## 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><strong>EPON Resin 828</strong></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>
<tr>
<td></td>
<td>Disperse to texture of 6-7 P.C.S. Add following at reduced speed</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>EPON Resin 828</strong></td>
<td>Hexion</td>
<td>32.1</td>
<td>3.34</td>
</tr>
<tr>
<td></td>
<td><strong>HELOXY™ Modifier 8</strong></td>
<td>Hexion</td>
<td>53.5</td>
<td>7.22</td>
</tr>
<tr>
<td></td>
<td><strong>Total Part A</strong></td>
<td></td>
<td>622.8</td>
<td>34.69</td>
</tr>
</tbody>
</table>

| Part B  | **EPIKURE Curing Agent 8535-W-50** | Hexion | 216.0 | 24.80 |
|         | Glacial Acetic Acid               |          | 2.0   | 0.24   |
|         | Water                            |          | 334.0 | 40.27  |
|         | **Total Part B**                  |          | 552.0 | 65.31  |
|         | **Total Part A & B**              |          | 1,174.8 | 100.00 |

### Mixing Instructions

<table>
<thead>
<tr>
<th></th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>622.8</td>
<td>34.69</td>
</tr>
<tr>
<td>Part B</td>
<td>552.0</td>
<td>65.31</td>
</tr>
<tr>
<td>Part A + B</td>
<td>1,174.8</td>
<td>100.00</td>
</tr>
</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>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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<table>
<thead>
<tr>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total weight solids</td>
<td>%</td>
</tr>
<tr>
<td>Total volume solids</td>
<td>%</td>
</tr>
<tr>
<td>Pigment volume concentration (PVC)</td>
<td>%</td>
</tr>
<tr>
<td>Volatile Organic Compound (VOC)</td>
<td>lb/gal</td>
</tr>
<tr>
<td></td>
<td>g/L</td>
</tr>
</tbody>
</table>

### Volatile Composition

<table>
<thead>
<tr>
<th>Water</th>
<th>lbs/gal</th>
<th>453.8/54.5</th>
</tr>
</thead>
<tbody>
<tr>
<td>Organic</td>
<td>lbs/gal</td>
<td>4.2/0.5</td>
</tr>
<tr>
<td>Pot life</td>
<td>hrs</td>
<td>1 – 2</td>
</tr>
</tbody>
</table>

### Viscosity @ 25°C

<table>
<thead>
<tr>
<th>Part A</th>
<th>KU</th>
<th>130</th>
</tr>
</thead>
<tbody>
<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

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For literature and technical assistance, visit our website at www.hexion.com