

Starting Formulation

SF 1014

White Gloss Enamel

EPON™ Resin 1001-CX-75 / EPIKURE™ Curing Agent 3100-XY-60

Formula	Material	Supplier	Pounds	Gallons
Part A				
	Ti-Pure™ R-960	Du Pont Company	300.0	8.58
	Imperial Anti-Flooding (IAF) Compound X-2280	RLM Industries, Inc.	4.0	0.18
	EPON Resin 1001-CX-75	Hexion	224.0	25.00
	High Speed Disperser to grind Hegman 7-8			
	SYN-U-TEX™ 402 Amino Resin		12.9	1.50
	Diacetone Alcohol	Shell Chemical Company	78.0	10.00
	Butyl OXITOL™ Glycol Ether	Shell Chemical Company	<u>35.6</u>	<u>4.74</u>
	Total Part A		654.5	50.00
Part B				
	EPIKURE Curing Agent 3100-XY-60	Hexion	281.0	36.00
	Xylene		28.8	4.00
	Butyl OXITOL™ Glycol Ether	Shell Chemical Company	<u>75.0</u>	<u>10.00</u>
	Total Part B		384.8	50.00
	Total Part A & B		1,039.8	100.00

Mixing Instructions

	Pounds	Gallons
Part A	654.5	50.00
Part B	<u>384.8</u>	<u>50.00</u>
Part A + B	1,039.8	100.00

Typical Formulation Table 1 / Formulation Properties Properties

	Units	Value
Mix ratio Part A : Part B	By volume	1 : 1

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	By weight	1.70 : 1.0
Weight per gallon		
Resin portion	lb./gal.	13.09
Converter portion	lb./gal.	7.70
Composite blend	lb./gal.	10.39
Total weight solids	%	61.9
Vehicle solids	%	46.2
Pigment volume concentration (PVC)	%	18.4
Volatile Organic Compound (VOC)	lb/gal	3.92
	g/L	472
Viscosity @ 25°C		
Part A	KU	92
Part B	KU	62
Part A & B	KU	77
Application		Brush or spray
Curing		Room temperature

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at www.hexion.com

General 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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