

Starting Formulation

SF 1806

Red Iron Oxide Primer

EPI-REZ™ Resin 3520-WY-55 / EPIKURE™ Curing Agent 8536-MY-60

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	2-Propoxyethanol		11.6	1.50
	Lutensol OP-10	BASF Chemical Co.	3.5	0.39
	Tamol 731 Surfactant	Rohm & Haas Co.	3.5	0.38
	Q148 Defoamer	Troy Chemical Co.	4.0	0.48
	Bentone LT 3% in water	Elementis Specialty Products	75.0	8.95
<i>Blend well and add</i>				
	Red Iron Oxide		100.0	2.34
	Celite 499 Diatomaceous Earth	Johns-Manville Co.	25.0	1.30
	Magnesium Silicate		100.0	4.22
<i>Disperse to a grind fineness of 5-6 Hegman, then add under agitation</i>				
	EPI-REZ Resin 3520-WY-55	Hexion	276.0	30.00
	DI Water		<u>295.0</u>	<u>35.44</u>
		Total Part A	893.6	85.00
Part B				
	EPIKURE Curing Agent 8536-MY-60	Hexion	<u>124.5</u>	<u>15.00</u>
		Total Part B	124.5	15.00
		Total Part A & B	1,018.1	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	893.6	85.00
Part B	<u>124.5</u>	<u>15.00</u>
Part A + B	1,018.1	100.00

Resin Composition

	<u>Units</u>	<u>Value</u>
Part A	% solids	67.0

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Part B	% solids	<u>33.0</u>
Part A + B	% solids	100.0

Typical Formulation Table 1 / Formulation Properties
Properties

	<u>Units</u>	<u>Value</u>
Nonvolatile content by weight	%	29.2
Total weight solids	%	45.3
Total volume solids	%	31.3
Pigment volume concentration (PVC)	%	25.2
Volatile Organic Compound (VOC)	lb/gal	2.05
	g/L	246
Volatile Composition		
Water	467.0	56.14
Organics	85.2	11.20
Application	Brush or Spray	
Viscosity @ 25°C		
Part A	KU	68
Part B	KU	90
Part A + B	KU	98

Typical Film Table 2 / Film Performance Properties ¹
Properties

	<u>Units</u>	<u>Value</u>
Drying Characteristics (Room Temperature Cure)		
Set to Touch	min.	30-60
Dry to Handle	min.	60
Dry Hard	hrs	4
Dry to Recoat	hrs	20
Salt Spray Resistance	Blistering	Creepage
	Gloss	
One coat primer, iron phosphate treated steel, 500 hours	None	None
One coat primer, two coats EPI-REZ Resin 3520-WY-55, enamel iron phosphate treated steel, film thickness 4 mils, 700 hours	None	1/2" Flat

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

General Information

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