

# Starting Formulation

SF 1609

Gloss White 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	125.8	13.04
	Heloxy™ Modifier 8	Hexion	42.0	5.68
	Isopropyl Alcohol		<u>8.4</u>	<u>1.28</u>
	Total Part A		176.2	20.00
Part B				
	EPIKURE Curing Agent 8537-WY-60	Hexion	160.0	17.78
	Colloid 640 Defoamer	Rhone-Poulenc, Inc.	4.0	0.50
	Rutile Titanium Dioxide, Kronos 2020	Kronos, Inc.	250.0	7.31
	<i>Disperse to a texture of 7-8 Hegman, then add at reduced speed</i>			
	EPIKURE Curing Agent 8537-WY-60	Hexion	79.0	8.78
	Colloid 640 Defoamer	Rhodia	4.0	0.50
	Water		<u>375.9</u>	<u>45.13</u>
	Total Part B		872.9	80.00
	Total Part A & B		1,049.1	100.00

## Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	176.2	20.00
Part B	<u>872.9</u>	<u>80.00</u>
Part A + B	1,049.1	100.00
<b>Resin Composition</b>		
Part A	% solids	54.0
Part B	% solids	46.0
Part A + B	% solids	100.0

Generated: October 19, 2021  
 Issue Date:  
 Revision:

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Typical Formulation Table 1 / Formulation Properties  
Properties

	<u>Units</u>	<u>Value</u>
Mix ratio Part A : Part B	By volume	1 : 4
	By weight	1 : 4.95
Total weight solids	%	53.5
Total volume solids	%	40.7
Pigment volume concentration (PVC)	%	17.9
Viscosity @ 25°C		
Part A	KU	55
Part B	KU	78
Part A & B	KU	93

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at [www.hexion.com](http://www.hexion.com)

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