

Starting Formulation

SF 1010

Gloss White Enamel

EPON™ Resin 1001-Y-75 / EPIKURE™ Curing Agent 3115-E-73

Formula	Material	Supplier	Pounds	Gallons
Part A				
	TI-PURE® R960 HG	Du Pont Company	250.0	7.55
	Bentone 38 Thixotrop	Elementis Specialties Inc.	14.0	0.91
	Imperial Anti-Flooding (IAF) Compound X-2280	RLM Industries, Inc.	4.0	0.18
	EPON Resin 1001-Y-75	Hexion	305.0	33.00
	Beetle U-216-8 Urea Formaldehyde Resin	Cytec Industries	17.0	2.00
	2-Propoxyethanol		23.3	3.00
<i>High Speed Disperse to GrindHegman 7-8</i>				
	Cyclohexanone		63.0	8.00
	Diacetone Alcohol	Shell Chemical Company	35.2	4.50
	n-Butyl Alcohol ⁵	Shell Chemical Company	<u>50.8</u>	<u>7.53</u>
	Total Part A		762.3	66.67
Part B				
	EPIKURE Curing Agent 3115-E-73	Hexion	168.0	21.90
	Xylene		14.4	2.00
	Ethyl Benzene		25.4	3.50
	Isopropyl Alcohol	Shell Chemical Company	<u>39.0</u>	<u>5.93</u>
	Total Part B		246.8	33.33
	Total Part A & B		1,009.1	100.00

Mixing Instructions

	Pounds	Gallons
Part A	762.3	66.67
Part B	<u>246.8</u>	<u>33.33</u>
Part A + B	1,009.1	100.00

Generated: October 21, 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.

Resin Composition

	<u>Units</u>	<u>Value</u>
Part A	% Solids	65
Part B	% Solids	<u>35</u>
Part A + B	% Solids	100

Disperse the pigments in a suitable portion of the vehicle using high speed dispersing equipment or a sand mill. Let down the pigment dispersion with the remaining vehicle. Charge the two ingredients of the curing agent component to a separate suitable container and mix thoroughly. Package the base component and the curing agent component separately to be combined just prior to use.

Typical Handling Properties Slowly combine three parts by volume of base component with one part by volume of curing agent component and mix thoroughly. Allow the mixed formulation to "sweat in" for one hour. The system is then ready for spray application. Because of the limited pot life of the mixed formulation, do not mix more material than can be used in a working day. For application of this system in confined or poorly ventilated areas, we recommend the use of a fresh air-supplied hood and other protective clothing sufficient to cover the applicator's entire body.

Typical Formulation Properties Table 1 / Formulation Properties

	<u>Units</u>	<u>Value</u>
Mix ratio Part A : Part B	By volume	2 : 1
	By weight	3.09:1.0
Nonvolatile content by weight	%	47.6
Weight per gallon	lb./gal.	10.09
Total weight solids	%	61.5
Pigment volume concentration (PVC)	%	17.9
Volatile Organic Compound (VOC)	lb/gal	3.88
	g/L	466
Viscosity @ 25°C		
Part A	KU	74
Part B	KU	60
Part A & B	KU	71

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

Generated: October 21, 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.

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

Generated: October 21, 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.