

## Starting Formulation

SF 1607

White Enamel

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

Formula	Material	Supplier	Pounds	Gallons
Part A				
	Rutile Titanium Dioxide		250.0	7.34
	EPON Resin 828	Westlake Epoxy	130.0	13.50
High speed disperse to texture of 7-8 Hegman reduce speed and add				
	EPON Resin 828	Westlake Epoxy	32.1	3.34
	HELOXY™ Modifier 8	Westlake Epoxy	<u>53.5</u>	<u>5.82</u>
	Total Part A		465.6	30.00
Part B				
	EPIKURE Curing Agent 8535-W-50	Westlake Epoxy	216.0	24.80
	Glacial Acetic Acid		2.0	0.24
	Water		<u>374.0</u>	<u>44.96</u>
	Total Part B		592.0	70.00
	Total Part A & B		1,057.6	100.00

### Mixing Instructions

	Pounds	Gallons
Part A	465.6	30.00
Part B	<u>592.0</u>	<u>70.00</u>
Part A + B	1,057.6	100.00

### Resin Composition

	Units	Value
Part A	% solids	66.5
Part B	% solids	33.5
Part A + B	% solids	100.0

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

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	<u>Units</u>	<u>Value</u>
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
Volatiles Composition		
Water	lbs	477.7
Organic	lbs	17.3

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

	<u>Units</u>	<u>Value</u>
Parts A and B	Parts	17
Water	Parts	1

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at [www.westlakeepoxy.com](http://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/](http://www.westlakeepoxy.com/Contacts/)

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

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