## Starting Formulation

**SF 1606**

**Gloss White Enamel**

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></td>
<td>EPI-REZ Resin 3520-WY-55</td>
<td>Hexion</td>
<td>411.6</td>
<td>45.03</td>
</tr>
<tr>
<td></td>
<td>Michemlube 182 Mar and Slip Agent</td>
<td>Michelman Chemicals, Inc.</td>
<td>27.8</td>
<td>3.33</td>
</tr>
<tr>
<td></td>
<td>Water</td>
<td></td>
<td>13.7</td>
<td>1.64</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td><strong>Total Part A</strong></td>
<td><strong>453.1</strong></td>
</tr>
<tr>
<td></td>
<td>EPIKURE Curing Agent 8537-WY-60</td>
<td>Hexion</td>
<td>160.0</td>
<td>17.70</td>
</tr>
<tr>
<td></td>
<td>Ektasolve DB Acetate</td>
<td>Eastman Chemical Products, Inc.</td>
<td>8.2</td>
<td>1.00</td>
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<tr>
<td></td>
<td>Triethylamine</td>
<td></td>
<td>3.7</td>
<td>0.61</td>
</tr>
<tr>
<td></td>
<td>Patcote 519 Defoamer</td>
<td>C.J. Patterson Co.</td>
<td>4.0</td>
<td>0.57</td>
</tr>
<tr>
<td></td>
<td>Kronos 2020 or Tronox CR-800</td>
<td>Kronos, Inc.</td>
<td>250.0</td>
<td>7.33</td>
</tr>
<tr>
<td></td>
<td></td>
<td>Kerr-McGee Chemical Co.</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

*High Speed disperse to a texture of 7-8 Hegman, then add*

|          | EPIKURE Curing Agent 8537-WY-60 | Hexion | 42.4   | 4.69   |
|          | Water                            |        | 150.0  | 18.10  |
|          | **Total Part B**                 |        | **619.1** | **50.00** |

**Total Part A & B** | **1,072.2** | **100.00** |

### Mixing Instructions

<table>
<thead>
<tr>
<th></th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>453.1</td>
<td>50.00</td>
</tr>
<tr>
<td>Part B</td>
<td>619.1</td>
<td>50.00</td>
</tr>
<tr>
<td>Part A + B</td>
<td>1,072.2</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>65.0</td>
</tr>
<tr>
<td>Part B</td>
<td>% solids</td>
<td>35.0</td>
</tr>
</tbody>
</table>

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Typical 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>1 : 1</td>
</tr>
<tr>
<td></td>
<td>By weight</td>
<td>1.0 : 1.37</td>
</tr>
<tr>
<td>Total weight solids</td>
<td>%</td>
<td>55.8</td>
</tr>
<tr>
<td>Total volume solids</td>
<td>%</td>
<td>42.3</td>
</tr>
<tr>
<td>Pigment volume concentration (PVC)</td>
<td>%</td>
<td>17.3</td>
</tr>
<tr>
<td>Volatile Organic Compound (VOC)</td>
<td>lb/gal</td>
<td>1.61</td>
</tr>
<tr>
<td></td>
<td>g/L</td>
<td>187</td>
</tr>
<tr>
<td>Viscosity @ 25°C</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Part A</td>
<td>KU</td>
<td>85</td>
</tr>
<tr>
<td>Part B</td>
<td>KU</td>
<td>110</td>
</tr>
<tr>
<td>Part A &amp; B</td>
<td>KU</td>
<td>99</td>
</tr>
</tbody>
</table>

Reduction for Spray Properties

<table>
<thead>
<tr>
<th>Properties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Parts A and B</td>
<td>Parts</td>
<td>17</td>
</tr>
<tr>
<td>Water</td>
<td>Parts</td>
<td>1</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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