

# Starting Formulation

SF 1610

White Enamel

EPON™ Resin 828 / EPIKURE™ Curing Agent 8535-W-50

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPON Resin 828	Hexion	162.1	16.84
	HELOXY™ Modifier 8	Hexion	<u>53.5</u>	<u>7.21</u>
	Total Part A		215.6	24.05
Part B				
	EPIKURE Curing Agent 8535-W-50	Hexion	216.0	24.80
	Rutile Titanium Dioxide, Kronos 2020	Kronos, Inc.	250.0	7.60
	Colloid 640 Defoamer	Rhodia	4.0	0.50
<i>High Speed disperse to texture 7-8 Hegman. Reduce speed and add</i>				
	Glacial Acetic Acid		2.0	0.24
	Colloid 640 Defoamer	Rhodia	4.0	0.50
	Water		<u>352.4</u>	<u>42.31</u>
	Total Part B		828.4	75.95
	Total Part A & B		1,044.0	100.00

## Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	215.6	24.05
Part B	<u>828.4</u>	<u>75.95</u>
Part A + B	1,044.0	100.00

## Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Total weight solids	%	44.2
Total volume solids	%	45.0
Volatile Organic Compound (VOC)	lb/gal	0.14
	g/L	16.8

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Viscosity @ 25°C

Part A	KU	68.0
Part B	KU	60.0
Part A & B	KU	100.0

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at [www.hexion.com](http://www.hexion.com)

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