**Starting Formulation**

**SF 1808**

**Solvent Resistant, Water-Reducible Epoxy Primer**

**EPI-REZ™ Resin 5522-WY-55 / EPIKURE™ Curing Agent 8290-Y-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 5522-WY-55</td>
<td>Hexion</td>
<td>200.0</td>
<td>22.35</td>
</tr>
<tr>
<td></td>
<td>Diacetone Alcohol</td>
<td>Shell Chemical Co.</td>
<td>6.6</td>
<td>0.84</td>
</tr>
<tr>
<td></td>
<td>Lutensol OP-10</td>
<td>BASF Chemical Co.</td>
<td>5.0</td>
<td>0.56</td>
</tr>
<tr>
<td></td>
<td>DI Water</td>
<td></td>
<td>84.8</td>
<td>10.18</td>
</tr>
<tr>
<td></td>
<td>Colloid 640 Defoamer</td>
<td>Rhodia</td>
<td>3.5</td>
<td>0.41</td>
</tr>
<tr>
<td></td>
<td>RO-4097 Kroma Red, Red Iron Oxide</td>
<td>Elementis Pigments Co.</td>
<td>104.4</td>
<td>2.45</td>
</tr>
<tr>
<td></td>
<td>Zeoespheres Type 600</td>
<td>3M Industries, Inc.</td>
<td>307.1</td>
<td>17.55</td>
</tr>
</tbody>
</table>

*Pebble mill approximately 18 hours*

|          | EPI-REZ Resin 5522-WY-55 | 187.2 | 20.92 |
|          | DI Water |  | 39.5 | 4.74 |
|          | Total Part A | 938.1 | 80.00 |

| Part B   | EPIKURE Curing Agent 8290-Y-60 | Hexion | 118.3 | 13.40 |
|          | DI Water |  | 55.0 | 6.60 |
|          | Total Part B | 173.3 | 20.00 |

|          | Total Part A & B | 1,111.4 | 100.00 |

**Mixing Instructions**

<table>
<thead>
<tr>
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<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>938.1</td>
<td>80.00</td>
</tr>
<tr>
<td>Part B</td>
<td>173.3</td>
<td>20.00</td>
</tr>
<tr>
<td>Part A + B</td>
<td>1,111.4</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>75.0</td>
</tr>
<tr>
<td>Part B</td>
<td>% solids</td>
<td>25.0</td>
</tr>
</tbody>
</table>

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Typical Formulation Properties

Table 1 / Formulation Properties

<table>
<thead>
<tr>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total weight solids</td>
<td>% 62.6</td>
</tr>
<tr>
<td>Total volume solids</td>
<td>% 49.2</td>
</tr>
<tr>
<td>Pigment volume concentration (PVC)</td>
<td>% 40.7</td>
</tr>
<tr>
<td>Volatile Organic Compound (VOC)</td>
<td>lb/gal 1.37, g/L 164</td>
</tr>
</tbody>
</table>

Reduction for Conventional Spray (by volume)

| Parts A and B | parts 36 |
| Water         | parts 1  |
| Induction Time | min. 30 |
| Viscosity @ 25°C |
| Part A        | KU 64   |
| Part B        | KU 58   |
| Part A + B    | KU 85   |

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

General Information

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Contact Information

For product prices, availability, or order placement, please contact customer service:

www.hexion.com/Contacts/

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