

# Starting Formulation

SF 1608

Semi-Gloss Black 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	92.4	9.52
	HELOXY™ Modifier 8	Hexion	<u>30.1</u>	<u>4.01</u>
	Total Part A		122.5	13.53
Part B				
	EPIKURE Curing Agent 8537-WY-60	Hexion	174.0	9.35
	L-475 Defoamer	Drew Chemical Corp.	4.0	0.52
	Calcium Carbonate		200.0	8.88
	Magnesium Silicate		150.0	6.34
	DI Water		58.2	7.00
<i>High speed disperse to texture of 6-7 Hegma. Reduce speed and add following slowly</i>				
	W-7012 Carbon Black Dispersion	Harshaw Chemical Co.	75.0	7.56
	DI Water		<u>306.7</u>	<u>36.82</u>
	Total Part B		967.9	86.47
	Total Part A & B		1,090.4	100.0

## Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	122.5	13.53
Part B	<u>967.9</u>	<u>86.47</u>
Part A + B	1,090.4	100.0
<b>Resin Composition</b>		
Part A	% solids	54.0
Part B	% solids	46.0
Part A + B	% solids	100.0

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Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Total weight solids	%	55.7
Total volume solids	%	43.1
Gloss (60° Angle)	Units	30
Volatiles Composition		
Water	lbs	442
Organic	lbs	35.6
Pigment volume concentration (PVC)	%	40.5
Volatile Organic Compound (VOC)	lb/gal	0.87
	g/L	105
Viscosity @ 25°C		
Part A	KU	72
Part B	KU	70
Part A & B Fresh	KU	108
1 Hour	KU	112
2 Hour	KU	115

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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For product prices, availability, or order placement, please contact customer service:

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