**Starting Formulation**

**SF 2017**

**Gray Appliance Primer**

**EPON™ Resin 1007F / Beckamine 21-511**

- Good color and color retention
- Outstanding adhesion
- Excellent detergent resistance; will consistently pass 300 hours immersion in 1% detergent solution at 165 °F

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pigments</td>
<td>Ti-Pure R-902</td>
<td>Du Pont Co.</td>
<td>76.3</td>
<td>2.29</td>
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<tr>
<td></td>
<td>Superjet Carbon Black LB-1011</td>
<td>Harcros Pigments, Inc.</td>
<td>0.9</td>
<td>0.06</td>
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<tr>
<td></td>
<td>EPON Resin 1007F solution</td>
<td>Hexion</td>
<td>226.7</td>
<td>22.88</td>
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<tr>
<td></td>
<td>Ethyl-3-ethoxy propionate</td>
<td></td>
<td>92.75</td>
<td>11.58</td>
</tr>
<tr>
<td></td>
<td>Xylene</td>
<td></td>
<td>92.75</td>
<td>12.64</td>
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<td>Urea Resin and Solvents</td>
<td>Beckamine 21-511</td>
<td>Reichhold Chemicals, Inc.</td>
<td>161.9</td>
<td>18.96</td>
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<td>Ethyl 3-ethoxy propionate</td>
<td>Eastman Chemical</td>
<td>117.8</td>
<td>14.89</td>
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<td></td>
<td>Xylene</td>
<td>Shell Chemical Co.</td>
<td>121.1</td>
<td>16.70</td>
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<tr>
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<td>Total Formulation</td>
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<td>890.2</td>
<td>100.00</td>
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</table>

**Mixing Instructions**

Dissolve the EPON 1007F in the first portions of ethyl-3-ethoxy propionate and xylene. Disperse the pigments in the EPON 1007F solution on a three-roll mill or other suitable dispersing equipment. Let down the grind with the Beckamine 21-511 and the remaining solvents. **NOTE: POOR GLOSS MAY RESULT IF A PORTION OF THE EPON RESIN SOLUTION IS USED IN LETTING DOWN THE DISPERSION.**

**Typical Handling**

For spray application, reduce the formulation to a No. 4 Ford Cup viscosity of 20 seconds with ethyl 3-ethoxy propionate/toluene, 1/1 by weight.

This coating system should be baked for 20 minutes at 385 °F.
**Units** | **Value**
--- | ---
EPON Resin 1007F/Beckamine 21-511 ratio (solids) | 70/30
Nonvolatile content by weight | % 45.0
Weight per gallon | lb/gal 8.9
Pigment : Binder Weight Ratio | 0.24/1.0
**Pigment volume concentration (PVC)** | % 6.6
**Volatile Organic Compound (VOC)** | lb/gal 4.89 g/L 587

**General Information**

These are starting formulations and are not proven in the user’s particular application but are simply meant to demonstrate the efficacy of the products and to assist in the development of the user’s own formulation. It is the user’s responsibility to fully-test and qualify the formulation, along with the ingredients, methods, applications or equipment identified herein (“Information”), by the user’s knowledgeable formulator or scientist, and to determine the appropriate use conditions and legal restrictions, prior to use of any Information.

**Safety, Storage & Handling**

Please refer to the MSDS for the most current Safety and Handling information.

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**Contact Information**

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

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For literature and technical assistance, visit our website at [www.hexion.com](http://www.hexion.com)

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