

Starting Formulation

SF 1815

Red Iron Oxide Primer

EPI-REZ™ Resin 5522-WY-55 / EPIKURE™ Curing Agent 8290-Y-60

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPI-REZ Resin 5522-WY-55	Hexion	200.0	22.35
	Diacetone Alcohol	Shell Chemical Co.	6.6	0.84
	Lutensol OP-10	BASF Chemicals Inc	5.0	0.56
	DI Water		84.8	10.18
	Colloid 640 Defoamer	Rhodia	3.5	0.41
	RO-4097 Kroma Red	Elementis Pigments Inc.	104.4	2.45
	Zeeospheres Type 400	3M Industries, Inc.	194.6	9.73
	Sparmite	Harcros Pigments, Inc.	89.8	2.45

Pebble mill approximately 18 hours then add

	EPI-REZ Resin 5522-WY-55	Hexion	266.8	29.81
	DI Water		<u>10.2</u>	<u>1.22</u>
	Total Part A		965.7	80.00

Part B

	EPIKURE Curing Agent 8290-Y-60	Hexion	45.3	5.13
	DI Water		35.0	4.20
	Zeeospheres Type 400	3M Industries, Inc.	150.0	7.50

High speed disperse to a texture of 4 ½ - 5 Hegman, reduce speed then add

	DI Water		<u>26.4</u>	<u>3.17</u>
	Total Part B		256.7	20.00

Total Part A & B 1,222.4 100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	965.7	80.00
Part B	<u>256.7</u>	<u>20.00</u>
Part A + B	1,222.4	100.00

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	Resin Composition	<u>Units</u>	<u>Value</u>
Part A		% solids	90.0
Part B		% solids	<u>10.0</u>
Part A + B		% solids	100.0

Typical Formulation Table 1 / Formulation Properties
Properties

	<u>Units</u>	<u>Value</u>
Mix Ratio, Part A: Part B	By volume	4 :1
Total weight solids	%	67.3
Total volume solids	%	51.4
Pigment volume concentration (PVC)	%	43.1
Volatile Organic Compound (VOC)	lb/gal	1.01
	g/L	121
Induction Time	min.	30
Viscosity @ 25°C		
Part A	KU	100
Part B	KU	140
Part A + B	KU	100
Reduction for Conventional Spray (By Volume)		
Parts A and B	parts	20
Water	parts	1

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:

www.hexion.com/Contacts/

For literature and technical assistance, visit our website at www.hexion.com

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