

Starting Formulation

SF 1603

Clear Coating

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	169.0	17.60
	HELOXY™ Modifier 8	Hexion	<u>55.0</u>	<u>7.40</u>
	Total Part A		224.0	25.00
Part B				
	EPIKURE Curing Agent 8537-WY-60	Hexion	318.0	35.40
	Tap Water		<u>330.0</u>	<u>39.60</u>
	Total Part B		648.0	75.00
	Total Part A & B		872.0	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	224.0	25.00
Part B	<u>648.0</u>	<u>75.00</u>
Part A + B	872.0	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 Properties

	<u>Units</u>	<u>Value</u>
Mix ratio Part A : Part B	By volume	1 : 3
	By weight	1.0 : 2.89
Total weight solids	%	47.7
Total volume solids	%	44.5

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Volatile Organic Compound (VOC)	lb/gal	1.23
	g/L	147
Viscosity @ 25°C		
Part A	KU	58
Part B	KU	112
Part A & B	KU	110

Viscosity Reductions Table 2 / Viscosity Reductions

Parts Formula to Water	Resins Solids	Fresh	Viscosity (Krebs Units)			
			1 Hour	2 Hours	3 Hours	4 Hours
100:10	43.8%	110	116	120	125	132
100:20	40.2%	101	102	104	106	108
100:30	37.5%	92	95	98	101	102

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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