

Starting Formulation

SF 1614

Block Fill Coating

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	91.0	9.42
	HELOXY Modifier 8	Hexion	30.0	4.06
	Pluronic F98 Surfactant	BASF Corp.	7.5	0.86
	L-475 Defoamer	Drew Chemical Corp.	2.0	0.26
<i>Mix at low speed 3 minutes. Add</i>				
	Rutile Titanium Dioxide, Kronos 2160 or R-960	Kronos, Inc. Du Pont Co.	100.0	3.02
	Atomite Calcium Carbonate	Thompson, Weinman & Co.	150.0	6.67
	1240 Grade Silica	Illinois Minerals Co.	100.0	4.55
<i>Disperse to a texture of 4-5 Hegman. Add at reduced speed</i>				
	Short Stuff Polyethylene Fibers	Mini Fibers, Inc.	5.0	0.67
	Water		<u>170.0</u>	<u>20.49</u>
	Total Part A		655.5	50.00
Part B				
	EPIKURE Curing Agent 8537-WY-60	Hexion	172.0	19.03
	L-475 Defoamer	Drew Chemical Corp.	2.0	0.26
	Cab-O-Sil M-5 Synthetic Silica	Cabot Corp.	5.0	0.27
<i>Mix at 2,000 rpm 3 minutes. Add</i>				
	Celite 499 Diatomaceous Silica	Manville Products Corp.	25.0	1.31
	Nyral 300 Magnesium Silicate	R.T Vanderbilt	100.0	4.22
	Water		8.3	1.00
<i>Mix at 300 rpm 3 minutes to a texture of 4 P.C.S. Add at reduced speed</i>				
	Short Stuff Polyethylene Fibers	Mini Fibers, Inc.	3.0	0.40
	Water		20.8	2.50
<i>Mix well. Complete by adding</i>				
	Water		<u>175.0</u>	<u>21.01</u>
	Total Part B		511.1	50.00

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Total Part A & B	1,166.6	100.00
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Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	655.5	50.00
Part B	<u>511.1</u>	<u>50.00</u>
Part A + B	1,166.6	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 Properties

	<u>Units</u>	<u>Value</u>
Mix ratio Part A : Part B	By volume	1 : 1
	By weight	1.28 : 1.0
Total weight solids	%	61.1
Total volume solids	%	45.2
Pigment volume concentration (PVC)	%	46.7
Volatiles Composition		
Water	lbs	407.8
Organic	lbs	46.0
Volatile Organic Compound (VOC)	lb/gal	0.90
	g/L	108
Viscosity @ 25°C		
Part A	KU	Soft Paste
Part B	KU	Soft Paste
Part A + B	KU	Soft Paste

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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