

Starting Formulation

SF 1817

Red Oxide Primer

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	130.0	13.50
	Red Iron Oxide		125.0	2.93
	Barium Sulfate		282.2	7.70
<i>Disperse to texture of 6-7 P.C.S. Add following at reduced speed</i>				
	EPON Resin 828	Hexion	32.1	3.34
	HELOXY™ Modifier 8	Hexion	<u>53.5</u>	<u>7.22</u>
	Total Part A		622.8	34.69
Part B				
	EPIKURE Curing Agent 8535-W-50	Hexion	216.0	24.80
	Glacial Acetic Acid		2.0	0.24
	Water		<u>334.0</u>	<u>40.27</u>
	Total Part B		552.0	65.31
	Total Part A & B		1,174.8	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	622.8	34.69
Part B	<u>552.0</u>	<u>65.31</u>
Part A + B	1,174.8	100.00

Resin Composition

	<u>Units</u>	<u>Value</u>
Part A	% solids	49.96
Part B	% solids	<u>50.04</u>
Part A + B	% solids	100.0

Typical Formulation Table 1 / Formulation Properties Properties

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	<u>Units</u>	<u>Value</u>
Total weight solids	%	61.24
Total volume solids	%	45.07
Pigment volume concentration (PVC)	%	23.2
Volatile Organic Compound (VOC)	lb/gal	0.04
	g/L	4.8
Volatile Composition		
Water	lbs/gal	453.8/54.5
Organic	lbs/gal	4.2/0.5
Pot life	hrs	1 – 2
Viscosity @ 25°C		
Part A	KU	130
Part B, Gardner-Holdt		A
Part A + B	KU	119
Reduced Viscosity, 10:1 in water	KU	80 - 90

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

General Information

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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:

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

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