Starting Formulation

SF 1601

Clear Glazing Enamel for Masonry
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>EPI-REZ Resin 3520-WY-55</td>
<td>Hexion</td>
<td>732.1</td>
<td>80.00</td>
</tr>
<tr>
<td></td>
<td>Total Part A</td>
<td></td>
<td>732.1</td>
<td>80.00</td>
</tr>
<tr>
<td>Part B</td>
<td>EPIKURE Curing Agent 8537-WY-60</td>
<td>Hexion</td>
<td>118.0</td>
<td>13.05</td>
</tr>
<tr>
<td></td>
<td>Acrysol A-1/AMP 95 Solution</td>
<td>See below</td>
<td>2.0</td>
<td>.24</td>
</tr>
<tr>
<td></td>
<td>Troy Q-148 Defoamer</td>
<td>Troy Chemicals</td>
<td>4.0</td>
<td>.48</td>
</tr>
<tr>
<td></td>
<td>Water</td>
<td></td>
<td>52.2</td>
<td>6.23</td>
</tr>
<tr>
<td></td>
<td>Total Part B</td>
<td></td>
<td>175.2</td>
<td>20.00</td>
</tr>
<tr>
<td></td>
<td>Total Part A &amp; B</td>
<td></td>
<td>907.3</td>
<td>100.00</td>
</tr>
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</table>

Mixing Instructions

<table>
<thead>
<tr>
<th></th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>732.1</td>
<td>80.00</td>
</tr>
<tr>
<td>Part B</td>
<td>175.2</td>
<td>20.00</td>
</tr>
<tr>
<td>Part A + B</td>
<td>907.3</td>
<td>100.00</td>
</tr>
</tbody>
</table>

Typical Formulation Table 1 / Formulation Properties

<table>
<thead>
<tr>
<th>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>4 : 1</td>
</tr>
<tr>
<td></td>
<td>By weight</td>
<td>4.18 : 1.0</td>
</tr>
<tr>
<td>Total weight solids</td>
<td>%</td>
<td>52.0</td>
</tr>
<tr>
<td>Total volume solids</td>
<td>%</td>
<td>47.2</td>
</tr>
<tr>
<td>Volatile Organic Compound (VOC)</td>
<td>lb/gal</td>
<td>1.37</td>
</tr>
<tr>
<td></td>
<td>g/L</td>
<td>166</td>
</tr>
<tr>
<td>Viscosity @ 25°C</td>
<td>KU</td>
<td>110</td>
</tr>
<tr>
<td></td>
<td>KU</td>
<td>145</td>
</tr>
</tbody>
</table>

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Revision:
Solution Preparation Table 2 / Solution Preparation

<table>
<thead>
<tr>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Acrysol A-1 (Rohm &amp; Haas Co.)</td>
<td>Parts 288.0</td>
</tr>
<tr>
<td>AMP-95</td>
<td>Parts 67.5</td>
</tr>
</tbody>
</table>

Mix well!

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at www.hexion.com

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