

Starting Formulation

SF 1002

Clear Coating

EPON™ Resin 8521-MX-60 / EPIKURE™ Curing Agent 3125

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPON Resin 8521-MX-60	Hexion	476.0	54.00
	Xylene	Shell Chemical Company	61.0	8.50
	Butyl OXITOL™ Glycol Ether	Shell Chemical Company	<u>31.4</u>	<u>4.17</u>
	Total Part A		568.4	66.67
Part B				
	EPIKURE Curing Agent 3125	Hexion	72.6	9.00
	Xylene	Shell Chemical Company	107.5	15.00
	Butyl OXITOL Glycol Ether	Shell Chemical Company	<u>70.0</u>	<u>9.33</u>
	Total Part B		250.1	33.33
	Total Part A & B		1132.9	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	568.4	66.67
Part B	<u>250.1</u>	<u>33.33</u>
Part A + B	818.5	100.00

Resin Composition

	<u>Units</u>	<u>Value</u>
Part A	% solids	79.7
Part B	% solids	<u>20.3</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	2 : 1
	by weight	2.27:1.0
Total weight solids	%	43.8
Total volume solids	%	35.7

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Volatile Organic Compound (VOC)	lb/gal	4.60
	g/L	552
Induction Time	min	60
Viscosity @ 25°C		
Part A	KU	71
Part B, #4 Ford Cup	sec	13
Part A & B	KU	57

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

General Information

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Contact Information

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

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