

## Starting Formulation

SF 1811

Iron Oxide Primer

EPON™ Resin 828 / EPIKURE™ Curing Agent 8537-WY-60

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPON Resin 828	Hexion	114.0	11.85
	HELOXY™ Modifier 8	Hexion	<u>41.0</u>	<u>5.58</u>
	Total Part A		155.0	17.43
Part B				
	EPIKURE Curing Agent 8537-WY-60	Hexion	220.0	24.53
	Red Iron Oxide	Elementis Pigments	125.0	2.93
	Barium Sulfate	Elementis Pigments	375.0	10.20
	<i>Disperse to a texture of 7-8 Hegman, reduce speed, then add</i>			
	DI Water		<u>374.0</u>	<u>44.91</u>
	Total Part B		1,094.0	82.57
	Total Part A & B		1,249.0	100.00

### Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	155.0	17.43
Part B	<u>1,094.0</u>	<u>82.57</u>
Part A + B	1,249.0	100.00

### Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Nonvolatile content by weight	%	38.4
Part A	lb/gal	8.88
Part B	lb/gal	13.25
Parts A and B	lb/gal	12.49
Total weight solids	%	63.2
Total volume solids	%	44.06

Generated: October 19, 2021  
 Issue Date:  
 Revision:

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Pigment volume concentration (PVC)	%	30.0
Volatile Organic Compound (VOC)	lb/gal	0.9
	g/L	108
Spray Application	Reduce 10-1 with DI water to 85-90 K.U.	
Pot life	hrs	5-6
Viscosity @ 25°C		
Part A	KU	72
Part B	KU	130
Parts A + B	KU	99

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

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For product prices, availability, or order placement, please contact customer service:

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For literature and technical assistance, visit our website at [www.hexion.com](http://www.hexion.com)

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