

Starting Formulation

SF 1600

Block Fill Coating

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

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPON Resin 828	Hexion	113.0	11.70
	HELOXY™ Modifier 8	Hexion	37.2	5.02
	Pluronic F-98 Surfactant, 25% in water	BASF Corp.	7.5	0.86
	L-475 Defoamer	Drew Chemical Corp.	7.5	0.26
<i>Mix at low speed – 3 minutes. Add</i>				
	Rutile Titanium Dioxide		100.0	3.02
	Calcium Carbonate		150.0	6.67
	Silica	Illinois Minerals Co.	100.0	4.55
	Short Stuff Polyethylene Fibers	Mini-Fibers, Inc.	5.0	0.67
<i>Add water as needed for ease of dispersion.</i>				
	Water		<u>144.0</u>	<u>17.25</u>
	Total Part A		658.7	50.00
Part B				
	EPIKURE Curing Agent 8535-W-50	Hexion	151.0	17.30
	L-475 Defoamer	Drew Chemical Corp.	2.0	0.26
	Cab-O-Sil M5 Silica	Cabot Corp.	5.0	0.29
<i>Mix at low speed – 5 minutes. Add</i>				
	Celite 499 Silica	Johns-Manville Corp.	25.0	1.31
	Magnesium Silicate		100.0	4.22
	Short Stuff Polyethylene Fibers	Mini-Fibers, Inc.	3.0	0.40
<i>Add water as needed for ease of dispersion.</i>				
	Water		<u>218.0</u>	<u>26.22</u>
	Total Part B		504.0	50.00
	Total Part A & B		1162.7	100.00

Mixing Instructions

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	<u>Pounds</u>	<u>Gallons</u>
Part A	658.7	50.00
Part B	<u>504.0</u>	<u>50.00</u>
Part A + B	1162.7	100.00

Resin Composition		<u>Units</u>	<u>Value</u>
Part A	% solids		66.5
Part B	% solids		<u>33.5</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 : 1
	By weight	1.31 : 1.0
Application	Brush or Spray	
Cure	Room Temperature	
Pencil Hardness (at 72 hours)	B	
Volatiles Composition		
Water	lbs	434.5
Organic	lbs	19.0
Total weight solids	%	61.0
Total volume solids	%	45.0
Pigment volume concentration (PVC)	%	46.8
Volatile Organic Compound (VOC)	lb/gal	0.40
	g/L	48
Viscosity @ 25°C		
Part A	KU	Soft Paste
Part B	KU	88
Part A & B, Fresh	KU	100
½ hour	KU	130
1 hour	KU	141

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.

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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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