

# Starting Formulation

## SF 1807

### Waterborne Red Iron Oxide Primer

### EPI-REZ™ Resin 5522-WY-55 / EPIKURE™ Curing Agent 8290-Y-60

Formula	Material	Supplier	Pounds	Gallons
<b>Part A</b>				
	EPI-REZ Resin 5522-WY-55	Hexion	330.0	37.21
	Diacetone Alcohol	Shell Chemical Co.	7.0	.89
	Colloid 640 Defoamer	Rhodia	3.5	.41
	Water		80.0	9.60
	RO-4097 Kroma Red	Elementis Pigments Co.	100.0	2.45
	Sparmite	Harcros Pigments, Inc.	100.0	2.73
	IOES Wollastokup	NYCO	150.0	6.19
	Halox SW-111	Halox Pigments	50.0	2.10
High Speed Disperse to a texture of 5-6 Hegman				
	EPI-REZ Resin 5522-WY-55	Hexion	147.0	16.43
	DI Water		16.6	1.99
		<b>Total Part A</b>	<b>984.1</b>	<b>80.00</b>
<b>Part B</b>				
	EPIKURE Curing Agent 8290-Y-60	Hexion	60.0	1.32
	DI Water		11.0	5.00
	Zeeosphere Type 400	3M Specialty Materials	100.0	.43
	Water Ground Mica, 325 mesh	KMG Minerals, Inc.	10.0	1.32
High Speed Disperse to a texture of 4-5 Hegman				
	DI Water		53.7	6.45
		<b>Total Part B</b>	<b>234.7</b>	<b>20.00</b>
		<b>Total Part A &amp; B</b>	<b>1,218.8</b>	<b>100.00</b>

#### Mixing Instructions

	Pounds	Gallons
Part A	984.1	80.00
Part B	234.7	20.00

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.

Part A + B	1,218.8	100.00
Resin Composition		
Part A	% solids	88.0
Part B	% solids	12.0
Part A + B	% solids	100.0

Typical Formulation Table 1 / Formulation Properties Properties

	Units	Value
Mix ratio Part A: Part B	By volume	4 :1
	By weight	4.19 : 1.0
Total weight solids	%	66.3
Total volume solids	%	49.8
Pigment volume concentration (PVC)	%	38.0
Volatile Organic Compound (VOC)	lb/gal	1.20
	g/L	143.94
Induction Time	min.	30
Viscosity @ 25°C		
Part A	KU	82
Part B	KU	101
Part A + B	KU	85

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.

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/](http://www.hexion.com/Contacts/)

For literature and technical assistance, visit our website at [www.hexion.com](http://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.