Starting Formulation

SF 1812

Low Sheen Gray Primer

EPI-REZ™ Resin 5522-WY-55 / EPIKURE™ Curing Agent 8290-Y-60

<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>EPI-REZ Resin 5522-WY-55</td>
<td>Hexion</td>
<td>522.1</td>
<td>58.34</td>
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<tr>
<td></td>
<td>DI Water</td>
<td></td>
<td>69.4</td>
<td>8.33</td>
</tr>
<tr>
<td></td>
<td>Total Part A</td>
<td></td>
<td>591.5</td>
<td>66.67</td>
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<tr>
<td>Part B</td>
<td>EPIKURE Curing Agent 8290-Y-60</td>
<td>Hexion</td>
<td>82.1</td>
<td>9.30</td>
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<tr>
<td></td>
<td>Kronos 2020</td>
<td>Kronos, Inc.</td>
<td>191.0</td>
<td>5.58</td>
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<td></td>
<td>SP Black 4 Powder</td>
<td>Degussa, Inc.</td>
<td>.3</td>
<td>.02</td>
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<td></td>
<td>Patcote 847 Defoamer</td>
<td>Hydrite Chemical Co.</td>
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<td>.28</td>
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<tr>
<td></td>
<td>DI Water</td>
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<td>25.0</td>
<td>3.00</td>
</tr>
<tr>
<td></td>
<td>Total Part B</td>
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<td>426.6</td>
<td>33.33</td>
</tr>
<tr>
<td></td>
<td>Total Part A &amp; B</td>
<td></td>
<td>1,018.1</td>
<td>100.00</td>
</tr>
</tbody>
</table>

High Speed Disperse to 7-8 Hegman, reduce speed and add

DI Water 126.2 15.15

Resin Composition

<table>
<thead>
<tr>
<th></th>
<th>Units</th>
<th>Value</th>
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</thead>
<tbody>
<tr>
<td>Part A</td>
<td>% solids</td>
<td>85.0</td>
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<tr>
<td>Part B</td>
<td>% solids</td>
<td>15.0</td>
</tr>
<tr>
<td>Part A + B</td>
<td>% solids</td>
<td>100.0</td>
</tr>
</tbody>
</table>

Mixing Instructions

<table>
<thead>
<tr>
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<th>Gallons</th>
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<tr>
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<td>426.6</td>
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<tr>
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<td>1,018.1</td>
<td>100.00</td>
</tr>
</tbody>
</table>

Typical Formulation Table 1 / Formulation Properties

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### Mix Ratio, Part A: Part B
- **Units**: By volume
- **Value**: 2 : 1

### Total Weight Solids
- **Units**: %
- **Value**: 51.1

### Total Volume Solids
- **Units**: %
- **Value**: 39.5

### Pigment Volume Concentration (PVC)
- **Units**: %
- **Value**: 14.2

### Volatile Organic Compound (VOC)
- **Units**: lb/gal
- **Value**: 1.51
- **Units**: g/L
- **Value**: 181

### Induction Time
- **Units**: min.
- **Value**: 30

### Viscosity @ 25°C
- **Units**: KU
- **Value**: 48
- **Units**: KU
- **Value**: 76
- **Units**: KU
- **Value**: 62

### Reduction for Conventional Spray (by volume to 55 K.U.)
- **Parts A and B**: parts
- **Value**: 11
- **Water**: parts
- **Value**: 1

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**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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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)