PRODUCT INFORMATION DATA SHEET

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44GN036 (44-GN-36)
Water Reducible Low Density Epoxy Primer

Product Information

Qualified Specifications **MIL-PRF-85582E TYPE I CLASS C2**
LMA-MR003E TYPE 1, 5PTMRT03D

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

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

Color Green

Reducer Distilled or deionized water (≈150% reduction)

Mix Ratio 2 parts 44GN036 base by volume to
1 part 44GN036CAT catalyst by volume to
4.5 parts water by volume (150% ± 10% reduction)

Kit Size	44GN036base	44GN036CAT	D.I. Water
GK	85 oz / 2.51 L	43 oz / 1.27 L	192 oz / 5.68 L
1GK	32 oz/946 ml	16 oz/473 ml	80 oz/2.37 L
QK	21 oz / 621 ml	11 oz/ 325 ml	48 oz / 1.42 L
1QK	8 oz/237 ml	4 oz/118 ml	20 oz/ 591 ml

Pot Life 4 hours at 73° ± 5°F

Viscosity initial: 20 ± 2 seconds # 2 EZ Zahn Cup
16 ± 2 seconds # 4 Ford Cup
Pot life: ≤ 8-second rise (typical)

Induction Time none required

Application Thickness 0.6 – 0.9 mils dry film thickness

Storage Stability (Per MIL-PRF-85582) 1 year when stored between 35 – 115°F

Recommended Storage Store indoors between 70 – 90°F in original unopened containers.

Characteristics (At 150% Reduction)*

Characteristics	Base	Catalyst	Admixed
Weight per gallon (lbs)	10.52	9.34	9.05
% Solids by weight	72.5%	69.3%	32.0%
% Solids by volume	57.2%	67.2%	24.2%
Coatings VOC (g/L)	346	344	346
Coatings VOC (lbs/gal)	2.89	2.87	2.88
Material VOC (g/L)	346	344	138
Material VOC (lbs/gal)	2.89	2.87	1.15

Dry Film Density:** 1.44 g/cc
Theoretical Coverageper gallon as applied:** 388 sq. ft.
Theoretical Coverage per gallon kit (GK) as applied: 970 sq. ft.
Theoretical Dry Film Weight (per gallon kit (GK) as applied): 3.40 g/sq. ft. (0.00750-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

Dry to tape 6 hours, min **Tack Free**1 hour, min **Dry Hard** 6 hours, 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	45 minutes
140°F	30 minutes
160°F	20 minutes
180°F	15 minutes

* Ambient temperatures are defined as 70° ± 10°F and 50% ± 10%

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%. **1GK &1QK:** Add the entire catalyst component to the base component. Fill the can to the chime with distilled or deionized water. Secure the can lid and place on paint shaker in an inverted position for 10 – 15 minutes. DO NOT SHAKE LONGER THAN 15 MINUTES. Primer is now ready for use.

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	11.70 lbs (5.34 kg)
1GK	1 gallon	5.27 lbs (2.4 kg)
QK	2.5 quarts	3.35 lbs (1.52 kg)
1QK	1 quart	1.74 lbs (0.79 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.