

Starting Formulation

SF 1613

Intermediate Coating for Film Build

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
	Rutile Titanium Dioxide		15.0	4.48
	Barium Sulfate		350.0	9.55
	<i>High speed disperse to texture of 7-8 Hegman, and add the following at reduced speed</i>			
	Tap Water		<u>367.0</u>	<u>44.01</u>
	Total Part B		952.0	82.57
	Total Part A & B		1,107.0	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	155.0	17.43
Part B	<u>952.0</u>	<u>82.57</u>
Part A + B	1,107.0	100.00

Resin Composition

	<u>Units</u>	<u>Value</u>
Part A	% solids	54.0
Part B	% solids	<u>46.0</u>
Part A + B	% solids	100.0

Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Total weight solids	%	63.2

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Total volume solids	%	45.2
Gloss (60° Angle)		83
Volatile Composition		
Water	lb/gal	412.0/49.4
Organic	lb/gal	43.0/5.3
Pigment volume concentration (PVC)	%	31.2
Volatiles Organic Compound (VOC)	lb/gal	0.85
	g/L	102
Application	Brush, Roller or Spray	
Pencil hardness on treated steel		
After 20 Hours		3B
After 72 Hours		HB
After 1 Week		2H
Viscosity @ 25° C		
Part A	KU	63
Part B	KU	88
Part A & B	KU	101

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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