PRODUCT INFORMATION DATA SHEET

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44GN011 (44-GN-11) Water Reducible Epoxy Primer

Product Information

Specification **BMS 10-11AA TYPE I CLASS A GRADE E**

Description Chromated, water reducible, chemically cured, two-component epoxy polyamide primer

Features

- Corrosion inhibiting
- Chemical and Solvent Resistant
- Resistant to Hydraulic Fluids, Lubricating Oils, Phosphate Ester Based Hydraulic Fluids and Distilled water

Color **BAC 452 GREEN**

Reducer Distilled or Deionized water (150% reduction)

Mix Ratio 2 parts 44GN011 base by volume to
1 part 44GN011CAT catalyst by volume to
4.5 parts water by volume (150% reduction)

Kit size	44GN011base	44GN011CAT	D.I. Water
GK	85 oz / 2.51 L	43 oz / 1.27 L	192 oz / 5.68 L
QK	21 oz / 621 mL	11 oz / 325 mL	48 oz / 1.42 L

Pot Life 4 hours at 72° ± 2°F

Viscosity initial: 20 ± 2 seconds # 2 EZ Zahn Cup

Induction Time none required

Application Thickness 0.5 – 0.7 mils dry film thickness

Storage Stability 9 months from date of manufacture when stored indoors between 40° – 100°F

Characteristics (At 150% Reduction)*

Characteristics	Base	Catalyst	Admixed
Weight per gallon (lbs)	12.47	9.34	9.55
% Solids by weight	77.5%	69.3%	36.0%
% Solids by volume	58.5%	67.2%	24.6%
Coatings VOC (g/L)	332	344	336
Coatings VOC (lbs/gal)	2.77	2.87	2.80
Material VOC (g/L)	332	344	134
Material VOC (lbs/gal)	2.77	2.87	1.12

Dry film density:** 1.68 g/cc
Theoretical Coverage per gallon:** 394 sq. ft.
Theoretical Coverage per mixed gallon kit: 985 sq. ft.
Theoretical Dry Film Weight per mixed gallon kit:
3.96 g/sq. ft (0.00872-lbs/sq. ft)

* Characteristics are calculated based on product formulas and ingredient characteristics as reported to Deft, Incorporated by raw material suppliers. Values reported are not specification values. They are presented for general information only.
** Dry film density and theoretical coverage based on proper application of coating at 1 mil dry film thickness and 100% transfer efficiency.

Dry Times

Dust Free 15 min, max
Tack Free 2 hours, max
Dry Through 6 hours, max
Dry to Tape 4 hours, min
Full Cure 7 days, max

Note: Dry times above were established at room (ambient) temperatures, 75° ± 5°F and 50% ± 10% Relative Humidity.

Forced Dry Schedule

For dry to stack conditions only. Allow a minimum of 15 minutes flash off time at ambient temperatures* prior to exposing painted parts to high temperatures. Complete testing should be done prior to use. Below are suggested starting points. Other variables may affect these cure schedules.

Temperature	Time
120°F	90 minutes
140°F	60 minutes
160°F	40 minutes
180°F	30 minutes

* Ambient temperatures are defined as 70° ± 10°F and 50% ± 10% Relative Humidity. For more information please refer to BAC 5736.

Mixing and Thinning

GK & QK: Stir or shake the base component to ensure any pigment, which may have settled on the bottom of the can, has been fully incorporated into the base. Do not stir or shake the base component longer than 5 minutes. Slowly add the one volume of catalyst to two volumes base component. Mix by hand stirring, paint shaker or mechanical mixing to ensure the base/catalyst mixture is homogeneous. DO NOT SHAKE OR MECHANICALLY MIX MATERIAL FOR LONGER THAN 5 MINUTES. To the catalyzed primer, add approx. 4.5 volumes (150%) of distilled or deionized water. Slowly add the water in one-third increments, mixing thoroughly after each addition, until fully incorporated and homogeneous. Be sure to scrape the sides and bottom of the container. Constant agitation of the material during spray application is recommended. The water is used to adjust the viscosity. Volumes of water needed may vary between 125 – 175%.

Application Equipment

Conventional, Air, Air Assisted Airless, HVLP, Electrostatic spray equipment may be used to apply this material. For your application, please contact the equipment manufacturer for more specific information on Conventional, HVLP or Electrostatic spray applications, and recommendations on hose diameter and lengths.

Packaging, Yields, Shipping Weight

This material is available in the follow kit sizes:

Kit size	Approx. Yield (Mixed)	Approx. Shipping Weight
GK	2.5 gallons	13.4 lbs (6.1 kg)
QK	2.5 quarts	3.6 lbs (1.6 kg)

Additional kit sizes are available upon request.

Equipment Cleanup

Water will clean approximately 95% of liquid primer remaining on equipment. Follow with Deft's IS-248 Cleaning Solvent for Water Reducible Primer to remove any residual primer from equipment. Once material has cured, use an approved chemical paint removal system to strip primer from parts and equipment

Safety

Refer to the product label or Material Safety Data Sheet (MSDS) for each component for Personal Protective Equipment and Proper Handling.