Starting Formulation

SF 1816

Waterborne Red Iron Oxide Primer
EPI-REZ™ Resin 5522-WY-55 / EPIKURE™ Curing Agent 8290-Y-60

Formula	Material	Supplier	Pounds	Gallons
	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
	High Speed Disperse to a Texture of 6-7 N.S.			
	EPI-REZ Resin 5522-WY-55	Hexion	147.0	16.43
	15% Sodium Nitrite Solution (in water)		8.0	0.95
	DI Water		8.7	1.04
		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
	High Speed Disperse to a Texture of 4-5 Hegman, reduce speed and add.			
	DI Water		53.7	6.45
		Total Part B	234.7	20.00
		Total Part A & B	1,192.0	100.00

Mixing Instructions	Pounds	Gallons
Part A	957.3	80.00
Part B	234.7	20.00

Generated: October 21, 2021
Issue Date:
Revision:

Part A + B	1,192.0	100.00

Resin Composition	Units	Value
Part A	% solids	88.0
Part B	% solids	12.0
Part A + B	% solids	100.0

Typical Formulation Properties

Table 1 / Formulation Properties

	Units	Value
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

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.

Exposure to these materials should be minimized and avoided, if feasible, through the observance of proper precautions, use of appropriate engineering controls and proper personal protective clothing and equipment, and adherence to proper handling procedures. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheet (MSDS) for these and all other products being used are understood by all persons who will work with them. Questions and requests for information on Hexion Inc. ("Hexion") products should be directed to your Hexion sales representative, or the nearest Hexion sales office. Information and MSDSs on non-Hexion products should be obtained from the respective manufacturer.

Contact Information

For product prices, availability, or order placement, please contact customer service:

www.hexion.com/Contacts/

For literature and technical assistance, visit our website atwww.hexion.com

Generated: October 21, 2021
Issue Date:
Revision: