# Starting Formulation

**SF 1616**

**Masonry Block Fill**

EPI-REZ™ Resin 3520-WY-55 / EPIKURE™ Curing Agent 8537-WY-60

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>2-Propoxylethanol</td>
<td>11.6</td>
<td>1.50</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Triton X-100 Surfactant</td>
<td>Dow Chemical Co.</td>
<td>3.5</td>
<td>0.39</td>
</tr>
<tr>
<td></td>
<td>Tamol 731 Surfactant</td>
<td>Rohm &amp; Haas Co.</td>
<td>3.5</td>
<td>0.38</td>
</tr>
<tr>
<td></td>
<td>Colloid 640 Defoamer</td>
<td>Rhodia</td>
<td>4.0</td>
<td>0.50</td>
</tr>
<tr>
<td></td>
<td>DI Water</td>
<td>71.0</td>
<td>8.50</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Mix and add</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Rutile Titanium Dioxide</td>
<td>50.0</td>
<td>1.46</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Atomite Calcium Carbonate</td>
<td>Thompson Weinman</td>
<td>75.0</td>
<td>3.30</td>
</tr>
<tr>
<td></td>
<td>ASP 170 Aluminum Silicate</td>
<td>Englehard Minerals +</td>
<td>35.0</td>
<td>1.67</td>
</tr>
<tr>
<td></td>
<td><strong>Hi speed disperse 10 minutes; then add</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Short Stuff Polyethylene Fibers</td>
<td>Mini Fibers, Inc.</td>
<td>7.0</td>
<td>0.93</td>
</tr>
<tr>
<td></td>
<td>DI Water</td>
<td>11.4</td>
<td>1.37</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Add at reduced speed</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>EPI-REZ Resin 3520-WY-55</td>
<td>Hexion</td>
<td>260.0</td>
<td>30.00</td>
</tr>
<tr>
<td></td>
<td>Total Part A</td>
<td></td>
<td>532.0</td>
<td>50.00</td>
</tr>
<tr>
<td>Part B</td>
<td>EPIKURE Curing Agent 8537-WY-60</td>
<td>Hexion</td>
<td>129.0</td>
<td>14.25</td>
</tr>
<tr>
<td></td>
<td>DI Water</td>
<td>166.0</td>
<td>20.00</td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Mix well and add</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>ASP 170 Aluminum Silicate</td>
<td>Englehard Minerals &amp;</td>
<td>50.0</td>
<td>2.38</td>
</tr>
<tr>
<td></td>
<td>325 Mesh Water Ground Mica</td>
<td>English Mica Co.</td>
<td>100.0</td>
<td>4.24</td>
</tr>
<tr>
<td></td>
<td>Atomite Calcium Carbonate</td>
<td>Thompson Weinman</td>
<td>125.0</td>
<td>5.56</td>
</tr>
<tr>
<td></td>
<td><strong>Hi speed disperse 10 minutes; then add</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>Short Stuff Polyethylene Fibers</td>
<td>Mini Fibers, Inc.</td>
<td>1.0</td>
<td>0.13</td>
</tr>
<tr>
<td></td>
<td>Tap Water</td>
<td>28.7</td>
<td>3.44</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Total Part B</td>
<td>599.7</td>
<td>50.00</td>
<td></td>
</tr>
</tbody>
</table>

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Total Part A & B  1,131.7  100.00

Mixing Instructions

<table>
<thead>
<tr>
<th></th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>532.0</td>
<td>50.00</td>
</tr>
<tr>
<td>Part B</td>
<td>599.7</td>
<td>50.00</td>
</tr>
<tr>
<td>Part A + B</td>
<td>1,131.7</td>
<td>100.00</td>
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</tbody>
</table>

Resin Composition

<table>
<thead>
<tr>
<th></th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>% solids</td>
<td>65.0</td>
</tr>
<tr>
<td>Part B</td>
<td>% solids</td>
<td>35.0</td>
</tr>
<tr>
<td>Part A + B</td>
<td>% solids</td>
<td>100.0</td>
</tr>
</tbody>
</table>

Caution: Although this coating will maintain a workable viscosity for 7 to 10 days, it is advisable to discard the material eight hours after the two components have been blended. Beyond eight hours film hardness is adversely affected.

Typical Formulation Properties

<table>
<thead>
<tr>
<th>Table 1 / Formulation Properties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mix ratio Part A : Part B</td>
<td>By volume</td>
<td>1 : 1</td>
</tr>
<tr>
<td></td>
<td>By weight</td>
<td>0.89 : 1.0</td>
</tr>
<tr>
<td>Total weight solids</td>
<td>%</td>
<td>67.4</td>
</tr>
<tr>
<td>Total volume solids</td>
<td>%</td>
<td>46.2</td>
</tr>
<tr>
<td>Pigment volume concentration (PVC)</td>
<td>%</td>
<td>42.2</td>
</tr>
<tr>
<td>Volatiles Composition</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Water, lbs./ 100 gallons</td>
<td>lbs</td>
<td>393.6</td>
</tr>
<tr>
<td>Organic, lbs.</td>
<td>Lbs/gal</td>
<td>1.21</td>
</tr>
<tr>
<td></td>
<td>g/l</td>
<td>145</td>
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</tbody>
</table>

Application

Brush and Roller

Viscosity @ 25°C

<table>
<thead>
<tr>
<th></th>
<th>KU</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td></td>
<td>128</td>
</tr>
<tr>
<td>Part B</td>
<td></td>
<td>108</td>
</tr>
<tr>
<td>Part A + B</td>
<td>108</td>
<td></td>
</tr>
<tr>
<td>Fresh</td>
<td></td>
<td>108</td>
</tr>
<tr>
<td>2 Hours</td>
<td></td>
<td>104</td>
</tr>
<tr>
<td>4 Hours</td>
<td></td>
<td>104</td>
</tr>
<tr>
<td>6 Hours</td>
<td></td>
<td>104</td>
</tr>
<tr>
<td>8 Hours</td>
<td></td>
<td>106</td>
</tr>
</tbody>
</table>
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.

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