

Starting Formulation

SF 1023

Zinc-Rich Primer

EPON™ Resin 1001-X-75 / EPIKURE™ Curing Agent 3115-X-70

| Formula | Material | Supplier | Pounds | Gallons |
|---------|-------------------------------|---------------------------|----------------|--------------|
| Part A | | | | |
| | Zinc Dust #22 | New Jersey Zinc Company | <u>1,800.0</u> | <u>30.80</u> |
| | Total Part A | | 1,800.0 | 30.80 |
| Part B | | | | |
| | Thixatrol™ ST | Elementis Specialties Co. | 6.0 | 0.71 |
| | Cab-O-Sil™ M-5 Silica | Cabot Corporation | 8.0 | 0.46 |
| | EPON Resin 1001-X-75 | Hexion | 124.0 | 13.70 |
| | n-Butyl Alcohol | Shell Chemical Company | 67.5 | 10.00 |
| | Butyl OXITOL™ Glycol Ether | | 40.5 | 5.00 |
| | Xylene | | <u>175.0</u> | <u>24.33</u> |
| | Total Part B | | 421.0 | 54.20 |
| Part C | | | | |
| | EPKURE Curing Agent 3115-X-70 | Hexion | 71.5 | 9.16 |
| | Xylene | | <u>42.0</u> | <u>5.84</u> |
| | Total Part C | | 113.5 | 15.00 |
| | Total Part A & B & C | | 2,334.5 | 100.00 |

Mixing Instructions

| | Pounds | Gallons |
|----------------|--------------|--------------|
| Part A | 1,800.0 | 30.80 |
| Part B | 421.0 | 54.20 |
| Part C | <u>113.5</u> | <u>15.00</u> |
| Part A + B + C | 2,334.5 | 100.00 |

Typical Formulation Table 1 / Formulation Properties

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| | <u>Units</u> | <u>Value</u> |
|---------------------------------|--------------|--------------|
| Volatile Organic Compound (VOC) | lb/gal | 3.77 |
| | g/L | 453 |

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at www.hexion.com

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