

Starting Formulation

SF 1814

Rapid Dry Waterborne Epoxy Primer

EPI-REZ™ Resin 5522-WY-55 and 3540-WY-55 / EPIKURE™ Curing Agent 8290-Y-60

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPI-REZ Resin 5522-WY-55	Hexion	258.7	28.92
	Diacetone Alcohol	Shell Chemical Co.	5.4	0.69
	Colloid 640 Defoamer	Rhodia	2.7	0.32
	DI Water		59.4	7.13
	RO-4097 Kroma Red, Red Iron Oxide	Elementis Pigments Inc.	77.6	1.90
	10ES Wollastokup	NYCO, Inc.	116.6	4.81
	Halox SW-111	Halox Pigments, Inc.	116.6	4.90
<i>High Speed Disperse to a Texture of 5-6 Hegman.</i>				
	EPI-REZ Resin 5522-WY-55	Hexion	114.3	12.77
	EPI-REZ Resin 3540-WY-55	Hexion	74.1	8.24
	15% Aqueous solution of sodium nitrite (in water)		6.2	0.74
	Water		<u>79.7</u>	<u>9.58</u>
		Total Part A	911.4	80.00
Part B				
	EPIKURE Curing Agent 8290-Y-60	Hexion	46.7	5.29
	DI Water		8.6	1.03
	Zeeosphere 400 type	3M Industries, Inc.	77.8	3.89
	Water Ground Mica, 325 Mesh	KMG Minerals, Inc.	7.7	0.33
<i>High Speed Disperse to a texture of 4-5 Hegman</i>				
	DI Water		78.5	9.42
	Glacial Acetic Acid		<u>0.4</u>	<u>0.04</u>
		Total Part B	219.7	20.00
		Total Part A & B	1,131.1	100.00

Mixing Instructions

Generated: October 19, 2021
 Issue Date:
 Revision:

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	<u>Pounds</u>	<u>Gallons</u>
Part A	911.4	80.00
Part B	<u>219.7</u>	<u>20.00</u>
Part A + B	1,131.1	100.00

Resin Composition	<u>Units</u>	<u>Value</u>
Part A	% solids	89.6
Part B	% solids	<u>10.4</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
Total weight solids	%	59.1
Total volume solids	%	43.8
Pigment volume concentration (PVC)	%	36.2
Volatile Organic Compound (VOC)	lb/gal	1.19
	g/L	142.8
Induction Time	min.	30
Viscosity @ 25°C		
Part A	KU	64
Part B	KU	70
Parts A + B	KU	62

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 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:

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