PRODUCT INFORMATION DATA SHEET

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44GN060 (44-GN-60) Water Reducible Epoxy Primer

Product Information

Specification **BMS 10-11AA TYPE I CLASS A GRADE E BAMS 565-001C GRADE B CATEGORY 2 TYPE RMS118H TYPE I CLASS L and M**

Description Chromated, water reducible, chemically cured,

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 44GN060 base by volume to
1 part 44GN060CAT catalyst by volume to
4.5 parts water by volume (150% ± 10% reduction)

Kit size	44GN060base	44GN060CAT	D.I. Water
GK	85 oz / 2.5 L	43 oz / 1.3 L	192 oz / 5.7 L
1GK	32 oz / 946 mL	16 oz / 473 mL	72 oz / 2.13 L
1QK	8 oz / 237 mL	4 oz / 118 mL	18 oz / 532 mL

Pot Life 6 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)	12.33	9.34	9.52
% Solids by weight	77.1%	69.3%	35.7%
% Solids by volume	58.3%	67.2%	24.5%
Coatings VOC (g/L)	334	344	337
Coatings VOC (lbs/gal)	2.78	2.87	2.81
Material VOC (g/L)	334	344	135
Material VOC (lbs/gal)	2.78	2.87	1.13

Dry film density:** 1.66 g/cc
Theoretical Coverage per gallon (1GK) kit:** 393 sq. ft.
Theoretical Coverage per gallon (GK) kit:** 983 sq. ft.
Theoretical Dry Film Weight per gallon kit:
3.92 g/sq. ft (0.00864-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: Add the catalyst to the base component and shake for 5 minutes. Pour out into a separate container such as a pressure pot. Fill the original container from the catalyzed material with DI or Distilled water and shake or stir. Add ½ of this water to the catalyzed material while stirring. When stirred in, add the other ½ container of water while stirring. Fill this container ½ full and add it while stirring. This 150% water addition will yield a viscosity of approx 20 ± 2 seconds in #2 EZ Zahn cup. Add small amounts of water if necessary to achieve this viscosity. A slight variation in water is normal. Product can accept 175% water reduction. **1GK &1QK:** Add the entire catalyst component to the base component. Fill the can to approximately the bottom of 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 (9.5 L)	13.5 lbs (6.1 kg)
1GK	1 gallon (3.8 L)	5.7 lbs (2.6 kg)
1QK	1 quart (946 mL)	1.9 lbs (861 g)

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.