

# Starting Formulation

## SF 1816

### Waterborne Red Iron Oxide Primer

### EPI-REZ™ Resin 5522-WY-55 / EPIKURE™ Curing Agent 8290-Y-60

| Formula  | <u>Material</u>                        | <u>Supplier</u>         | <u>Pounds</u> | <u>Gallons</u> |
|--|--|-------------------------|---------------|----------------|
| Part A   |  |                         |               |                |
|  | EPI-REZ Resin 5522-WY-55               | Hexion                  | 330.0         | 37.21          |
|  | Diacetone Alcohol                      | Shell Chemical Co.      | 7.0           | 0.89           |
|  | Colloid 640 Defoamer                   | Rhodia                  | 3.5           | 0.41           |
|  | DI Water                               |                         | 80.0          | 9.60           |
|  | RO-4097 Kroma Red                      | Elementis Pigments Inc. | 100.0         | 2.45           |
|  | Sparmite                               | Elementis Pigments Inc. | 23.1          | 0.63           |
|  | 10ES Wollastokup                       | NYCO                    | 150.0         | 6.19           |
|  | Halox SW-111                           | Halox Pigments, Inc.    | 100.0         | 4.20           |
| <i>High Speed Disperse to a Texture of 6-7 N.S.</i>                          |  |                         |               |                |
|  | EPI-REZ Resin 5522-WY-55               | Hexion                  | 147.0         | 16.43          |
|  | 15% Sodium Nitrite Solution (in water) |                         | 8.0           | 0.95           |
|  | DI Water                               |                         | <u>8.7</u>    | <u>1.04</u>    |
|  | Total Part A                           |                         | 957.3         | 80.00          |
| Part B   |  |                         |               |                |
|  | EPIKURE Curing Agent 8290-Y-60         | Hexion                  | 60.0          | 6.80           |
|  | DI Water                               |                         | 11.0          | 1.32           |
|  | Zeeospheres Type 400                   | 3M Industries, Inc.     | 100.0         | 5.00           |
|  | Water Ground Mica, 325 mesh            | KMG Minerals, Inc.      | 10.0          | 0.43           |
| <i>High Speed Disperse to a Texture of 4-5 Hegman, reduce speed and add.</i> |  |                         |               |                |
|  | DI Water                               |                         | <u>53.7</u>   | <u>6.45</u>    |
|  | Total Part B                           |                         | 234.7         | 20.00          |
|  | Total Part A & B                       |                         | 1,192.0       | 100.00         |

#### Mixing Instructions

|        | <u>Pounds</u> | <u>Gallons</u> |
|--------|---------------|----------------|
| Part A | 957.3         | 80.00          |
| Part B | <u>234.7</u>  | <u>20.00</u>   |

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|            |         |        |
|------------|---------|--------|
| Part A + B | 1,192.0 | 100.00 |
|------------|---------|--------|

| Resin Composition |          | <u>Units</u> | <u>Value</u> |
|-------------------|----------|--------------|--------------|
| Part A            | % solids |              | 88.0         |
| Part B            | % solids |              | <u>12.0</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 :1         |
| Total weight solids                                 | %            | 65.4         |
| Total volume solids                                 | %            | 49.5         |
| Pigment volume concentration (PVC)                  | %            | 38.2         |
| Volatile Organic Compound (VOC)                     | lb/gal       | 1.17         |
|   | g/L          | 141          |
| Induction Time                                      | min.         | 30           |
| Viscosity @ 25°C                                    |              |              |
| Part A  | KU           | 114          |
| Part B  | KU           | 101          |
| Part A + B  | KU           | 106          |
| Reduction to Spray Viscosity (By Volume 70-75 K.U.) |              |              |
| Parts A and B                                       | parts        | 12           |
| Parts Water   | parts        | 1            |

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