

# Starting Formulation

SF 1015

High Solids Gloss White Enamel

EPON™ Resin 828 / EPIKURE™ Curing Agent 3192

Formula	Material	Supplier	Pounds	Gallons
Part A				
	Ti-Pure™ R-960	Du Pont Company	250.0	7.32
	Barium Sulfate		200.0	5.45
	Bentone 38 Thixotrope	Elementis Specialties Inc.	15.0	1.00
	Methyl Alcohol		6.0	0.91
	EPON Resin 828	Hexion	240.0	25.00
	High Speed disperse to grind Hegman 7-8			
	Xylene		93.7	13.00
	EPON Resin 828	Hexion	77.0	8.00
	Xylene		<u>43.0</u>	<u>5.99</u>
	Total Part A		924.7	66.67
Part B				
	EPIKURE Curing Agent 3192	Hexion	214.0	27.60
	Xylene		<u>41.3</u>	<u>5.73</u>
	Total Part B		255.3	33.33
	Total Part A & B		1,180.00	100.00

## Mixing Instructions

	Pounds	Gallons
Part A	924.7	66.67
Part B	<u>255.3</u>	<u>33.33</u>
Part A + B	1,180.00	100.00

## Resin Composition

	Units	Value
Part A	% Solids	60.00
Part B	% Solids	<u>40.00</u>

Generated: October 21, 2021  
 Issue Date:  
 Revision:

© and ™ Licensed trademarks of Hexion Inc.

## DISCLAIMER

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.

Part A + B	% Solids	100.00
------------	----------	--------

Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Mix ratio Part A : Part B	By volume	2:1
	By weight	3.62:1.0
Total weight solids	%	84.5
Total volume solids	%	74.4
Pigment volume concentration (PVC)	%	
Volatile Organic Compound (VOC)	lb/gal	
	g/L	221
Induction Time	hrs	1
Pot life	hrs	8
Viscosity @ 25°C		
Part A	KU	118
Part B	KU	72
Part A & B		
Fresh	KU	75
1 hour	KU	79
2 hours	KU	82
3 hours	KU	92
4 hours	KU	94
5 hours	KU	103
6 hours	KU	115
8 hours	KU	122

Typical Film Table 2 / Film Performance Properties Properties

*Determined on films applied to MEK-washed Q Panels and cured 7 days at 25 °C and 55% relative humidity.*

	<u>Units</u>	<u>Value</u>
Pencil hardness		
20 hours		6B
48 hours		2B
72 hours		B

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

Generated: October 21, 2021  
 Issue Date:  
 Revision:

© and ™ Licensed trademarks of Hexion Inc.

DISCLAIMER

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.

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 information on Hexion Inc. ("Hexion") products should be directed to your Hexion sales representative, or the nearest Hexion sales office. Information and MSDSs on non-Hexion products should be obtained from the respective manufacturer.

#### 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)

---

Generated: October 21, 2021  
Issue Date:  
Revision:

® and ™ Licensed trademarks of Hexion Inc.

#### DISCLAIMER

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.