



PRODUCT INFORMATION DATA SHEET

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02GN070A (02-GN-70A) Low Density Quick Dry Epoxy Polyamide Primer

Product Information				Forced Dry Schedule												
Specifications		MIL-PRF-23377K Type II Class C2		<p>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.</p> <table><tr><th>Temperature</th><th>Time</th></tr><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></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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140 °F	30 minutes															
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Description		Chemically cured, strontium chromate, two-component epoxy polyamide primer														
Features		<ul style="list-style-type: none">Corrosion inhibitingChemical and Solvent ResistantResistant to immersion in Hydraulic Fluids, Lubricating Oils, Phosphate Ester Based Hydraulic Fluids, Skydrol and Distilled water														
Color		Dark Green Low IR Reflecting														
Reducer		None required. May be reduced with IS-237*														
Mix Ratio		3 parts 02GN070A base by volume to 1 part 02GN070ACAT catalyst by volume														
Kit size	02GN070A base		02GN070ACAT													
GK	1 can filled @ 96 oz / 2.84 L		1 can filled @ 32 oz / 946 mL													
Pot Life		4 hours at 75° ± 10°F		<h3>Mixing and Thinning</h3> <p>Stir or shake the base component to ensure any pigment, which may have settled on the bottom of the can, has been fully incorporated into the base. Do not stir or shake the base component longer than 5 minutes. Slowly add one part by volume of catalyst to three parts by volume base component. Mix by hand stirring, paint shaker or mechanical mixing to ensure the base/catalyst mixture is homogeneous. DO NOT SHAKE OR MECHANICALLY MIX MATERIAL FOR LONGER THAN 10 MINUTES. Constant agitation of the material during spray application is recommended.</p>												
Viscosity		initial: 20 ± 2 seconds # 2 EZ Zahn Cup 40 seconds, max, # 4 Ford Cup Pot life: 70 seconds, max, # 4 Ford Cup														
Induction Time		None required														
Application Thickness		0.6 – 0.9 mils dry film thickness														
Storage Stability		1 year from DOM when stored between 35 - 115°F														
Recommended Storage		Store indoors between 70 – 90°F in original unopened containers.		<h3>Application Equipment</h3> <p>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.</p>												
*Use only if needed and if local and state VOC limits allow.																
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Characteristics*																
Characteristics	Base	Catalyst	Admixed													
Weight per gallon (lbs)	12.84	8.04	11.64	<h3>Packaging, Yields, Shipping Weight</h3> <p>This material is available in the follow kit sizes:</p> <table><tr><th>Kit size</th><th>Approx. Yield (Mixed)</th><th>Approx. Shipping Weight</th></tr><tr><td>GK</td><td>1 gallon (3.8 L)</td><td>13.0 lbs (5.9 kg)</td></tr></table> <p>Additional kit sizes are available upon request.</p>			Kit size	Approx. Yield (Mixed)	Approx. Shipping Weight	GK	1 gallon (3.8 L)	13.0 lbs (5.9 kg)				
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% Solids by weight	72.4%	61.4%	70.5%													
% Solids by volume	54.9%	69.5%	58.6%													
Coatings VOC (g/L)	314	372	330													
Coatings VOC (lbs/gal)	2.62	3.1	2.75	<h3>Equipment Cleanup</h3> <p>Use IS-237 Epoxy Reducer (MIL-T-81772B Type II) to remove any liquid or residual primer from equipment. <u>Once material has cured, use an approved chemical paint removal system to strip primer from parts and equipment</u></p>												
Material VOC (g/L)	281	372	304													
Material VOC (lbs/gal)	2.34	3.1	2.53													
Dry film density**:		1.68 g/cc														
Theoretical Coverage** per gallon as applied:		939 sq. ft.														
Theoretical Dry Film Weight per gallon kit as applied:		3.96 g/sq. ft (0.00872-lbs/sq. ft)		<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>												
* 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.																
Note: Formulation contains VOC exempt solvents.																
Dry Times																
Dry to Topcoat: 5 hour min-24 hours, max		Tack Free: 5 hours, Max .														
Dry Hard: 8 hours, max		Full Cure: 14 days, max														
Note: Dry times above were established at room (ambient) temperatures, 75° ± 5°F and 50% ± 10% Relative Humidity. After 8 hours cure, it is recommended to solvent wipe the entire primed surface before top coating. After 24 hours of cure, it is recommended to scuff sand the entire primed surface for optimal inter-coat adhesion. Ref: T.O. 1-1-8 Section 6.12.6.5																