### Starting Formulation

**SF 1607**

White Enamel  
**EPON™ Resin 828 / EPIKURE™ Curing Agent 8535-W-50**

<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>Rutile Titanium Dioxide</td>
<td>Hexion</td>
<td>250.0</td>
<td>7.34</td>
</tr>
<tr>
<td></td>
<td>EPON Resin 828</td>
<td>Hexion</td>
<td>130.0</td>
<td>13.50</td>
</tr>
<tr>
<td></td>
<td>EPIKURE™ Curing Agent 8535-W-50</td>
<td>Hexion</td>
<td>216.0</td>
<td>24.80</td>
</tr>
<tr>
<td></td>
<td>Glacial Acetic Acid</td>
<td></td>
<td>2.0</td>
<td>0.24</td>
</tr>
<tr>
<td></td>
<td>Water</td>
<td></td>
<td>374.0</td>
<td>44.96</td>
</tr>
</tbody>
</table>

**Mixing Instructions**

<table>
<thead>
<tr>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>465.6</td>
</tr>
<tr>
<td>Part B</td>
<td>592.0</td>
</tr>
<tr>
<td>Part A + B</td>
<td>1,057.6</td>
</tr>
</tbody>
</table>

### Resin Composition

<table>
<thead>
<tr>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A % solids</td>
<td>66.5</td>
</tr>
<tr>
<td>Part B % solids</td>
<td>33.5</td>
</tr>
<tr>
<td>Part A + B % solids</td>
<td>100.0</td>
</tr>
</tbody>
</table>

### Typical Formulation Table 1 / Formulation Properties - Room Temperature Cure (Brush or Spray)

<table>
<thead>
<tr>
<th>Properties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
</table>

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Mix ratio Part A : Part B

By volume 30 : 70

By weight 0.78 : 1.0

Weight per gallon

lb/gal 10.58

Total weight solids % 53.2

Total volume solids % 45.8

Pigment volume concentration (PVC) % 17.5

Volatile Organic Compound (VOC)

lb/gal 0.41
g/L 49.2

Viscosity @ 25°C

Part A & B - Fresh KU 75 - 85

Part A & B - 1 Hour KU off scale

Gloss (60° Angle)

Units 98

Pencil Hardness, 72 Hours cure B

Volatileis Composition

Water lbs 477.7

Organic lbs 17.3

Reduction for Spray Table 2 / Reduction for Conventional Spray (By Volume)

Properties

Units Value

Parts A and B Parts 17

Water Parts 1

Storage

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

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.

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

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