PRODUCT INFORMATION DATA SHEET

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44GN054 (44-GN-54) Water Reducible Epoxy Primer

Product Information

Specification DMS 1786M COMPOSITION D

Description Chromated, water reducible, chemically cured, 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 DN9295 Green

Reducer Distilled or deionized water (≈150% reduction)

Mix Ratio 2 parts 44GN054 base by volume to
1 part 44GN054CAT catalyst by volume to
4.5 parts water by volume (150% ± 10% reduction)

Kit Size	44GN054base	44GN054CAT	D.I. Water
1GK	32 oz / 946 mL	16 oz / 473 mL	80 oz / 2.37 L
1QK	8 oz / 237 mL	4 oz/ 118 mL	20 oz / 591 mL

Pot Life 3 hours minimum at 77° ± 5°F, 50 ± 10% RH

Viscosity initial: 20 ± 2 seconds # 2 EZ Zahn Cup
Pot life: ≤ 5-second rise (typical)

Induction Time none required

Application Thickness 0.8 – 1.3 mils dry film thickness

Storage Stability: 1 year from date of manufacture when stored indoors between 35 – 115°F in original unopened containers.

Characteristics (At 150% Reduction)*

Characteristics	Base	Catalyst	Admixed
Weight per gallon, lbs (± 0.5 lbs)	12.48	9.34	9.57
% Solids by weight	77.6%	69.3%	36.0%
% Solids by volume	58.6%	67.2%	24.6%
Coatings VOC (g/L)	335	344	338
Coatings VOC (lbs/gal)	2.80	2.87	2.82
Material VOC (g/L)	335	344	135
Material VOC (lbs/gal)	2.80	2.87	1.13

Dry Film Density** 1.68 g/cc
Theoretical Coverageper gallon kit as applied:** 394 sq. ft.
Theoretical Dry Film Weight (per gallon kit as applied):
3.98 g/sq. ft. (0.00877-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 stack 90 minutes

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 30 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
130°F	30 minutes

* Ambient temperatures are defined as 77° ± 10°F and 50% ± 10% Relative Humidity.

Mixing and Thinning

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 viscosity should be 20 ± 2 seconds in a # 2 EZ Zahn Cup. Constant agitation is recommended. Add small amounts of water if necessary to achieve desired viscosity. A slight variation in the amount of water is normal.

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
1GK	1 gallon	5.75 lbs (2.61 kg)
1QK	1 quart	1.86 lbs (0.84 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.