



# PRODUCT INFORMATION DATA SHEET

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## 44GN072 (44-GN-72) Water Reducible Low Density Epoxy Primer

Product Information				Forced Dry Schedule																																		
<b>Qualified Specifications</b>	MIL-PRF-85582E TYPE I CLASS C2 LMA-MR003E, MMS 423 5PTMRT03C BAMS 565-001B GRADE B CATEGORY 2 TYPE 2			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. <table border="1" style="margin: 10px auto;"> <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> * Ambient temperatures are defined as 70° ± 10°F and 50% ± 10% Relative Humidity.			Temperature	Time	120°F	45 minutes	140°F	30 minutes	160°F	20 minutes	180°F	15 minutes																						
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<b>Description</b>	Chromated, water reducible, chemically cured, low density two-component epoxy polyamide primer																																					
<b>Features</b>	<ul style="list-style-type: none"> <li>Corrosion inhibiting</li> <li>Chemical and Solvent Resistant</li> <li>Resistant to immersion in Hydraulic Fluids, Lubricating Oils, Phosphate Ester Based Hydraulic Fluids and Distilled water</li> </ul>																																					
<b>Color</b>	Green																																					
<b>Reducer</b>	Distilled or deionized water (≈150% reduction)																																					
<b>Mix Ratio</b>	2 parts 44GN072 base by volume to 1 part 44GN072CAT catalyst by volume to 4 parts water by volume (150% ± 10% reduction)																																					
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<b>Pot Life</b>	4 hours at 73° ± 5°F																																					
<b>Viscosity</b>	initial: 20 ± 2 seconds # 2 EZ Zahn Cup 16 ± 2 seconds # 4 Ford Cup Pot life: ≤ 8-second rise (typical)																																					
<b>Induction Time</b>	none required																																					
<b>Application Thickness</b>	0.6 – 0.9 mils dry film thickness																																					
<b>Storage Stability (Per MIL-PRF-85582)</b>	1 year when stored between 35 – 115°F																																					
<b>Recommended Storage</b>	Store indoors between 70 – 90°F in original unopened containers.																																					
Characteristics (At 150% Reduction)*				Mixing and Thinning																																		
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<b>Dry Film Density**:</b>	1.46 g/cc			Application Equipment																																		
<b>Theoretical Coverage**per gallon as applied:</b>	424 sq. ft.			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.																																		
<b>Theoretical Dry Film Weight (per gallon kit (GK) as applied):</b>	3.44 g/sq. ft. (0.00734-lbs/sq. ft.)			Packaging, Yields, Shipping Weight																																		
* 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.				This material is available in the follow kit sizes:																																		
** Dry film density and theoretical coverage based on proper application of coating at 1 mil dry film thickness and 100% transfer efficiency.				<table border="1" style="width: 100%; text-align: center;"> <thead> <tr> <th>Kit size</th> <th>Approx. Yield (Mixed)</th> <th>Approx. Shipping Weight</th> </tr> </thead> <tbody> <tr> <td>1GK</td> <td>1 gallon</td> <td>5.27 lbs (2.40 kg)</td> </tr> <tr> <td>1QK</td> <td>1 quart</td> <td>1.74 lbs (0.79 kg)</td> </tr> </tbody> </table> Additional kit sizes are available upon request.			Kit size	Approx. Yield (Mixed)	Approx. Shipping Weight	1GK	1 gallon	5.27 lbs (2.40 kg)	1QK	1 quart	1.74 lbs (0.79 kg)																							
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Dry Times				Equipment Cleanup																																		
<b>Tack Free</b>	1 hour, min	<b>Dry to tape</b>	6 hours, min	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.																																		
<b>Dry Hard</b>	6 hours, max			Safety																																		
Note: Dry times above were established at room (ambient) temperatures, 75° ± 5°F and 50% ± 10% Relative Humidity.				Refer to the product label or Material Safety Data Sheet (MSDS) for each component for Personal Protective Equipment and Proper Handling.																																		