

# Starting Formulation

## SF 1802

### Clear Enamel (For Maximum Solvent and Abrasion Resistance) EPI-REZ™ Resin 5522-WY-55 / EPIKURE™ Curing Agent 8290-Y-60

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPI-REZ Resin 5522-WY-55	Hexion	490.6	54.82
	Michemlube 743 Mar and Slip Agent	Michelman Chemicals	41.0	5.00
	CYCLO SOL 63	Shell Chemical Co.	32.3	4.37
	Ektasolve EP, 2-Propoxyethanol	Eastman Chemical Products	33.2	4.37
	DI Water		53.6	6.44
		<b>Total Part A</b>	<b>650.7</b>	<b>75.00</b>
Part B				
	EPIKURE Curing Agent 8290-Y-60	Hexion	145.8	16.51
	DeeFo PI-4 Concentrate Defoamer	Münzing Additives	4.0	0.49
	DI Water		66.6	8.00
		<b>Total Part B</b>	<b>216.4</b>	<b>25.00</b>
		<b>Total Part A &amp; B</b>	<b>867.1</b>	<b>100.00</b>

#### Mixing Instructions

	Pounds	Gallons
Part A	650.7	75.00
Part B	216.4	25.00
Part A + B	867.1	100.00

	Resin Composition	Units	Value
Part A		% solids	75.0
Part B		% solids	25.0
Part A + B		% solids	100.0

#### Typical Formulation Table 1 / Formulation Properties Properties

Units	Value
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Mix Ratio, Part A: Part B	By volume	3 :1
Total weight solids	%	41.8
Total volume solids	%	37.6
Volatile Organic Compound (VOC)	lb/gal	2.74
	g/L	329
Induction Time	min.	30
Viscosity @ 25°C		
Part A	KU	58
Part B	KU	68
Part A + B	KU	85

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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