

Starting Formulation

SF 1027

VOC Compliant Lead and Chromate Free Primer EPON™ Resin 828 / EPIKURE™ Curing Agent 3175

| Formula | <u>Material</u> | <u>Supplier</u> | <u>Pounds</u> | <u>Gallons</u> |
|---|-----------------------------------|---------------------------|----------------|----------------|
| Part A | | | | |
| | EPON Resin 828 | Hexion | 238.1 | 24.68 |
| | CYMEL™ U-216-10LF Resin | Cytec Industries | 3.0 | .59 |
| | Anti-Terra U Dispersant | BYK-Chemie USA | 5.0 | .64 |
| | Toluene | | 75.0 | 10.41 |
| | Butyl OXITOL™ Glycol Ether | Shell Chemical Co. | 20.4 | 2.72 |
| | Bentone SD-2 Thixotrope | Elementis Specialties Co. | 10.2 | 1.20 |
| | RD-4097 Kroma Red, Red Iron Oxide | Elementis Pigments, Co. | 120.4 | 2.95 |
| | ZP-10 Zinc Phosphate | Heucotech, Ltd. | 150.0 | 5.45 |
| | Sparmite Barium Sulfate | Harcros Pigments, Inc. | 329.9 | 9.00 |
| | Zeeosphere 400 type | 3M Industries, Inc. | 299.6 | 16.37 |
| | Water Ground Mica, 325 Mesh | KMG Minerals, Inc. | 78.5 | 3.14 |
| High Speed Disperse to grind 5-6 Hegman, reduce speed and add the following | | | | |
| | EPON Resin 828 | Hexion | 24.8 | 2.56 |
| | Xylene | | <u>2.1</u> | <u>.29</u> |
| | Total Part A | | 1,357.0 | 80.00 |
| Part B | | | | |
| | EPIKURE Curing Agent 3175 | Hexion | 142.2 | 17.64 |
| | Xylene | | <u>17.0</u> | <u>2.36</u> |
| | Total Part B | | 159.2 | 20.00 |
| | Total Part A & B | | 1,516.2 | 100.00 |

Mixing Instructions

| | <u>Pounds</u> | <u>Gallons</u> |
|------------|---------------|----------------|
| Part A | 1,357.0 | 80.00 |
| Part B | <u>159.2</u> | <u>20.00</u> |
| Part A + B | 1,516.2 | 100.00 |

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Resin Composition

| | <u>Units</u> | <u>Value</u> |
|------------|--------------|--------------|
| Part A | % solids | 64.9 |
| Part B | % solids | <u>35.1</u> |
| Part A + B | % solids | 100.0 |

Typical Formulation Table 1 / Formulation Properties Properties

| | <u>Units</u> | <u>Value</u> |
|------------------------------------|--------------|--------------|
| Mix ratio Part A : Part B | By volume | 4 : 1 |
| | By weight | 8.52 : 1.0 |
| Total weight solids | % | 92.0 |
| Total volume solids | % | 85.7 |
| Pigment volume concentration (PVC) | % | 44.5 |
| Volatile Organic Compound (VOC) | lb/gal | 1.21 |
| | g/L | 145 |
| Induction Time | min. | 30 |
| Viscosity @ 25°C | | |
| Part A + Part B | KU | 140 |

Reduction to Spray Table 2 / Reduction to Spray Viscosity by Volume (65-70 K.U.) Properties

| | <u>Units</u> | <u>Value</u> |
|--|--------------|--------------|
| Parts A and B | | 3.7 |
| Xylene | | 1.0 |
| Total Volume Solids at Application Viscosity | % | 67.5 |
| VOC at Application Viscosity | lb/gal | 2.47 |
| | g/L | 297 |
| Usable Pot Life | hrs | 11+ |

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.

Exposure to these materials should be minimized and avoided, if feasible, through the observance of proper precautions, use of appropriate engineering controls and proper personal protective clothing and equipment, and adherence to proper handling procedures. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheet (MSDS) for these and all other products being used are understood by all persons who will work with them. Questions and requests for

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