

# Starting Formulation

SF 1004

Clear Coating

EPON™ Resin 8521-MX-60 / EPIKURE™ Curing Agent 3213

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPON Resin 8521-MX-60	Hexion	524.0	60.00
	Diacetone Alcohol	Shell Chemical Company	39.2	5.00
	2-Propoxyethanol		37.9	5.00
	Xylene		<u>71.9</u>	<u>10.00</u>
	Total Part A		673.0	80.00
Part B				
	EPIKURE Curing Agent 3213	Hexion	73.8	9.00
	2-Propoxyethanol		30.3	4.00
	Methyl Isobutyl Ketone	Shell Chemical Company	26.7	4.00
	Xylene	Shell Chemical Company	<u>21.6</u>	<u>3.00</u>
	Total Part B		152.4	20.00
	Total Part A & B		825.4	100.00

## Mixing Instructions

	Pounds	Gallons
Part A	673.0	80.00
Part B	<u>152.4</u>	<u>20.00</u>
Part A + B	825.4	100.00

## Typical Formulation Table 1 / Formulation Properties Properties

	Units	Value
Mix Ratio, Part A : Part B	by volume	4 : 1
	by weight	4.42:1.0
Weight per gallon	pounds	8.34
Total weight solids	%	41.8
Total volume solids	%	33.9
Volatile Organic Compound (VOC)	lb/gal	4.80

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	g/L	576
Viscosity @ 25°C		
Part A	KU	68
Part B	cP	15
Part A & Part B	KU	59

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

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For literature and technical assistance, visit our website at [www.hexion.com](http://www.hexion.com)

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