

# Starting Formulation

SF 1046

High Solids Red Iron Oxide Epoxy Primer  
 EPON™ Resin 874-CX-90 / EPIKURE™ Curing Agent 3175

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPON Resin 874-CX-90	Hexion	305	33.41
	Beetle 216-8	American Cyanamid Company	11.0	1.30
	Xylene	Shell Chemical Company	75.5	10.49
	MIBK	Shell Chemical Company	60.4	9.10
	PGME Acetate		15.1	1.86
	Zinc Phosphate J-0852	Davis Colors	181.5	6.93
	10 ES WOLLASTOKUP	NYCO Minerals, Inc.	181.5	7.50
	Sparmite	Harcros Pigments. Inc.	238.0	6.48
	MicroMica C-3000	KMG Minerals, Inc.	39.5	1.39
	Copperas R-5098	Harcros Pigments. Inc.	39.5	0.91
<i>High Speed Disperse to a Texture of 5-6 Hegman.</i>				
	Bentone SD-2	Elementis Specialties	<u>9.0</u>	<u>0.63</u>
	Total Part A		1156.0	80.00
Part B				
	EPIKURE Curing Agent 3175	Hexion	110.0	13.61
	Xylene	Shell Chemical Company	31.5	4.38
	n-Butanol	Shell Chemical Company	<u>13.5</u>	<u>2.01</u>
	Total Part B		155.0	20.00
	Total Part A & B		1311.0	100.0

## Mixing Instructions

	Pounds	Gallons
Part A	1156.0	80.00
Part B	<u>155.0</u>	<u>20.00</u>

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Part A + B	1311.0	100.0
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Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Mix ratio Part A : Part B	By volume	4 : 1
	By weight	7.46: 1.0
Total weight solids	%	82.39
Total volume solids	%	67.11
Pigment volume concentration (PVC)	%	35.0
Volatile Organic Compound (VOC)	lb/gal	2.31
	g/L	277
Induction Time	min.	30
Viscosity @ 25°C		
Part A + Part B	KU	85

Typical Film Table 2 / Film Performance Properties Properties

*Drawdown on CRS for 7 days at 77 °F and 55% relative humidity.*

	<u>Units</u>	<u>Value</u>
Pigment : binder ratio	%	1.70
Curing agent phr	on solids	40
Pot life from 85-130 KU	hrs	8
Pounds/gallon	lbs/gal	13.11
Dry film thickness	mils	1.5
Set-to-touch	hrs	0.75
Cotton free	hrs	7.5
Thru-dry	hrs	13.0
Pencil hardness		H
Impact resistance, direct/reverse		54/4
Flexibility		Pass 1/4
Salt spray testing (1000 hrs)		6F-6M
Water resistance (1000 hrs at 160 °F)		6M
Adhesion		5A

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

General Information

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