



# PRODUCT INFORMATION DATA SHEET

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01BK038 (01-BK-38)

GMS 5006 TYPE I

FED STD COLOR 27038

HIGH SOLIDS EPOXY TOPCOAT

Product Information				Forced Dry Schedule																																	
<b>Specification:</b> <b>GMS 5006 TYPE I</b> <b>Description:</b> Chemically cured, two-component, epoxy topcoat intended for use on aircraft and aerospace equipment.  <b>Features:</b> <ul style="list-style-type: none"> <li>When used over properly applied Commercial or Military primers, it provides excellent adhesion and flexibility.</li> <li>Resistant to hydraulic fluids, lubricating oils and water.</li> <li>Provides excellent chemical resistance to solvents,</li> </ul> <b>Color:</b> <b>FED STD 595C # 27038 Semi-Gloss Black</b> <b>Reducer/Thinner:</b> None required. <b>Mix Ratio:</b> 3:1 by parts by volume 3 parts 01BK038 base component to 1 part 80X104A catalyst component				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. <table border="1"> <thead> <tr> <th>Temperature</th> <th>Time</th> </tr> </thead> <tbody> <tr> <td>120°F</td> <td>45 minutes</td> </tr> <tr> <td>140°F</td> <td>30 minutes</td> </tr> <tr> <td>160°F</td> <td>20 minutes</td> </tr> <tr> <td>180°F</td> <td>15 minutes</td> </tr> </tbody> </table>		Temperature	Time	120°F	45 minutes	140°F	30 minutes	160°F	20 minutes	180°F	15 minutes																						
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<b>Pot Life:</b> 4 hours at 70° ± 10°F, 50 ± 10% R.H. <b>Viscosity:</b> initial: 20 – 28 sec # 2 Zahn Cup 4 hours: 35 sec max, # 2 Zahn Cup <b>Induction Time:</b> 30 minutes <b>Application Thickness:</b> 1.7 – 2.3 mils dry film thickness <b>Storage stability:</b> 1 year when stored indoors between 35 – 115°F in original unopened containers.				<h3>Mixing and Thinning</h3> <p>Thoroughly stir or shake the base component (Part A) before combining to ensure all solids are completely dispersed. Add one volume of catalyst component (Part B) to the three parts of base component (Part A). Do not use the catalyst component (Part B) from another color. Mix by hand stirring, paint shaker or mechanical mixing to ensure the base/catalyst mixture is homogeneous. <b>DO NOT SHAKE OR MECHANICALLY MIX MATERIAL FOR LONGER THAN 10 MINUTES.</b> Thinners are not required for the mixed material. If the addition of a thinner is necessary, MIL-T-81772B Type II* (IS-237) is available. Do not add thinner to attempt to compensate for coatings beyond its useful pot life.</p> <p>*Use only if needed and if local and state VOC limits allow.</p>																																	
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<b>Dry Film Density***:</b> 1.37g/cc <b>Theoretical Coverage per gallon:</b> 787sq. ft. <b>Theoretical Dry Film Weight (per gallon kit as applied):</b> 3.24 g/sq ft (0.00714 lbs/sq. ft.)				<h3>Packaging, Yields, Shipping Weight</h3> <p>This material is available in the follow kit sizes:</p> <table border="1"> <thead> <tr> <th>Kit size</th> <th>Approx. Yield (Mixed)</th> <th>Approx. Shipping Weight</th> </tr> </thead> <tbody> <tr> <td>QK</td> <td>1 quart</td> <td>3.5 lbs (1.6 kg)</td> </tr> </tbody> </table> <p>Additional kit sizes are available upon request.</p>		Kit size	Approx. Yield (Mixed)	Approx. Shipping Weight	QK	1 quart	3.5 lbs (1.6 kg)																										
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<p>* 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.          ** Catalyst component contains VOC exempt solvents.          *** 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.</p>				<h3>Equipment Cleanup</h3> <p>IS-237 Epoxy Reducer (MIL-T-81772B Type II) may be used for general clean up of parts and equipment before coating has fully cured and is still in a liquid state. Once material is fully cured, use an approved chemical paint removal system to strip off coating.</p>																																	
<h3>Dry Times</h3> <p><b>Dust Free:</b> 2 hours, max      <b>Dry Through:</b> 9 hours, max  <b>Tack Free:</b> 4 hours, max      <b>Full Cure:</b> 14 days</p> <p>Note: Dry times above were established at room (ambient) temperatures, 73° ± 4°F and 50% ± 10% Relative Humidity.</p>				<h3>Safety</h3> <p>Refer to the product label or Material Safety Data Sheet (MSDS) for each component for Personal Protective Equipment and Proper Handling.</p>																																	