

Starting Formulation

SF 1018

Gray Enamel

EPON™ Resin 1001-CX-75 / EPIKURE™ Curing Agent 3115-X-70

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	Ti-Pure R-610	Du Pont Company	100.0	2.86
	Lampblack		8.0	0.54
	Bentone 38	Rheox, Inc.	2.0	0.13
	Imperial Anti-Flooding (IAF) Compound X-2280	RLM Industries, Inc.	3.0	0.14
	EPON Resin 1001-CX-75	Hexion	323.0	36.00
	SYN-U-TEX™ 402 Amino Resin	Shell Chemical Company	12.9	1.50
	Butyl OXITOL™ Glycol Ether	Shell Chemical Company	37.5	5.00
	Xylene		<u>27.4</u>	<u>3.83</u>
		Total Part A	513.8	50.00
Part B				
	EPIKURE Curing Agent 3115-X-70	Hexion	185.5	23.80
	2-Propoxyethanol		37.5	5.00
	Xylene		<u>152.0</u>	<u>21.20</u>
		Total Part B	375.0	50.00
		Total Part A & B	888.8	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	513.8	50.00
Part B	<u>375.0</u>	<u>50.00</u>
Part A + B	888.8	100.00

Typical Formulation Table 1 / Formulation Properties Properties

Application	<u>Units</u>	<u>Value</u>
		Brush or Spray

Allow 1 hour induction prior to application and 48 hours before recoating

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Cure Schedule	Room Temperature cure	
Weight per gallon	lb/gal	8.88
Total weight solids	%	55.4
Vehicle solids	%	49.0
Pigment volume concentration (PVC)	%	8.2
Volatile Organic Compound (VOC)	lb/gal	3.95
	g/L	475
Viscosity @ 25°C		
Part A	KU	84
Part B	KU	12 sec
Part A & B	KU	62

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

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Contact Information

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

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For literature and technical assistance, visit our website at www.hexion.com

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