



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

01W074 (01-W-74)

GMS 5006 TYPE I

FED STD 595 COLOR 17925

HIGH SOLIDS EPOXY TOPCOAT

Product Information				Forced Dry Schedule																																		
Specification: GMS 5006 TYPE I, VOUGHT GM5003C TYPE I and NGC 207-9-275 Description: Chemically cured, two-component, epoxy topcoat intended for use on aircraft and aerospace equipment. Features: <ul style="list-style-type: none"> When used over properly applied Commercial or Military primers, it provides excellent adhesion and flexibility. Resistant to hydraulic fluids, lubricating oils and water. Provides excellent chemical resistance to solvents. Color: Fed Std 595B # 17925 Gloss White Reducer/Thinner: None required. Mix Ratio: 3:1 by parts by volume 3 parts 01W074 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> <p>*Ambient temperatures are defined as 70° ± 10°F and 50% ± 10% Relative Humidity.</p>			Temperature	Time	120°F	45 minutes	140°F	30 minutes	160°F	20 minutes	180°F	15 minutes																						
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<h3>Dry Times</h3> <p>Dust Free: 2 hours, max Dry Through: 9 hours, max Tack Free: 4 hours, max Full Cure: 14 days</p> <p>Note: Dry times above were established at room (ambient) temperatures, 73° ±4°F and 50% ± 10% Relative Humidity.</p>				<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>GK</td> <td>1 gallon</td> <td>12.5 lbs (5.7 kg)</td> </tr> <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	GK	1 gallon	12.5 lbs (5.7 kg)	QK	1 quart	3.5 lbs (1.6 kg)																							
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<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>				<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>																																		