

Starting Formulation

SF 1030

High Gloss White Enamel for Low Temperature Applications
 EPON™ Resin 828 / EPIKURE™ Curing Agent 3292-FX-60

Formula	Material	Supplier	Pounds	Gallons
Part A				
	Ektasolve™ EP 2-Propoxyethanol	Eastman Chemical Products, Inc.	50.0	6.59
	EPON Resin 828	Hexion	180.0	18.56
	Anti-Terra™ U Dispersant	BYK-Chemie USA	5.0	0.64
	Beetle™ 216-8 Urea Formaldehyde Resin	Cytec Industries	5.0	0.59
<i>Mix thoroughly, then add:</i>				
	Tronox™ CR-800 Titanium Dioxide	Kerr-McGee Chemical Co.	266.6	7.75
	Barytes™ Barium Sulfate	Harcros Pigments Inc.	240.0	6.54
	WCD 399 Talc Magnesium Silicate	Whittaker, Clark & Daniels, Inc.	50.0	2.22
	Aerosil™ R-972 Thixotrope	Degussa, Inc.	3.0	0.16
<i>High speed disperse to 7 Hegman, reduce speed then add:</i>				
	EPON Resin 828		103.3	10.65
	Toluene	Shell Chemical Company	21.3	2.96
	Xylene	Shell Chemical Company	50.0	6.94
	Butyl OXITOL™ Glycol Ether	Shell Chemical Company	22.5	3.00
	BYK VP-320 Anti-mar Agent	BYK-Chemie USA	<u>0.5</u>	<u>0.07</u>
	Total Part A		997.2	66.67
Part B				
	EPIKURE Curing Agent 3292-FX-60	Hexion	<u>283.3</u>	<u>33.33</u>
	Total Part B		283.3	33.33
	Total Part A & B		1,280.5	100.00

Mixing Instructions

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	<u>Pounds</u>	<u>Gallons</u>
Part A	997.2	66.67
Part B	<u>283.3</u>	<u>33.33</u>
Part A + B	1,280.5	100.00

Resin Composition

	<u>Units</u>	<u>Value</u>
Part A	% solids	62.5
Part B	% solids	37.5
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	2 : 1
	By weight	3.52 : 1.0
Total weight solids	%	78.8
Total volume solids	%	63.7
Pigment volume concentration (PVC)	%	26.1
Volatile Organic Compound (VOC)	lb/gal	2.71
	g/L	325
Induction Time	min.	30
Viscosity @ 25°C		
Part A	KU	78
Part B, Gardner-Holdt		Z-1
Part A & B	KU	80

Reduction for Spray Table 2 / Reduction for conventional spray – by volume Properties

	<u>Units</u>	<u>Value</u>
Parts A and B	parts	30
Toluene	parts	1

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.

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