

## Starting Formulation

SF 1025

White Corrosion Resistant Primer

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

Formula	Material	Supplier	Pounds	Gallons
Part A				
	Molywhite™ 101 Corrosion Inhibitive Pigment	Sherwin-Williams Co.	100.00	2.38
	Ti-Pure™ R-960, Rutile Titanium Dioxide	Du Pont Co.	200.0	6.05
	Sparmite™ Barium Sulfate	Harcros Pigments, Inc.	75.0	2.04
	Bentone™ 38 Thixotrope	Elementis Specialties Inc.	5.0	0.33
	EPON Resin 1001-Y-75	Hexion	208.0	22.50
	Xylene		14.4	2.00
	Ektasolve™ EP, 2-Propoxyethanol	Eastman Chemical Products, Inc.	46.6	6.00
	Diacetone Alcohol	Shell Chemical Co.	39.2	5.00
	Cyclohexanone		<u>29.2</u>	<u>3.70</u>
	Total Part A		717.4	50.00
Part B				
	399 Lo-micron™ Magnesium Silicate	Whittaker Clark & Daniels, Inc.	175.0	7.38
	Bentone™ 38 Thixotrope	Elementis Specialties Inc.	8.0	0.53
	EPIKURE Curing Agent 3115-E-73	Hexion	115.0	14.97
	Ethyl Benzene		25.3	3.50
	Ektasolve™ EP, 2-Propoxyethanol	Eastman Chemical Products, Inc.	54.4	7.00
	n-Butyl Alcohol	Shell Chemical Co.	71.0	10.50
	Isopropyl Alcohol	Shell Chemical Co.	<u>40.2</u>	<u>6.12</u>
	Total Part B		488.9	50.00
	Total Part A & B		1,206.3	100.00

### Mixing Instructions

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	<u>Pounds</u>	<u>Gallons</u>
Part A	717.4	50.00
Part B	<u>488.9</u>	<u>50.00</u>
Part A + B	1,206.3	100.00

Resin Composition

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

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	1.47 : 1.0
Vehicle Non-Volatile	%	37.4
Weight per gallon	lb./gal.	12.06
Total weight solids	%	66.7
Pigment volume concentration (PVC)	%	41.0
Volatile Organic Compound (VOC)	lb/gal	4.51
	g/L	541
Viscosity @ 25°C		
Part A +	KU	90
Part B	KU	65
Part A & B	KU	68
Application	Brush or Spray	
Cured Schedule	Room Temperature	

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

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