

Starting Formulation

SF 2017

Gray Appliance Primer

EPON™ Resin 1007F / Beckamine 21-511

- Features
- Good color and color retention
 - Outstanding adhesion
 - Excellent detergent resistance; will consistently pass 300 hours immersion in 1% detergent solution at 165 °F

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
	Pigments			
	Ti-Pure R-902	Du Pont Co.	76.3	2.29
	Superjet Carbon Black LB-1011	Harcros Pigments, Inc.	0.9	0.06
	EPON Resin 1007F solution			
	EPON Resin 1007F	Hexion	226.7	22.88
	Ethyl-3-ethoxy propionate		92.75	11.58
	Xylene		92.75	12.64
	Urea Resin and Solvents			
	Beckamine 21-511	Reichhold Chemicals, Inc.	161.9	18.96
	Ethyl 3-ethoxy propionate	Eastman Chemical	117.8	14.89
	Xylene	Shell Chemical Co.	<u>121.1</u>	<u>16.70</u>
		Total Formulation	890.2	100.00

Mixing Instructions	<u>Pounds</u>	<u>Gallons</u>
Total Formulation	890.2	100.00

Dissolve the EPON 1007F in the first portions of ethyl-3-ethoxy propionate and xylene. Disperse the pigments in the EPON 1007F solution on a three-roll mill or other suitable dispersing equipment. Let down the grind with the Beckamine 21-511 and the remaining solvents. NOTE: POOR GLOSS MAY RESULT IF A PORTION OF THE EPON RESIN SOLUTION IS USED IN LETTING DOWN THE DISPERSION.

Typical Handling For spray application, reduce the formulation to a No. 4 Ford Cup viscosity of 20 seconds
Properties with ethyl 3-ethoxy propionate/toluene, 1/1 by weight.

This coating system should be baked for 20 minutes at 385 °F.

Typical Formulation Table 1 / Formulation Properties Properties

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	<u>Units</u>	<u>Value</u>
EPON Resin 1007F/Beckamine 21-511 ratio (solids)	By weight	70/30
Nonvolatile content by weight	%	45.0
Weight per gallon	lb/gal	8.9
Pigment : Binder Weight Ratio		0.24/1.0
Pigment volume concentration (PVC)	%	6.6
Volatile Organic Compound (VOC)	lb/gal	4.89
	g/L	587

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.

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