat is a VOC-compliant refinish system at 420 grams/liter (3.5 lbs/gal) for use in regulated areas. The basecoat features a wide range of solid, metallic, pearl and special effect colours and was designed to deliver high gloss, precision colour match, superior metallic orientation and excellent flow characteristics.

PACKAGE SIZES

- 0.5 Liter
- 1 Liter
- Gallon (3.5 Liters)

COMPATIBLE SUBSTRATES

- Properly sanded OEM Finishes
- Properly sanded Cured Aged Finishes
- PS5011™/PS5012A™/PS5015™ 2K 2.1 VOC Urethane Primer
- PS3401™/PS403™/PS3405™ 2K 2.1 VOC DTM Primer Surfacer

These substrates may be directly topcoated; however, we suggest sealing prior to colour coating for optimum results



MIXING

COMPONENTS

Mix 1 Part Montana Big Sky 3.5 Low VOC Basecoat with 1 Part LR65, LR75, LR85, or LR95 Basemaker.

NOTE: Be sure to shake basecoat reducer prior to use.



Component	Volume
Montana Big 3.5 Low VOC Basecoat	1
Montana Big Sky Basemaker (LR65, LR75, LR85, LR95)	1

Component	Temperature Range
LR65 Fast	65 – 75°F/18 – 24°C
LR75 Medium	70 - 80°F/21 – 27°C
LR85 Slow	75 - 90°F/24 – 32°C
LR95 Very Slow	85 - 100°F/29 – 38°C

COMPATIBLE CLEARCOATS

- CRV21™ 2K 2.1 VOC Urethane Crystal Clear Clearcoat
- PE1500™ 2K 2.1 VOC Speed Clearcoat
- PE2300™ 2K 2.1 VOC Acrylic Urethane Clearcoat 800

POT LIFE

No pot life restrictions for uncatalyzed colour. Close container after use. Clean equipment immediately after use.



APPLICATION



APPLICATION EQUIPMENT

HVLP Gravity	1.3 - 1.4 mm	6 – 8 PSI	*At the cap
High Efficiency	1.3 - 1.4 mm	19 PSI	At gauge

NOTE: Refer to spray gun manufacturer for further information regarding HVLP Inlet Pressures

SURFACE PREPARATION

Overall or Full Panel Repair

Prior to repair, wash the surface with mild detergent and hot water, making sure to rinse well and dry with a clean dry cloth. Solvent clean with TH5953™ Zero VOC Surface Cleaner to remove any contaminants prior to sanding or bodywork. Make all repairs – treat bare metals and prime with appropriate Montana Big Sky™ primers and sealers. When using a sealer, final sand with P400 grit sandpaper or finer. When topcoating over sanded substrates, finish sand with P500 - P800 grit sandpaper. Final clean with TH5953™ Zero VOC Surface Cleaner, making sure surface is clean and dry. Final wipe using a tack cloth prior to applying sealer or colour.

Blend Repair Area

Detergent wash and solvent clean prior to repair. Make the necessary repairs following product directions. Use proper procedures for featheredging and priming. Final sand primed area with P500 or finer. Final sand the remainder of the panel with P800 grit paper, a gray nylon scuff pad or scuff gel is also acceptable. If using sanding past rinse well whilewiping to remove all residue. Re-clean using TH5953™ Zero VOC Surface Cleaner before applying colour. Final wipe using a tack cloth prior to applying sealer or colour.

APPLICATION

Confirm colour match is appropriate by spraying a test panel prior to application. Strain paint prior to application. Apply 2 – 3 medium wet coats, or until desired coverage is achieved allowing a 5–10 minute flash between coats. For coarse, harder to orient metallics, a lower pressure effect coat may be applied. Spray Montana Big Sky™ 3.5 Low VOC Basecoat making sure the metallics are uniform prior to clear coating. Allow final coat to flash for 25 – 35 minutes prior to applying clearcoat. Extended flash times may be necessary for cooler spraying conditions or when applying more than 3 coats. When two-toning, apply first colour and allow 45 – 60 minute flash prior to taping for second colour.



Make sure the first colour is dry before taping to avoid tape tracking.

Blending Colour

Use an appropriate basecoat tack cloth to final wipe repair area. Tack cloths may be used between coats of basecoat to eliminate overspray. A Blender may be applied prior to basecoat by applying 1 coat of (L90) Stabilizing Additive Ready to Spray. Allow to flash for 10-15 minutes prior to colour application. Apply basecoat until desired hiding is achieved. Apply extending each coat beyond the prior coat while keeping within the sanded blend area. Allow proper flash time between coats. Do not dry spray colour. For harder to spray metallic colours, use (L90) Stabilizing Additive at a rate of 1:1 to your reduced basecoat once coverage is achieved. This will allow for enhanced metallic orientation, achieve an invisible blend and eliminate the possibility of "Halo Effect".

Baking

Do not bake basecoat.

RECOATING

The basecoat may be recoated within 24 hours. Prior to clearcoating, sand small spots (to remove dirt or debris) with P800 or finer grit paper; Then re-apply a light wet coat of Low VOC basecoat, allow proper flash – proceed with applying clear following the clearcoat directions.



DRY TIMES

AIR DRY

Dust Free	10-15 minutes
Dry To Handle	30 minutes (Basecoat must be cleared)
Reworking	24 hours



PHYSICAL PROPERTIES

VOC (AP)	100 g/L (0.8 lbs/gal) max
VOC (LE)	420 g/L (3.5 lbs/gal) max
Gallon Weight (avg)	1155 g/L (9.64 lbs/gal)
Avg. Mil/micron	0.5 – 1.50 mils
	13 – 37 micron
Recommended Coats	2 – 3

VOC REGULATED AREAS

VOC as Applied	420 grams/liter 3.5 lbs/gallon
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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.

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In the United States and Canada:

1 855 6 AXALTA
axalta.us/bigskylv

