



PRODUCT INFORMATION DATA SHEET

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44GN060 (44-GN-60)

Water Reducible Epoxy Primer

Product Information				Forced Dry Schedule																																		
Specification	BMS 10-11AB TYPE I CLASS A GRADE E BAMS 565-001C GRADE B CATEGORY 2 TYPE 1 RMS118H TYPE I CLASS L and M			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. As a general guideline Max Operating Temperature (MOT) is 275°F or less. This is a general guideline only, not experimental data. End user must confirm that this product is fit for use at elevated temperature-time profiles. <table border="1" style="margin: 10px auto;"> <thead> <tr> <th>Temperature</th> <th>Time</th> </tr> </thead> <tbody> <tr> <td>120°F</td> <td>90 minutes</td> </tr> <tr> <td>140°F</td> <td>60 minutes</td> </tr> <tr> <td>160°F</td> <td>40 minutes</td> </tr> <tr> <td>180°F</td> <td>30 minutes</td> </tr> </tbody> </table> <p>* Ambient temperatures are defined as 70° ± 10°F and 50% ± 10% Relative Humidity. For more information please refer to BAC 5736</p>			Temperature	Time	120°F	90 minutes	140°F	60 minutes	160°F	40 minutes	180°F	30 minutes																						
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Description	Chromated, water reducible, chemically cured,																																					
Features	<ul style="list-style-type: none"> Corrosion inhibiting Chemical and Solvent Resistant Resistant to Hydraulic Fluids, Lubricating Oils, Phosphate Ester Based Hydraulic Fluids and Distilled water 																																					
Color	BAC 4910 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	Mixing and Thinning																																		
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			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.																																		
Viscosity	initial: 20 ± 2 seconds # 2 EZ Zahn Cup 31-39 seconds #2 Ford 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)*				Application Equipment																																		
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1.66 g/cc 393 sq. ft. 983 sq. ft. 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				Packaging, Yields, Shipping Weight																																		
Dust free	15 min, max			This material is available in the follow kit sizes: <table border="1" style="margin: 10px auto;"> <thead> <tr> <th>Kit size</th> <th>Approx. Yield (Mixed)</th> <th>Approx. Shipping Weight</th> </tr> </thead> <tbody> <tr> <td>GK</td> <td>2.5 gallons (9.5 L)</td> <td>13.5 lbs (6.1 kg)</td> </tr> <tr> <td>1GK</td> <td>1 gallon (3.8 L)</td> <td>5.7 lbs (2.6 kg)</td> </tr> <tr> <td>1QK</td> <td>1 quart (946 mL)</td> <td>1.9 lbs (861 g)</td> </tr> </tbody> </table>			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)																				
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Tack Free	2 hours, max			Additional kit sizes are available upon request.																																		
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.				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.																																						