





Montana Big Sky™ PS3008 2K Viper Grip II Metal Etch



COMPONENTS

PS3008 2K Viper Grip II Metal Etch Primer
PC3000M, PC3000S Primer Converter



APPLICATION

1-2 coats
5-10 minute flash between coats




MIX RATIO

1 : 1




DRY TIME

To Topcoat – 30 minutes



VISCOSITY

N/A



VOC

659 grams / liter
5.5 lbs / gallon



GENERAL

DESCRIPTION

Montana Big Sky PS3008 2K Viper Grip II Metal Etch Primer is a non-induction, chromate-free, metal pretreatment designed to provide a fast-drying barrier coat that etches bare metal substrates preparing them for additional topcoats. PS3008 Viper Grip II maximizes the adhesion properties to properly prepared steel, aluminum, and galvanized metal. PS3008 Viper Grip II offers very good corrosion protection with moderate filling properties.

COLOR

PS3008 Green

COMPATIBLE SUBSTRATES

- Thoroughly sanded OEM finishes adjoining metal
- Thoroughly sanded and cured paint adjoining metal
- Properly prepared steel, aluminum, and galvanized steel
- Cured body filler

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



MIXING

COMPONENTS

Mix 1 part PS3008 2K Viper Grip II Metal Etch Primer with 1 part PC3000M or PC3000S Metal Etch Converter. Use plastic or lined spray gun cup.

Component	Volume
Montana Big Sky PS3008 2K Viper Grip II Metal Etch Primer	1
Montana Big Sky PC3000M/PC3000S Metal Etch Converter	1



CONVERTER SELECTION

- PC3000M Medium 60 - 85°F /15 - 29°C
- PC3000S Sow 80°F + / 26°C +

POT LIFE

3-5 days at 75°F/23°C. Store in plastic so performance is not reduced. Stir well before use.



APPLICATION

APPLICATION EQUIPMENT

HVLP Gravity	1.3 - 1.4 mm	6 – 8 PSI	*At the cap
High Efficiency	1.3 - 1.4 mm	17 – 19 PSI	At gauge

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

SURFACE PREPARATION

Be sure to completely remove all rust or oxidation prior to applying primer. Remove rust or oxidation if applicable by sand blasting, grinding, or sanding. Do not use a phosphate conversion coating prior to priming with PS3008 Viper Grip II.

Bare Substrates

Solvent clean with TH5950 Strong Wax & Grease Remover, TH5951 Mild Wax & Grease Remover or TH5953 Zero VOC Waterborne Surface Cleaner. Finish sand using P180 grit sandpaper. Surface cleaners and a scuff pad may be used to remove light surface oxidation on aluminum. Follow by re-cleaning the aluminum to remove sanding residue.

APPLICATION

Apply over properly prepared surfaces. Apply 1 -2 coats of PS3008 Viper Grip II allowing a 5 -10 minute flash between coats. Allow the final coat to dry for 30 minutes before applying a surfacer, sealer or topcoats. If PS3008 Viper Grip II dries more than 24 hours, scuff sand with P400 grit or finer sandpaper before applying surfacer, sealer or topcoats.

COMPATIBLE TOPCOATS

- Acrylic Primer/Surfacers
- Urethane Primers/Surfacers
- Urethane Sealers
- Montana Primer/Surfacer/Sealers

Do not recoat with a polyester-based primer surfacer or epoxy.

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

Dust Free	5-10 minutes
To Topcoat	30 minutes primer

DRY TIME TO SAND

Does not require sanding unless product has dried for 24 hours or longer. Scuff sand using P400 grit or finer sandpaper, re-priming is not required. PS3008 Viper Grip II may be water sanded followed by thorough cleaning and drying.



DRY TIME TO TOPCOAT

30 minutes @ 75°F/23°C before applying a primer-surfacer or sealer only



PHYSICAL PROPERTIES

VOC as Applied	5.5 lbs/gallon (659 g/L)
RTS Volume Solids	12.84%
Volume Solids	24.65%
Weight Solids	39.4%
Film Thickness	0.5 mils ± 0.1 mils per coat
Flash Point	See SDS
Theoretical Coverage	385 sq ft. @ 0.5 mil
Number of Coats	2-3 (maximum of 3)

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 659 grams/liter | 5.5 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.

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In the United States and Canada:
1.855.6.AXALTA
montanabigsky.us

