PRODUCT INFORMATION DATA SHEET

17451 Von Karman Avenue, Irvine, CA 92614
Tel (949) 474-0400 (800) 544-3338
Fax (949) 474-7269
www.deftfinishes.com

44GN098 (44-GN-98) Water Reducible High Performance Epoxy Primer

Product Information

Qualified Specifications
MIL-PRF-85582E TYPE I CLASS N
LMA-MR003E TYPE II CLASS 2 GRADE A
5PTMRT09C GRADE B
HMS 15-1100 TYPE I CLASS 2 GRADE N
PWA 36515-3 and FMS 3027C FORM 3

Description Non-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 Green

Reducer Distilled or deionized water (135% reduction)

Mix Ratio 2 parts 44GN098 base by volume to
1 part 44GN098CAT catalyst by volume to
4 parts water by volume (approx 135%)

Kit Size	44GN098base	44GN098CAT	D.I. Water
1GK	36 oz / 1.06 L	18 oz / 532 ml	73.6 oz / 2176 ml
1QK	9.1 oz / 269 ml	4.5 oz / 133 ml	18.4 oz / 544 ml
1PK	4.5 oz / 134 ml	2.3 oz / 67 ml	9.2 oz / 272ml

Pot Life 4 hours at 73° ± 5°F

Viscosity initial: 20 ± 2 seconds # 2 Zahn Cup

Induction Time none required

Application Thickness 0.6 – 0.9 mils dry film thickness

Storage Stability (Per MIL-PRF-85582) 2 years when stored between 35 – 115°F (1year per LMA-MR003E)

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

Characteristics (At 135% Reduction)*

Characteristics	Base	Catalyst	Admixed
Weight per gallon (lbs)	13.0	9.34	9.80
% Solids by weight	77.6%	69.3%	38.6%
% Solids by volume	63.3%	67.2%	27.5%
Coatings VOC (g/L)	297	344	313
Coatings VOC (lbs/gal)	2.5	2.9	2.6
Material VOC (g/L)	297	344	133
Material VOC (lbs/gal)	2.5	2.9	1.10

Dry Film Density:** 1.65 g/cc
Theoretical Coverage per gallon kit as applied: 441 sq. ft.
Theoretical Dry Film Weight (per gallon kit as applied): 3.90 g/sq. ft. (0.00859-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, theoretical coverage and dry film weight is based on proper application of coating at 1 mil dry film thickness and 100% transfer efficiency.

Dry Times

Tack Free 1 hours, min
Dry Hard 6 hours, max
Dry to tape 6 hours, min

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% Relative Humidity.

Mixing Instructions

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. Constant agitation of the material during spray application is recommended. The water is used to adjust the viscosity. Volumes of water needed may vary.

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 / 3.8 L	6.6 lbs (3.0 kg)
1QK	1 quart / 946 mL	2.0 lbs (0.9 kg)
1PK	1 pint / 473 mL	1.0 lbs (453 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 liquid 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.