

Starting Formulation

SF 1808

Solvent Resistant, Water-Reducible Epoxy Primer EPI-REZ™ Resin 5522-WY-55 / EPIKURE™ Curing Agent 8290-Y-60

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPI-REZ Resin 5522-WY-55	Hexion	200.0	22.35
	Diacetone Alcohol	Shell Chemical Co.	6.6	0.84
	Lutensol OP-10	BASF Chemical Co.	5.0	0.56
	DI Water		84.8	10.18
	Colloid 640 Defoamer	Rhodia	3.5	0.41
	RO-4097 Kroma Red, Red Iron Oxide	Elementis Pigments Co.	104.4	2.45
	Zeeospheres Type 600	3M Industries, Inc.	307.1	17.55
<i>Pebble mill approximately 18 hours</i>				
	EPI-REZ Resin 5522-WY-55		187.2	20.92
	DI Water		<u>39.5</u>	<u>4.74</u>
	Total Part A		938.1	80.00
Part B				
	EPIKURE Curing Agent 8290-Y-60	Hexion	118.3	13.40
	DI Water		<u>55.0</u>	<u>6.60</u>
	Total Part B		173.3	20.00
	Total Part A & B		1,111.4	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	938.1	80.00
Part B	<u>173.3</u>	<u>20.00</u>
Part A + B	1,111.4	100.00
Resin Composition		
Part A	% solids	75.0
Part B	% solids	<u>25.0</u>

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Issue Date:
Revision:

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Part A + B % solids 100.0

Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Total weight solids	%	62.6
Total volume solids	%	49.2
Pigment volume concentration (PVC)	%	40.7
Volatile Organic Compound (VOC)	lb/gal	1.37
	g/L	164
Reduction for Conventional Spray (by volume)		
Parts A and B	parts	36
Water	parts	1
Induction Time	min.	30
Viscosity @ 25°C		
Part A	KU	64
Part B	KU	58
Part A + B	KU	85

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

General Information

These are starting formulations and are not proven in the user's particular application but are simply meant to demonstrate the efficacy of the products and to assist in the development of the user's own formulation. It is the user's responsibility to fully-test and qualify the formulation, along with the ingredients, methods, applications or equipment identified herein ("Information"), by the user's knowledgeable formulator or scientist, and to determine the appropriate use conditions and legal restrictions, prior to use of any Information.

Safety, Storage & Handling

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:

www.hexion.com/Contacts/

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

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