

Starting Formulation

SF 1022

High Solids Lead and Chromate Free Primer
 EPON™ Resin 828 / EPIKURE™ Curing Agent 3175

Formula	Material	Supplier	Pounds	Gallons
	Part A			
	EPON Resin 828	Hexion	238.1	24.68
	Beetle™ U 216-8	Cytec Ind.	3.0	0.59
	Anti-Terra U Dispersant	BYK-Chemie USA	5.0	0.64
	Toluene	Shell Chemical Co.	75.0	10.41
	Butyl OXITOL™ Glycol Ether		20.4	2.72
	Bentone SD-2 Thixotrope	Elementis Specialties Inc.	10.2	1.20
	RD-4097 Kroma Red, Red Iron Oxide	Elementis Pigments	120.4	2.95
	ZP-10 Zinc Phosphate	Heucotech, Ltd.	150.0	5.45
	Sparmite Barium Sulfate	Harcros Pigments	341.3	9.31
	399 Lo-Micron Magnesium Silicate	Whittaker, Clark & Daniels, Inc.	120.3	5.34
	Water Ground Mica, 325 Mesh	Franklin Minerals Inc.	78.5	3.14
		High speed disperse to grind Hegman 5-6		
	EPON Resin 828	Hexion	24.8	2.56
	Xylene	Shell Chemical Co.	<u>96.3</u>	<u>13.37</u>
		Total Part A	1,283.3	82.36
	Part B			
	EPIKURE 3175 Curing Agent	Hexion	<u>142.2</u>	<u>17.64</u>
		Total Part B	142.2	17.64
		Total Part A & B	1,425.5	100.00

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Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	1,283.3	82.36
Part B	<u>142.2</u>	<u>17.64</u>
Part A + B	1,425.5	100.00

Resin Composition

	<u>Units</u>	<u>Value</u>
Part A	% Solids	64.9
Part B	% Solids	<u>35.1</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	4.67 : 1
	By weight	9.02 : 1.0
Total weight solids	%	86.1
Total volume solids	%	72.5
Pigment volume concentration (PVC)	%	37.8
Volatile Organic Compound (VOC)	lb/gal	1.92
	g/L	230
Induction Time	min.	30
Viscosity @ 25°C		
Part A + Part B	KU	124

Reduction to Table 2 / Reduction to Spray Viscosity by Volume (70-75 K.U.)
Spray Properties

	<u>Unit</u>	<u>Value</u>
Parts A and B		6.5
Xylene		1.0
Total Volume Solids at Application Viscosity	%	62.8
VOC at Application Viscosity	lb/gal	3.03
	g/L	364
Pot Life	hrs	11

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at www.hexion.com

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Safety, Storage & Handling

Please refer to the MSDS for the most current Safety and Handling information.

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