

Starting Formulation

SF 1005

Black Enamel

EPON™ Resin 1001-CX-75 / EPIKURE™ Curing Agent 3115-X-70

- Features
- Formulated for spray application
 - Desirable mixing ration of 1 to 1 by volume

Formula	Material	Supplier	Pounds	Gallons
Part A				
	Carbon black: Monarch™ 880	Cabot Corporation	13.6	0.91
	EPIKURE Curing Agent 3115-X-70	Hexion	98.7	12.66
	Ethyl 3-ethoxy propionate		41.0	5.24
Mill grind to a steel ball mill and grind for 48 hours, and let down with the following				
	EPIKURE Curing Agent 3115-X-70		29.6	3.79
	n-Butanol		17.9	2.66
	Ethyl 3-ethoxy propionate		193.4	24.74
	Paint Additive #11	Dow Corning Corporation	<u>0.8</u>	
		Total Part A	395.0	50.00
Part B				
	EPON Resin 1001-CX-75	Hexion	217.5	23.90
	Beetle™ U216-8	Cytec Industries	13.6	1.61
	Xylene	Shell Chemical Company	<u>175.5</u>	<u>24.49</u>
		Total Part B	406.6	50.00
		Total Part A & B	801.8	100.00

Mixing Instructions

	Pounds	Gallons
Part A	395.0	50.00
Part B	406.6	50.00
Part A + B	801.8	100.00

Charge the ingredients of the mill grind to a steel ball mill and grind for 48 hours. Discharge mill and let down this mixture with the let down solution. The materials in the base component are simply combined, mixed and packaged.

Typical Handling Combine equal volumes of the curing agent component and the base component, and mix thoroughly. Allow the mixed formulation to "sweat in" for one hour. The system is then

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Properties thoroughly. Allow the mixed formulation to sweat in for one hour. The system is then ready for spray application. 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 Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Mix ratio Part A : Part B	by volume	1 : 1
	by weight	0.97:1.0
Nonvolatile content by weight	%	34.3
Weight per gallon	lb./gal.	8.0
Pigment : Binder Weight Ratio		0.05/1.0
Pigment volume concentration (PVC)	%	3.2
Volatile Organic Compound (VOC)	lb/gal	5.27
	g/L	632
Induction Time	hrs	1.0
Pot life	hrs	8+

Cure Schedules Table 2 / Cure Schedules

At ambient temperatures of 70°F to 80°F, this coating will dry to handle in about six hours. Physical properties will be fully developed in about two days. Chemical and solvent resistance will be fully developed in seven days. At ambient temperatures of 55°F, several weeks may be required to produce full cure.

	<u>Units</u>	<u>Value</u>
Force dry, to asandable stage		
100°F	hrs	1.5 – 2
110°F	hrs	1 – 1.5
120°F	min.	45
140°F	min.	30
Force dry, to full cure		
140°F	hrs	1.5
High temperature bake, to full cure		
200°F	min.	20
250°F	min.	10
300°F	min.	7
350°F	min.	4
400°F	min.	2

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,

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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:

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