

Starting Formulation

SF 1617

Gloss White Enamel

EPI-REZ™ Resin 3520-WY-55 / EPIKURE™ Curing Agent 8540-MU-60

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPI-REZ Resin 3520-WY-55	Hexion	329.4	36.04
	Michemlube 182 Mar and Slip Agent	Michelman Chemicals, Inc.	27.8	3.33
	Water		<u>88.6</u>	<u>10.63</u>
	Total Part A		445.8	50.00
Part B				
	EPIKURE Curing Agent 8540-MU-60	Hexion	160.0	19.28
	Deefo PI-4 Concentrate Defoamer	Münzing	4.0	0.49
	Rutile Titanium Dioxide, Kronos 2020	Kronos, Inc.	250.0	7.33
	<i>High speed disperse to a texture of 7-8 Hegman, reduce speed and add the following with mixing</i>			
	EPIKURE Curing Agent 8540-MU-60	Hexion	22.5	2.71
	Water		<u>168.2</u>	<u>20.19</u>
	Total Part B		604.7	50.00
	Total Part A & B		1050.5	100.0

Mixing Instructions

	Pounds	Gallons
Part A	445.8	50.00
Part B	<u>604.7</u>	<u>50.00</u>
Part A + B	1050.5	100.0

Resin Composition

	Units	Value
Part A	% solids	62.2
Part B	% solids	<u>37.8</u>
Part A + B	% solids	100.0

Typical Formulation Table 1 / Formulation Properties Properties

	Units	Value
Mix ratio Part A : Part B	By volume	1 : 1
	By weight	0.74 : 1.0

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Total weight solids	%	51.5
Total volume solids	%	37.6
Pigment volume concentration (PVC)	%	19.5
Volatile Organic Compound (VOC)	lb/gal	1.89
	g/L	227
Induction Time	minutes	30
Pot Life	hrs	>8
Viscosity @ 25°C		
Part A + Part B	KU	69

Typical Film Properties Table 2 / Film Performance Properties ^{1, 2}

	<u>ASTM Method</u>	<u>Units</u>	<u>Value</u>
Set-to-touch dry		hrs	2.0
Cotton-free dry,		hrs	10.25
Thru-dry		hrs	14.0
Pencil hardness	D-3363		HB
Impact resistance	D-2794		
Direct		in/lb	44
Reverse		in/lb	32
Flexibility pass 1/8 in.	D-522		
Adhesion, X-cut	D-3359		5A
Chemical resistance ² - 48 hr spot test			
10% NaOH (aq.)			10
30% H2SO4 (aq.)			9
DI water			10
Corrosion resistance- Salt fog test, 1400 hr	B-117		
Blisters at scribe	D-714		8D
Face Blisters			8MD
Water resistance, 600 hr	D-870		
Immersion at 60 °C			
Face corrosion			10
Blister rating			6MD
Immersion at 25 °C			
Face corrosion			10
Blister rating			10

¹ 2 mil DFT on CRS.Cured 14 days at 77 °F, 55% R.H.

² Rating: 10 = no effect; 0 = complete failure.

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at www.hexion.com

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