

Starting Formulation

SF 1047

High Solids Red Iron Oxide Epoxy Primer

EPON™ Resin 874-CX-90 / EPIKURE™ Curing Agent 3140

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPON Resin 874-CX-90	Hexion	263.0	28.85
	Beetle U216-8	Cytec Industries.	12.0	1.41
	Xylene	Shell Chemical Company	75.5	10.49
	MIBK	Shell Chemical Company	60.4	9.10
	PGME Acetate		15.1	1.86
	Zinc Phosphate J-0852	Davis Colors	176.5	6.74
	10 ES WOLLASTOCOAT	NYCO Minerals, Inc.	176.5	7.29
	Sparmite	Harcros Pigments Inc.	233.5	6.35
	MicroMica C-3000	KMG Minerals, Inc.	38.8	1.36
	Copperas R-5098	Harcros Pigments Inc.	38.7	0.90
<i>High Speed Disperse to a Texture of 5-6 N. S.</i>				
	Bentone SD-2	Elementis Specialties	<u>9.3</u>	<u>0.65</u>
	Total Part A		1099.3	75.00
Part B				
	EPIKURE Curing Agent 3140	Hexion	132.0	16.32
	Xylene	Shell Chemical Company	42.9	5.95
	n-Butanol	Shell Chemical Company	<u>18.4</u>	<u>2.73</u>
	Total Part B		193.3	25.00
	Total Part A & B		1292.6	100.0

Mixing Instructions

	Pounds	Gallons
Part A	1099.3	75.00
Part B	<u>193.3</u>	<u>25.00</u>
Part A + B	1292.6	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	3 : 1
	By weight	5.69 : 1.0
Total weight solids	%	81.2
Total volume solids	%	65.4
Pigment volume concentration (PVC)	%	35.0
Volatile Organic Compound (VOC)	lb/gal	2.43
	g/L	292
Induction Time	min.	30
Viscosity @ 25°C Part A + Part B		
	KU	85

Typical Film Table 2 / Film Properties
Properties

Drawdown on CRS. Cured for 7 days at 77 °F and 55% relative humidity.

	<u>Units</u>	<u>Value</u>
Pigment:binder ratio	%	1.72
Curing agent, based on solids	phr	56
Pot life from 85-130 KU	hrs	6
Pounds/gallon	lbs/gal	12.92
Dry film thickness	mils	1.5
Set-to-touch	hrs	1.0
Cotton free	hrs	7.5
Thru-dry	hrs	18.0
Pencil hardness		H
Impact resistance, direct/reverse		52/4
Flexibility		Pass 1/4
Salt spray testing (500 hrs)		2F-2M
Water resistance (500 hrs at 160 °F)		4M
Adhesion		5A

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,

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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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