

Starting Formulation

SF 1009

Gloss White Enamel

EPON™ Resin 828 / EPIKURE™ Curing Agent 3175

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPON Resin 828	Hexion	291.1	30.17
	TI-PURE® R960 HG	Du Pont Company	508.4	15.74
	BENTONE® SD-2 Thixotrope	Elementis Specialties Inc.	7.0	0.52
	BUSPERSE® 47, Dispersant/Viscosity Depressant	Buckman Laboratories	2.3	0.31
	EASTMAN® EP, 2-Propoxyethanol	Eastman Chemical Products, Inc.	4.5	0.59
<i>High Speed Disperse to GrindHegman 7-8</i>				
	EASTMAN EP, 2-Propoxyethanol	Eastman Chemical Products, Inc.	123.9	16.34
	BUSPERSE 47, Dispersant/Viscosity Depressant	Buckman Laboratories	2.3	0.31
	Methyl propyl ketone		<u>74.1</u>	<u>11.02</u>
	Total Part A		1,013.6	75.00
Part B				
	EPIKURE Curing Agent 3175	Hexion	158.3	19.69
	EASTMAN EP, 2-Propoxyethanol		<u>40.0</u>	<u>5.31</u>
	Total Part B		198.5	25.00
	Total Part A & B		1,212.1	100.00

Mixing Instructions

	Pounds	Gallons
Part A	1,013.6	75.00
Part B	<u>198.5</u>	<u>25.00</u>
Part A + B	1,212.1	100.00

Disperse the pigments in a suitable portion of the vehicle using high speed dispersing equipment. Let down the pigment dispersion with the remaining vehicle. Charge the two ingredients of the curing agent component to a separate suitable container and mix thoroughly. Package the base component and the curing agent component separately to be combined just prior to use.

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combined just prior to use.

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	5.11:1.0
Total weight solids	%	80.0
Total volume solids	%	66.7
Pigment volume concentration (PVC)	%	24.4
Volatile Organic Compound (VOC)	lb/gal	2.43
	g/L	292
Induction Time	minutes	30
Potlife	hrs	6
Viscosity @ 25°C		
Part A	KU	64
Part B	KU	61
Part A & B	KU	64

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.

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Contact Information

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

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