**Starting Formulation**

**SF 1009**

**Gloss White Enamel**

**EPON™ Resin 828 / EPIKURE™ Curing Agent 3175**

<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>291.1</td>
<td>30.17</td>
</tr>
<tr>
<td></td>
<td>Ti-PURE® R960 HG</td>
<td>Du Pont Company</td>
<td>508.4</td>
<td>15.74</td>
</tr>
<tr>
<td></td>
<td>BENTONE® SD-2 Thixotrope</td>
<td>Elementis Specialties Inc.</td>
<td>7.0</td>
<td>0.52</td>
</tr>
<tr>
<td></td>
<td>BUSPERSE® 47, Dispersant/Viscosity Depressant</td>
<td>Buckman Laboratories</td>
<td>2.3</td>
<td>0.31</td>
</tr>
<tr>
<td></td>
<td>EASTMAN® EP, 2-Propoxylethanol</td>
<td>Eastman Chemical Products, Inc.</td>
<td>4.5</td>
<td>0.59</td>
</tr>
</tbody>
</table>

**High Speed Disperse to GrindHegman 7-8**

| Part A  | EASTMAN EP, 2-Propoxylethanol | Eastman Chemical Products, Inc. | 123.9  | 16.34   |
|         | BUSPERSE 47, Dispersant/Viscosity Depressant | Buckman Laboratories | 2.3    | 0.31    |
|         | Methyl propyl ketone | 74.1 | 11.02 |

**Total Part A**

|          | 1,013.6 | 75.00 |

| Part B  | EPIKURE Curing Agent 3175 | Hexion | 158.3  | 19.69   |
|         | EASTMAN EP, 2-Propoxylethanol | 40.0    | 5.31   |

**Total Part B**

|          | 198.5   | 25.00 |

**Total Part A & B**

|          | 1,212.1 | 100.00 |

**Mixing Instructions**

<table>
<thead>
<tr>
<th></th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>1,013.6</td>
<td>75.00</td>
</tr>
<tr>
<td>Part B</td>
<td>198.5</td>
<td>25.00</td>
</tr>
<tr>
<td>Part A + B</td>
<td>1,212.1</td>
<td>100.00</td>
</tr>
</tbody>
</table>

Disperse the pigments in a suitable portion of the vehicle using high speed dispersing equipment. Let down the pigment dispersion with the remaining vehicle. Charge the two ingredients of the curing agent component to a separate suitable container and mix thoroughly. Package the base component and the curing agent component separately to be combined just prior to use.
Typical Formulation

Table 1 / Formulation Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mix ratio Part A : Part B</td>
<td>By volume</td>
<td>3 : 1</td>
</tr>
<tr>
<td></td>
<td>By weight</td>
<td>5.11 : 1.0</td>
</tr>
<tr>
<td>Total weight solids</td>
<td>%</td>
<td>80.0</td>
</tr>
<tr>
<td>Total volume solids</td>
<td>%</td>
<td>66.7</td>
</tr>
<tr>
<td>Pigment volume concentration (PVC)</td>
<td>%</td>
<td>24.4</td>
</tr>
<tr>
<td>Volatile Organic Compound (VOC)</td>
<td>lb/gal</td>
<td>2.43</td>
</tr>
<tr>
<td></td>
<td>g/L</td>
<td>292</td>
</tr>
<tr>
<td>Induction Time</td>
<td>minutes</td>
<td>30</td>
</tr>
<tr>
<td>Potlife</td>
<td>hrs</td>
<td>6</td>
</tr>
<tr>
<td>Viscosity @ 25°C</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Part A</td>
<td>KU</td>
<td>64</td>
</tr>
<tr>
<td>Part B</td>
<td>KU</td>
<td>61</td>
</tr>
<tr>
<td>Part A &amp; B</td>
<td>KU</td>
<td>64</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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