

Starting Formulation

SF 1611

High Gloss Tint Base Enamel

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	135.2	14.01
	HELOXY™ Modifier 8	Hexion	<u>44.9</u>	<u>5.99</u>
	Total Part A		180.1	20.00
Part B				
	EPIKURE Curing Agent 8537-WY-60	Hexion	160.0	17.78
	Alcolec 439-C Water-Dispersible Lecithin	American Lecithin Co.	3.6	0.41
	Kronos 2020, Rutile Titanium Dioxide	Kronos, Inc.	180.0	5.40
	<i>High speed disperse to a texture of 7-8 Hegman., then add</i>			
	EPIKURE Curing Agent 8537-WY-60	Hexion	95.7	9.82
	Glacial Acetic Acid		3.1	0.37
	Water		<u>385.0</u>	<u>46.22</u>
	Total Part B		827.4	80.00
	Total Part A & B		1,007.5	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	180.1	20.00
Part B	<u>827.4</u>	<u>80.00</u>
Part A + B	1,007.5	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

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Properties

	<u>Units</u>	<u>Value</u>
Mix ratio Part A : Part B	By volume	1 :4
	By weight	1 : 4.59
Total weight solids	%	51.0
Total volume solids	%	41.1
Pigment volume concentration (PVC)	%	13.1
Volatile Organic Compound (VOC)	lb/gal	1.16
	g/L	139
Viscosity @ 25°C		
Part A	KU	65
Part B	KU	72
Part A & B	KU	89

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

General Information

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