

Starting Formulation

SF 1605

High Gloss Gray Enamel

EPI-REZ™ Resin 3520-WY-55 / EPIKURE™ Curing Agent 8537-WY-60

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPI-REZ Resin 3520-WY-55	Hexion	411.6	45.03
	Michemlube 182 Mar and Slip Agent	Michelman Chemicals, Inc.	27.8	3.33
	Water		<u>13.7</u>	<u>1.64</u>
	Total Part A		453.1	50.00
Part B				
	EPIKURE Curing Agent 8537-WY-60	Hexion	120.0	13.27
	Ektasolve DB Acetate	Eastman Chemical Products, Inc.	8.2	1.00
	Triethylamine		3.7	0.61
	Patcote 519 Defoamer	C.D. Patterson Co.	4.0	0.57
	Kronos 20205 or Tronox CR-800	Kronos, Inc. Kerr-McGee Chemical Co.	180.0	5.40
<i>High Speed disperse to a texture of 10 P.C.S.</i>				
	EPIKURE Curing Agent 8537-WY-60	Hexion	82.4	9.16
	Water		<u>166.5</u>	<u>19.99</u>
	Total Part B		564.8	50.00
	Total Part A & B		1,017.9	100.00

Add 4 ounces Aqueous Lampblack Colorant (Colortrend 888-9907B) for every one gallon of the composite blend of Resin and Converter Portions.

Mixing Instructions

	Pounds	Gallons
Part A	453.1	50.00
Part B	<u>564.8</u>	<u>50.00</u>
Part A + B	1,017.9	100.00

Resin Composition

	Units	Value
Part A	% solids	65.0

Generated: October 19, 2021
 Issue Date:
 Revision:

© and ™ Licensed trademarks of Hexion Inc.

DISCLAIMER

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.

Part B	% solids	<u>35.0</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 : 1
	By weight	0.80 : 1.0
Volatile composition		
Water	lb/gal	364.3 / 43.66
Organics	lb/gal	90.2 / 11.64
Total weight solids	%	51.9
Total volume solids	%	40.4
Pigment volume concentration (PVC)	%	13.4
Volatile Organic Compound (VOC)	lb/gal	2.22
	g/L	266
Viscosity @ 25°C		
Part A	KU	85
Part B	KU	110
Part A & B	KU	99

Reduction for Spray Table 2 / Reduction for Conventional Spray (by volume) Properties

	<u>Units</u>	<u>Value</u>
Composite Blend	Parts	25
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.

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.

Generated: October 19, 2021
Issue Date:
Revision:

© and ™ Licensed trademarks of Hexion Inc.

DISCLAIMER

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.

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

Generated: October 19, 2021
Issue Date:
Revision:

® and ™ Licensed trademarks of Hexion Inc.

DISCLAIMER

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.