

## Starting Formulation

SF 1604

Clear Sealer

EPON™ Resin 828 / EPIKURE™ Curing Agent 8535-W-50

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPON Resin 828	Hexion	296.2	30.69
	Eastman EP, 2-Propoxyethanol		<u>146.6</u>	<u>19.31</u>
	Total Part A		442.8	50.00
Part B				
	EPIKURE Curing Agent 8535-W-50	Hexion	318.0	36.26
	Glacial Acetic Acid		2.9	0.35
	Water		<u>111.5</u>	<u>13.39</u>
	Total Part B		432.4	50.00
	Total Part A & B		875.2	100.00

### Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	442.8	50.00
Part B	<u>432.4</u>	<u>50.00</u>
Part A + B	875.2	100.00

### Resin Composition

	<u>Units</u>	<u>Value</u>
Part A	% solids	65.0
Part B	% solids	35.0
Part A + B	% solids	100.0

### Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Volatiles Composition		
Water	lbs	264.1
Organic	lbs	156.0

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Total weight solids	%	52.0
Total volume solids	%	48.0
Volatile Organic Compound (VOC)	lb/gal	2.28
	g/L	274
Viscosity @ 25°C		
Part A	KU	53
Part B	KU	114
Part A & B	KU	58

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at [www.hexion.com](http://www.hexion.com)

#### General Information

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#### Contact Information

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

[www.hexion.com/Contacts/](http://www.hexion.com/Contacts/)

For literature and technical assistance, visit our website at [www.hexion.com](http://www.hexion.com)

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