

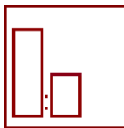
## 44GN057 Water Reducible Epoxy Primer – Touch Up

### Product description

44GN057 is a water reducible, chemically cured, two-component epoxy polyamide primer designed to protect the structural interior of aircraft from corrosion. 44GN057 is specially formulated for brushing / touch-up application.

- Corrosion inhibiting
- Compatible with epoxy and urethane interior topcoats
- Excellent adhesion to aluminum and composite surfaces
- Chemical and solvent resistant
- Resistant to immersion in hydraulic fluids, lubricating oils, phosphate ester based hydraulic fluids and distilled water

### Components



#### **Mix ratio (by volume):**

- 44GN057 (base component) 2 parts
- 44GN057CAT (catalyst component) 1 part
- Reducer (Distilled or Deionized water) 3.75 parts water by volume (approximately 125 ± 10%)

### Specifications



44GN057 primer is qualified to the following material specifications:

- BMS 10-11 Ty I Cl A Gr E
- BAC 5736
- GMS 5005 Type II
- HJMS-7102

*Note: PPG Aerospace recommends you check the most recent specification QPLs for updated information.*

#### **Product compatibility:**

44GN057 primer is compatible with the following topcoat specifications:

- BMS 10-11 Type II
- BMS 10-60 Type I & II
- CMS-CT-203 Type I Class 4

### Surface preparation and pretreatments



44GN057 primer can be applied over clean, dry, intact aluminum and composite surfaces. Aluminum surfaces shall be treated with materials conforming to MIL-DTL-5541 or equivalent.

### Instructions for use

# 44GN057 Water Reducible Epoxy Primer – Touch Up



## Mixing instructions:

44GN057 is available in 1 and 4 ounce touch up kits. An acetone-blend thinner is available upon request. Other kit sizes are available upon request.

The kit consists of an inner cup, which contains the 44GN057 catalyst component and is located inside an outer cup (bottle) that contains the 44GN057 base component. The thinner component is housed in a separate bottle.

To mix, remove the outer lid and pour the 44GN057 catalyst component from the inner cup into the 44GN057 base component in the outer cup (bottle). Replace the lid and shake by hand until well mixed, approximately 2 minutes. Open the lid and add the thinner component. Replace the lid and shake by hand until well mixed and uniform.

*Note: It is important to condition the paint for 24 hours prior to mixing by placing all materials in the shop or hangar, with ambient temperatures between 13° and 35°C (55° to 95°F). The minimum temperature of the paint components should be 13°C (55°F) prior to mixing.*



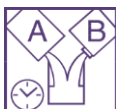
## Induction time:

Not Required



## Viscosity: (23°C/73°F)

- Not applicable



## Pot life: @ 21 - 25°C (70 - 77°F)

- 150 minutes maximum when thinned with water
- 6 hours maximum when thinned with acetone-water blend

## Application guidelines

### Recommended application conditions:

Temperature	15 - 30°C (59 - 86°F)
Relative Humidity	20 - 90%

### Application:

*These application guidelines represent PPG's best advice in standard conditions. Some parameters will be influenced by environmental conditions, equipment settings, and other variables.*

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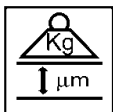


**Theoretical coverage:** at 25 microns (1 mil dry film)

1 oz. Touch-up kit: 0.31 square meters (3.42 square feet)

4 oz. Touch-up kit: 1.27 square meters (13.7 square feet)

Recommended dry film thickness; 12.5 to 22.5 microns (0.5 to 0.9 mils)



**Dry film density:**

1.66 grams/cubic centimeter (13.85 pounds/gallon)

**Dry film weight:**

42.2 grams/square meter at 25 microns dry film (0.00864 pounds/square feet at 1 mil dry film)



**Equipment:**

44GN057 primer is compatible with all current forms of spray equipment.

*\*Note: When spraying with electrostatic spray equipment, ensure that this is rated for use with water-borne coatings. Spraying water-borne coatings with regular electrostatic spray equipment can result in safety hazards.*

**Equipment Cleaning:**

Water will clean approximately 95% of liquid primer remaining on equipment. Follow with 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.

## Physical Properties (product)



**Color:** BAC 452 green



**Gloss:** 10 G.U. maximum at 60°



<b>Dry Times</b>	<b>21 - 27°C (70 - 80°F)</b>
Dust Free	15 minutes maximum
Tack Free	2 hours maximum

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Dry Through	6 hours maximum
Dry to Tape	4 hours minimum
Full Cure	7 days

*Note: Dry times above were established at room (ambient) temperatures, 75° ± 5°F and 50% ± 10% relative humidity.*

Forced Dry Schedule: 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.

Temperature	Time
49°C (120°F)	90 minutes
60°C (140°F)	60 minutes
71°C (160°F)	40 minutes
82°C (180°F)	30 minutes

*Note: Ambient temperatures are defined as 70° ± 10°F and 50% ± 10% Relative Humidity. For more information please refer to BAC 5736.*

## VOC

### VOC:

Mixed, ready to use VOC (EPA method 24)	337 grams/liter
Base Component	334 grams/liter
Catalyst Component	344 grams/liter



### Flash point closed cup:

Base Component	22°C (72°F)
Catalyst Component	31°C (87°F)

### Shelf Life:

4 months from date of packaging

*Note: Shelf life is provided for original, unopened containers.*

*Note: The application and performance property values above are typical for the material, but not intended for use in specifications or for acceptance inspection criteria because of variations in testing methods, conditions and configurations.*

## Storage recommendations

# 44GN057 Water Reducible Epoxy Primer – Touch Up



Inspect the condition of the container to ensure compliance. The material should be stored at temperatures between 5°C to 35°C (41°F to 95°F) to ensure shelf life.

*Note: When procuring to a qualified material specification, follow those storage instructions.*

## Health Precautions

This product is safe to use and apply when recommended precautions are followed. Before using this product, read and understand the Safety Data Sheet (SDS), which provides information on health, physical and environmental hazards, handling precautions and first aid recommendations. An SDS is available on request. Avoid overexposure. Obtain medical care in case of extreme overexposure.

**For industrial use only. Keep away from children.**

**Additional information can be found at: [www.ppgaerospace.com](http://www.ppgaerospace.com)**

**For sales and ordering information call the local PPG office at the numbers listed below:**

### **Asia Pacific**

**ASC – Australia**  
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PRC-DeSoto International, Inc.  
12780 San Fernando Road  
Sylmar, CA 91342  
[www.ppgaerospace.com](http://www.ppgaerospace.com)

Issue Date: 9/24  
Lit: 4633