

Starting Formulation

SF 1026

Zinc-Rich Primer

EPONOL™ Resin 53-BH-35

- Features
- One-package fast drying shop primer
 - No hard settling on storage
 - Excellent corrosion resistance
 - Recommended as a primer in the maintenance, automotive and marine fields

| Formula | Material | Supplier | Pounds | Gallons |
|---|---------------------------------------|--|----------------|---------------|
| <i>Solvents & Additives</i> | | | | |
| | Thixatrol™ ST | Elementis Specialties, Inc. | 10.5 | 1.20 |
| | Propylene glycol methyl ether acetate | Eastman Chemical Products, Inc. | 124.8 | 15.54 |
| <i>EPONOL Resin Solution</i> | | | | |
| | EPONOL Resin 53-BH-35 | Hexion | 314.1 | 40.27 |
| Disperse above with high speed dispersing equipment. Disperse to a temperature of 130 °F to 140 °F and grind Hegman 5-6. Then add the following with good mixing. | | | | |
| <i>Pigments</i> | | | | |
| | Zinc dust type 335 | Meadowbrook Corp. | 1,533.0 | 25.80 |
| | Syloid™ ZN-1 | W. R. Grace & Co., Davison Chemical Division | 21.0 | 1.19 |
| | Xylene | Shell Chemical Co. | <u>114.7</u> | <u>16.00</u> |
| | | Total | 2,118.1 | 100.00 |

Mixing Instructions

| | Pounds | Gallons |
|--------|---------|---------|
| Part A | 2,118.1 | 100.00 |

Disperse the Thixatrol ST in the EPONOL Resin 53-BH-35 along with the solvents using high speed dispersing equipment. It should be noted that maximum thixotropy is developed at about 130 °F to 140 °F. The zinc dust and Syloid ZN-1 are then added with good agitation until they are thoroughly dispersed. Package immediately to minimize water pickup by this primer system.

Typical Handling Properties The primer may be thinned to application viscosity with a blend of propylene glycol methyl ether acetate/xylene, 60/40 by weight. The coating should be dry to handle in about 25 minutes.

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CAUTION: While the adhesion of epoxy two-package topcoats over EPONOL Resin zinc-rich primers is excellent, alkyds and epoxy ester topcoats should be avoided because poor adhesion has been observed in those types of topcoats over zinc-rich primers.

FDA Status EPONOL Resin 53-BH-35 does not meet the requirements of the Food and Drug Administration and, therefore, cannot be recommended for food contact applications

Typical Formulation Table 1 / Formulation Properties Properties

| | <u>Units</u> | <u>Value</u> |
|---------------------------------|--------------|--------------|
| Nonvolatile content by weight | % | 79.2 |
| Weight per gallon | lb/gal | 21.2 |
| Pigment : Binder Weight Ratio | | 93.7 |
| Volatile Organic Compound (VOC) | lb/gal | 4.41 |
| | g/L | 529 |

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 at www.hexion.com

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