

Starting Formulation

SF 1800

Clear Enamel (Maximum Acid 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	540.8	60.42
	CYCLO SOL 63	Shell Chemical Co.	32.3	4.37
	Ektasolve EP, 2-Propoxyethanol	Eastman Chemical Products	33.2	4.37
	Water		<u>48.6</u>	<u>5.84</u>
	Total Part A		654.9	75.00
Part B				
	EPIKURE Curing Agent 8290-Y-60	Hexion	87.6	9.92
	Patcote 847 Defoamer	C.J. Patterson Co.	4.0	0.56
	Water		<u>121.0</u>	<u>14.52</u>
	Total Part B		212.6	25.00
	Total Part A & B		867.5	100.00

Mixing Instructions

	Pounds	Gallons
Part A	654.9	75.00
Part B	<u>212.6</u>	<u>25.00</u>
Part A + B	867.5	100.00

Resin Composition

	Units	Value
Part A	% solids	85.0
Part B	% solids	<u>15.0</u>
Part A + B	% solids	100.0

Typical Formulation Table 1 / Formulation Properties Properties

	Units	Value
Mix ratio Part A : Part B	By volume	3 : 1

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	By weight	3.08 : 1.0
Total weight solids	%	40.3
Total volume solids	%	36.1
Pigment volume concentration (PVC)	%	31.1
Volatile Organic Compound (VOC)	lb/gal	2.57
	g/L	308
Induction Time	min.	30
Viscosity @ 25°C		
Part A	KU	93
Part B	KU	61
Part A + B	KU	75

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

Please refer to the MSDS for the most current Safety and Handling information.

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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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