Starting Formulation

SF 1817

Red Oxide Primer

EPON™ Resin 828 / EPIKURE™ Curing Agent 8535-W-50

<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>EPON Resin 828</td>
<td>Hexion</td>
<td>130.0</td>
<td>13.50</td>
</tr>
<tr>
<td></td>
<td>Red Iron Oxide</td>
<td></td>
<td>125.0</td>
<td>2.93</td>
</tr>
<tr>
<td></td>
<td>Barium Sulfate</td>
<td></td>
<td>282.2</td>
<td>7.70</td>
</tr>
</tbody>
</table>

Disperse to texture of 6-7 P.C.S. Add following at reduced speed

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>EPON Resin 828</td>
<td>Hexion</td>
<td>32.1</td>
<td>3.34</td>
</tr>
<tr>
<td></td>
<td>HELOXY™ Modifier 8</td>
<td>Hexion</td>
<td>53.5</td>
<td>7.22</td>
</tr>
</tbody>
</table>

Total Part A

<table>
<thead>
<tr>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>622.8</td>
<td>34.69</td>
</tr>
</tbody>
</table>

Part B

<table>
<thead>
<tr>
<th>Formula</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>EPIKURE Curing Agent 8535-W-50</td>
<td>Hexion</td>
<td>216.0</td>
<td>24.80</td>
</tr>
<tr>
<td>Glacial Acetic Acid</td>
<td></td>
<td>2.0</td>
<td>0.24</td>
</tr>
<tr>
<td>Water</td>
<td></td>
<td>334.0</td>
<td>40.27</td>
</tr>
</tbody>
</table>

Total Part B

<table>
<thead>
<tr>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
<td>552.0</td>
<td>65.31</td>
</tr>
</tbody>
</table>

Mixing Instructions

<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></td>
<td></td>
<td>622.8</td>
<td>34.69</td>
</tr>
<tr>
<td>Part B</td>
<td></td>
<td></td>
<td>552.0</td>
<td>65.31</td>
</tr>
<tr>
<td>Part A + B</td>
<td></td>
<td></td>
<td>1,174.8</td>
<td>100.00</td>
</tr>
</tbody>
</table>

Resin Composition

<table>
<thead>
<tr>
<th>Formula</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>% solids</td>
<td>49.96</td>
</tr>
<tr>
<td>Part B</td>
<td>% solids</td>
<td>50.04</td>
</tr>
<tr>
<td>Part A + B</td>
<td>% solids</td>
<td>100.0</td>
</tr>
</tbody>
</table>

Typical Formulation Table 1 / Formulation Properties

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Page 1 of 2
<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total weight solids</td>
<td>%</td>
<td>61.24</td>
</tr>
<tr>
<td>Total volume solids</td>
<td>%</td>
<td>45.07</td>
</tr>
<tr>
<td>Pigment volume concentration (PVC)</td>
<td>%</td>
<td>23.2</td>
</tr>
<tr>
<td>Volatile Organic Compound (VOC)</td>
<td>lb/gal</td>
<td>0.04</td>
</tr>
<tr>
<td></td>
<td>g/L</td>
<td>4.8</td>
</tr>
</tbody>
</table>

**Volatile Composition**

<table>
<thead>
<tr>
<th>Component</th>
<th>lbs/gal</th>
</tr>
</thead>
<tbody>
<tr>
<td>Water</td>
<td>453.8/54.5</td>
</tr>
<tr>
<td>Organic</td>
<td>4.2/0.5</td>
</tr>
</tbody>
</table>

**Pot life**

<table>
<thead>
<tr>
<th></th>
<th>hrs</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>1 – 2</td>
</tr>
</tbody>
</table>

**Viscosity @ 25°C**

<table>
<thead>
<tr>
<th>Component</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>KU</td>
<td>130</td>
</tr>
<tr>
<td>Part B, Gardner-Holdt</td>
<td>A</td>
<td></td>
</tr>
<tr>
<td>Part A + B</td>
<td>KU</td>
<td>119</td>
</tr>
<tr>
<td>Reduced Viscosity, 10:1 in water</td>
<td>KU</td>
<td>80 - 90</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).

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

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