

# Starting Formulation

## SF 1801

### Clear Enamel (Maximum Solvent and Abrasion Resistance) EPI-REZ™ Resin 5522-WY-55 / EPIKURE™ Curing Agent 8290-Y-60

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPI-REZ Resin 5522-WY-55	Hexion	477.2	53.31
	CYCLO SOL 63	Shell Chemical Co.	32.3	4.37
	Ektasolve EP, 2-Propoxyethanol	Eastman Chemical Products, Inc.	33.2	4.37
	Water		<u>107.9</u>	<u>12.95</u>
		Total Part A	650.6	75.00
Part B				
	EPIKURE Curing Agent 8290-Y-60	Hexion	145.8	16.51
	Patcote 847 Defoamer	C.J. Patterson Co.	4.0	0.56
	Water		<u>66.1</u>	<u>7.93</u>
		Total Part B	215.9	25.00
		Total Part A & B	866.5	100.00

#### Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	650.6	75.00
Part B	<u>215.9</u>	<u>25.00</u>
Part A + B	866.5	100.00

#### Resin Composition

	<u>Units</u>	<u>Value</u>
Part A	% solids	75.0
Part B	% solids	25.0
Part A + B	% solids	100.0

#### Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Mix Ratio Part A: Part B	Bv weight	3 : 1

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Total weight solids	%	40.4
Total volume solids	%	36.0
Volatile Organic Compound (VOC)	lb/gal	2.84
	g/L	340
Induction Time	min.	30
Viscosity @ 25°C		
Part A	KU	68
Part B	KU	64
Part A + B	KU	75

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

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