

Starting Formulation

SF 1016

Gloss White Enamel

EPON™ Resin 8521-MX-60 / EPIKURE™ Curing Agent 3125

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPON Resin 8521-MX-60	Hexion	396.0	45.00
	X-2280 IAF Compound Anti-Floating Agent	RLM Industries Inc.	3.0	0.14
	Ti-Pure R-902	DuPont Co.	300.0	8.58
	Diacetone Alcohol	Shell Chemical Co.	39.1	5.00
	High Speed Disperse to grind Hegman 7-8			
	2-Propoxyethanol		75.8	10.00
	Xylene	Shell Chemical Co.	<u>45.0</u>	<u>6.28</u>
	Total Part A		858.9	75.00
Part B				
	EPIKURE Curing Agent 3125	Hexion	60.6	7.45
	Xylene		<u>126.5</u>	<u>17.55</u>
	Total Part B		187.1	25.00
	Total Part A & B		1,046.0	100.00

Mixing Instructions

	Pounds	Gallons
Part A	858.9	75.00
Part B	<u>187.1</u>	<u>25.00</u>
Part A + B	1,046.0	100.00

Resin Composition

	Units	Value
Part A	% Solids	79.7
Part B	% Solids	<u>20.3</u>
Part A + B	% Solids	100

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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	3 : 1
	By weight	4.59:1.0
Total weight solids	%	57.2
Total volume solids	%	38.2
Pigment volume concentration (PVC)	%	22.5
Volatile Organic Compound (VOC)	lb/gal	4.45
	g/L	534
Induction Time	min.	60
Viscosity @ 25°C		
Part A	KU	75
Part B, Ford Cup	sec.	12
Part A & B	KU	62

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, 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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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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