

Starting Formulation

SF 1606

Gloss White Enamel

EPI-REZ™ Resin 3520-WY-55 / EPIKURE™ Curing Agent 8537-WY-60

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPI-REZ Resin 3520-WY-55	Hexion	411.6	45.03
	Michemlube 182 Mar and Slip Agent	Michelman Chemicals, Inc.	27.8	3.33
	Water		<u>13.7</u>	<u>1.64</u>
	Total Part A		453.1	50.00
Part B				
	EPIKURE Curing Agent 8537-WY-60	Hexion	160.0	17.70
	Ektasolve DB Acetate	Eastman Chemical Products, Inc.	8.2	1.00
	Triethylamine		3.7	0.61
	Patcote 519 Defoamer	C.J. Patterson Co.	4.0	0.57
	Kronos 2020 or Tronox CR-800	Kronos, Inc. Kerr-McGee Chemical Co.	250.0	7.33
<i>High Speed disperse to a texture of 7-8 Hegman., then add</i>				
	EPIKURE Curing Agent 8537-WY-60	Hexion	42.4	4.69
	Water		<u>150.0</u>	<u>18.10</u>
	Total Part B		619.1	50.00
	Total Part A & B		1,072.2	100.00

Mixing Instructions

	Pounds	Gallons
Part A	453.1	50.00
Part B	<u>619.1</u>	<u>50.00</u>
Part A + B	1,072.2	100.00

Resin Composition

	Units	Value
Part A	% solids	65.0
Part B	% solids	35.0

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 Revision:

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Part A + B	% solids	100.0
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Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Mix ratio Part A : Part B	By volume	1 : 1
	By weight	1.0: 1.37
Total weight solids	%	55.8
Total volume solids	%	42.3
Pigment volume concentration (PVC)	%	17.3
Volatile Organic Compound (VOC)	lb/gal	1.61
	g/L	187
Viscosity @ 25°C		
Part A	KU	85
Part B	KU	110
Part A & B	KU	99

Reduction for Spray Table 2 / Reduction for Conventional Spray (By Volume) Properties

	<u>Units</u>	<u>Value</u>
Parts A and B	Parts	17
Water	Parts	1

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:

www.hexion.com/Contacts/

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

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