

# Starting Formulation

SF 1612

Gloss White Enamel

EPON™ Resin 828 / EPIKURE™ Curing Agent 8537-WY-60

| Formula   | <u>Material</u>                 | <u>Supplier</u>                         | <u>Pounds</u> | <u>Gallons</u> |
|---|---------------------------------|---|---------------|----------------|
| Part A  |                                 |   |               |                |
|   | EPON Resin 828                  | Hexion                                  | 126.5         | 13.11          |
|   | HELOXY™ Modifier 8              | Hexion                                  | <u>42.0</u>   | <u>5.68</u>    |
|   | Total Part A                    |   | 168.5         | 18.79          |
| Part B  |                                 |   |               |                |
|   | EPIKURE Curing Agent 8537-WY-60 | Hexion                                  | 160.0         | 17.70          |
|   | Colloid 640 Defoamer            | Rhodia                                  | 4.0           | 0.50           |
|   | Kronos 2020 or Tronox CR-800    | Kronos, Inc.<br>Kerr-McGee Chemical Co. | 250.0         | 7.33           |
| Disperse to a texture of 9-10 P.C.S. at reduced speed, then add |                                 |   |               |                |
|   | EPIKURE Curing Agent 8537-WY-60 | Hexion                                  | 79.0          | 8.74           |
|   | Colloid 640 Defoamer            | Rhodia                                  | 4.0           | 0.50           |
|   | Water                           |   | <u>386.9</u>  | <u>46.44</u>   |
|   | Total Part B                    |   | 883.9         | 81.21          |
|   | Total Part A & B                |   | 1,052.4       | 100.00         |

## Mixing Instructions

|            | <u>Pounds</u> | <u>Gallons</u> |
|------------|---------------|----------------|
| Part A     | 168.5         | 18.79          |
| Part B     | <u>883.9</u>  | <u>81.21</u>   |
| Part A + B | 1,052.4       | 100.00         |

## Resin Composition

|            | <u>Units</u> | <u>Value</u> |
|------------|--------------|--------------|
| Part A     | % solids     | 54.0         |
| Part B     | % solids     | <u>46.0</u>  |
| Part A + B | % solids     | 100.0        |

Typical Formulation Table 1 / Formulation Properties

Generated: October 19, 2021  
 Issue Date:  
 Revision:

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## Properties

|                                    | <u>Units</u> | <u>Value</u> |
|------------------------------------|--------------|--------------|
| Total weight solids                | %            | 53.4         |
| Total volume solids                | %            | 40.8         |
| Pigment volume concentration (PVC) | %            | 18.0         |
| Volatile Organic Compound (VOC)    | lb/gal       | 1.02         |
|                                    | g/L          | 122          |
| Viscosity @ 25°C                   |              |              |
| Part A                             | KU           | 67           |
| Part B                             | KU           | 74           |
| Part A & B                         | KU           | 95           |

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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