

# Starting Formulation

SF 1017

Gloss Gray Enamel

EPON™ Resin 1001-Y-75 / EPIKURE™ Curing Agent 3115-E-73

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	Ti-Pure™ R-960	Du Pont Company	100.0	3.03
	Lampblack		3.0	0.20
	X-2280 IAF Compound, Anti-flooding Agent	RLM Industries Inc.	4.0	0.18
	Bentone™ 38 Thixotrope	Elementis Specialties Inc.	14.0	0.91
	EPON Resin 1001-Y-75	Hexion	305.0	33.00
		High Speed disperses to grind Hegman 7-8		
	Beetle™ U216-8 Urea Formaldehyde Resin	Cytec Industries	17.0	2.00
	2-Propoxyethanol		23.3	3.00
	Cyclohexanone		63.0	8.00
	Diacetone Alcohol	Shell Chemical Co.	35.2	4.50
	n-Butyl Alcohol	Shell Chemical Co.	<u>80.0</u>	<u>11.85</u>
		Total Part A	644.5	66.67
Part B				
	EPKURE Curing Agent 3115-E-73	Hexion	168.0	21.90
	Xylol		14.4	2.00
	Ethyl Benzene		25.4	3.50
	Isopropyl Alcohol	Shell Chemical Co.	<u>39.0</u>	<u>5.93</u>
		Total Part B	246.8	33.33
		Total Part A & B	891.3	100.00

## Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	644.5	66.67
Part B	<u>246.8</u>	<u>33.33</u>
Part A + B	891.3	100.00

Generated: October 19, 2021  
 Issue Date:  
 Revision:

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Resin Composition

	<u>Units</u>	<u>Value</u>
Part A	% Solids	65
Part B	% Solids	<u>35</u>
Part A + B	% Solids	100

Typical Formulation Table 1 / Formulation Properties Properties

Application	Brush or Spray	
Cured Schedule	Room Temperature	
	<u>Units</u>	<u>Value</u>
Mix ratio Part A : Part B	By volume	2 : 1
	By weight	2.61:1.0
Nonvolatile content by weight	%	45.7
Weight per gallon	lb./gal.	8.91
Total weight solids	%	54.3
Pigment volume concentration (PVC)	%	7.8
Volatile Organic Compound (VOC)	lb/gal	4.07
	g/L	488
Viscosity @ 25°C		
Part A	KU	63
Part B	KU	58
Part A & B	KU	63

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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