Starting Formulation
SF 1026
Zinc-Rich Primer
EPONOL™ Resin 53-BH-35

Features
- One-package fast drying shop primer
- No hard settling on storage
- Excellent corrosion resistance
- Recommended as a primer in the maintenance, automotive and marine fields

Formula Material Supplier Pounds Gallons

Solvents & Additives
Thixatrol™ ST Elementis Specialties, Inc. 10.5 1.20
Propylene glycol methyl ether acetate Eastman Chemical Products, Inc. 124.8 15.54

EPONOL Resin Solution
EPONOL Resin 53-BH-35 Hexion 314.1 40.27

Disperse above with high speed dispersing equipment. Disperse to a temperature of 130 °F to 140 °F and grind Hegman 5-6. Then add the following with good mixing.

Pigments
Zinc dust type 335 Meadowbrook Corp. 1,533.0 25.80
Syloid™ ZN-1 W. R. Grace & Co., Davison Chemical Division 21.0 1.19
Xylene Shell Chemical Co. 114.7 16.00
Total 2,118.1 100.00

Mixing Instructions

Part A

<table>
<thead>
<tr>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>2,118.1</td>
<td>100.00</td>
</tr>
</tbody>
</table>

Disperse the Thixatrol ST in the EPONOL Resin 53-BH-35 along with the solvents using high speed dispersing equipment. It should be noted that maximum thixotropy is developed at about 130 °F to 140 °F. The zinc dust and Syloid ZN-1 are then added with good agitation until they are thoroughly dispersed. Package immediately to minimize water pickup by this primer system.

Typical Handling
The primer may be thinned to application viscosity with a blend of propylene glycol methyl ether acetate/xylene, 60/40 by weight. The coating should be dry to handle in about 25 minutes.

CAUTION: The information provided is believed to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion’s terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion’s specifications. Nothing contained herein constitutes an offer for the sale of any product.

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DISCLAIMER
CAUTION: While the adhesion of epoxy two-package topcoats over EPONOL Resin zinc-rich primers is excellent, alkyds and epoxy ester topcoats should be avoided because poor adhesion has been observed in those types of topcoats over zinc-rich primers.

FDA Status  EPONOL Resin 53-BH-35 does not meet the requirements of the Food and Drug Administration and, therefore, cannot be recommended for food contact applications.

Typical Formulation  Table 1 / Formulation Properties

<table>
<thead>
<tr>
<th>Properties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Nonvolatile content by weight</td>
<td>%</td>
<td>79.2</td>
</tr>
<tr>
<td>Weight per gallon</td>
<td>lb/gal</td>
<td>21.2</td>
</tr>
<tr>
<td>Pigment : Binder Weight Ratio</td>
<td></td>
<td>93.7</td>
</tr>
<tr>
<td>Volatile Organic Compound (VOC)</td>
<td>lb/gal</td>
<td>4.41</td>
</tr>
<tr>
<td></td>
<td>g/L</td>
<td>529</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).

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.

Exposure to these materials should be minimized and avoided, if feasible, through the observance of proper precautions, use of appropriate engineering controls and proper personal protective clothing and equipment, and adherence to proper handling procedures. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheet (MSDS) for these and all other products being used are understood by all persons who will work with them. Questions and requests for information on Hexion Inc. ("Hexion") products should be directed to your Hexion sales representative, or the nearest Hexion sales office. Information and MSDSs on non-Hexion products should be obtained from the respective manufacturer.

Contact Information

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


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

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