

Starting Formulation

SF 1607

White Enamel

EPON™ Resin 828 / EPIKURE™ Curing Agent 8535-W-50

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	Rutile Titanium Dioxide		250.0	7.34
	EPON Resin 828	Hexion	130.0	13.50
High speed disperse to texture of 7-8 Hegman reduce speed and add				
	EPON Resin 828	Hexion	32.1	3.34
	HELOXY™ Modifier 8	Hexion	<u>53.5</u>	<u>5.82</u>
	Total Part A		465.6	30.00
Part B				
	EPIKURE Curing Agent 8535-W-50	Hexion	216.0	24.80
	Glacial Acetic Acid		2.0	0.24
	Water		<u>374.0</u>	<u>44.96</u>
	Total Part B		592.0	70.00
	Total Part A & B		1,057.6	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	465.6	30.00
Part B	<u>592.0</u>	<u>70.00</u>
Part A + B	1,057.6	100.00

	<u>Units</u>	<u>Value</u>
Part A	% solids	66.5
Part B	% solids	33.5
Part A + B	% solids	100.0

Typical Formulation Table 1 / Formulation Properties - Room Temperature Cure (Brush or Spray) Properties

<u>Units</u>	<u>Value</u>
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Mix ratio Part A : Part B	By volume	30 : 70
	By weight	0.78 : 1.0
Weight per gallon	lb/gal	10.58
Total weight solids	%	53.2
Total volume solids	%	45.8
Pigment volume concentration (PVC)	%	17.5
Volatile Organic Compound (VOC)	lb/gal	0.41
	g/L	49.2
Viscosity @ 25°C		
Part A & B - Fresh	KU	75 - 85
Part A & B - 1 Hour	KU	off scale
Gloss (60° Angle)	Units	98
Pencil Hardness, 72 Hours cure		B
Volatiles Composition		
Water	lbs	477.7
Organic	lbs	17.3

Reduction for Spray Table 2 / Reduction for Conventional Spray (By Volume)
Properties

	<u>Units</u>	<u>Value</u>
Parts A and B	Parts	17
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.

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Contact Information

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

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

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