

Starting Formulation

SF 1020

Gloss White Enamel

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

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	Ti-Pure™ R-960	Du Pont Company	300.0	8.58
	Imperial Anti-Flooding (IAF) Compound X-2280	RLM Industries, Inc.	3.0	0.14
	EPON Resin 1001-CX-75	Hexion	323.0	36.00
	Beetle U216-8	Cytec Industries	12.9	1.50
High speed disperse the above to Hegman 8 grind				
	BUTYL OXITOL™ Glycol Ether	Shell Chemical Company	28.4	3.78
	Total Part A		667.3	50.00
Part B				
	EPIKURE Curing Agent 3115-X-70	Hexion	185.5	23.80
	2-Propoxyethanol		37.9	5.00
	Xylene	Shell Chemical Company	<u>152.0</u>	<u>21.20</u>
	Total Part B		375.4	50.00
	Total Part A & B		1,042.7	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	667.3	50.00
Part B	<u>375.4</u>	<u>50.00</u>
Part A + B	1,042.7	100.00

Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Mix ratio Part A : Part B	By volume	1 : 1
	By weight	1.18 : 1.0
Total weight solids	%	65.3
Total volume solids	%	51.4

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Pigment volume concentration (PVC)	%	17.4
Volatile Organic Compound (VOC)	lb/gal	3.55
	g/L	425.4
Viscosity @ 25°C		
Part A	KU	129
Part B, #4 Ford	sec	14
Part A & B	KU	68

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

General Information

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