

Starting Formulation

SF 1004

Clear Coating

EPON™ Resin 8521-MX-60 / EPIKURE™ Curing Agent 3213

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPON Resin 8521-MX-60	Westlake Epoxy	524.0	60.00
	Diacetone Alcohol	Shell Chemical Company	39.2	5.00
	2-Propoxyethanol		37.9	5.00
	Xylene		<u>71.9</u>	<u>10.00</u>
	Total Part A		673.0	80.00
Part B				
	EPIKURE Curing Agent 3213	Westlake Epoxy	73.8	9.00
	2-Propoxyethanol		30.3	4.00
	Methyl Isobutyl Ketone	Shell Chemical Company	26.7	4.00
	Xylene	Shell Chemical Company	<u>21.6</u>	<u>3.00</u>
	Total Part B		152.4	20.00
	Total Part A & B		825.4	100.00

Mixing Instructions

	Pounds	Gallons
Part A	673.0	80.00
Part B	<u>152.4</u>	<u>20.00</u>
Part A + B	825.4	100.00

Typical Formulation Table 1 / Formulation Properties Properties

	Units	Value
Mix Ratio, Part A : Part B	by volume	4 : 1
	by weight	4.42:1.0
Weight per gallon	pounds	8.34
Total weight solids	%	41.8
Total volume solids	%	33.9

Generated: March 28, 2024
Issue Date:
Revision:

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Volatile Organic Compound (VOC)	lb/gal	4.80
	g/L	576
Viscosity @ 25°C		
Part A	KU	68
Part B	cP	15
Part A & Part B	KU	59

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at www.westlakeepoxy.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 Westlake Epoxy products should be directed to your Westlake Epoxy sales representative, or the nearest Westlake Epoxy sales office. Information and MSDSs on non-Westlake Epoxy products should be obtained from the respective manufacturer.

Contact Information

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

www.westlakeepoxy.com/Contacts/

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

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