

Starting Formulation

SF 1618

Block Fill Coating

EPON™ Resin 828 / EPIKURE™ Curing Agent 8537-WY-60

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPON Resin 828	Hexion	91.0	9.42
	HELOXY™ Modifier 8	Hexion	30.0	4.06
	Pluronic F-98 Surfactant (25% in water)	BASF Chemical Corp.	7.5	0.86
	Drew Plus L-475 Defoamer	Drew Chemical Corp.	2.0	0.26
<i>Mix at low speed 3 minutes. Add</i>				
	Rutile Titanium Dioxide		100.0	3.02
	Calcium Carbonate		150.0	6.67
	Silica		100.0	4.55
<i>Disperse to a texture of 3-3 ½ Hegman. Add at reduced speed</i>				
	Polyethylene Fibers	Mini Fibers, Inc.	5.0	0.67
	DI Water		<u>170.0</u>	<u>20.49</u>
	Total Part A		655.5	50.00
Part B				
	EPIKURE Curing Agent 8537-WY-60	Hexion	172.0	19.15
	Drew Plus L-475 Defoamer	Drew Chemical Corp.	2.0	0.26
	Synthetic Silica		5.0	0.29
<i>Mix at about 2,000 RPM 3 minutes. Add</i>				
	Diatomaceous Silica		25.0	1.31
	Magnesium Silicate		100.0	4.22
	Tap Water		8.3	1.00
<i>Mix at about 300 RPM for 3 minutes to texture of 3-3 ½ Hegman.</i>				
<i>Then add following at reduced speed</i>				
	Polyethylene Fibers	Mini Fibers, Inc.	3.0	0.40
	DI Water		20.8	2.50
<i>Complete by adding</i>				
	DI Water		<u>174.0</u>	<u>20.87</u>
	Total Part B		510.1	50.00

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Total Part A & B 1,165.6 100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	655.5	50.00
Part B	<u>510.1</u>	<u>50.00</u>
Part A + B	1,165.6	100.00

Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Total weight solids	%	63.0
Total volume solids	%	46.0
Volatiles Composition		
Water	lbs	406.8
Organic	lbs	36.1
Pigment volume concentration (PVC)	%	46.0
Volatile Organic Compound (VOC)	lb/gal	0.71
	g/L	85.2
Potlife	hrs	4-5
Application	Brush, Trowel or Squeegee	
Viscosity @ 25°C		
Part A	KU	Soft Paste
Part B	KU	Soft Paste
Part A + B	KU	Soft Paste

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

General Information

These are starting formulations and are not proven in the user's particular application but are simply meant to demonstrate the efficacy of the products and to assist in the development of the user's own formulation. It is the user's responsibility to fully-test and qualify the formulation, along with the ingredients, methods, applications or equipment identified herein ("Information"), by the user's knowledgeable formulator or scientist, and to determine the appropriate use conditions and legal restrictions, prior to use of any Information.

Safety, Storage & Handling

Please refer to the MSDS for the most current Safety and Handling information.

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Contact Information

For product prices, availability, or order placement, please contact customer service:

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