

Starting Formulation

SF 2508

Red Bake Coating

EPI-REZ™ Resin 3540-WY-55

Formula	Material	Supplier	Pounds	Gallons
	Forumulation			
	Benzyl Alcohol		8.0	0.92
	Triton X-100 Surfactant	Union Carbide Corp.	3.0	0.33
	Tamol 731 Surfactant	Rohm & Haas Co.	3.0	0.32
	Water		50.0	6.00
	Q-148 Defoamer	Troy Chemical Co.	5.0	0.60
	RO-4097 Synthetic Red Oxide	Harcros Pigments, Inc.	50.0	1.23
	Nytal 300 Silicate	R.T Vanderbilt Co.	11.0	0.46
	S. F. Magnesium Silicate #399	Whitaker, Clarke, Daniels	8.0	0.34
	X10R Barytes Barium Sulfate	Harcros Pigments, Inc.	64.0	1.75
	Celite 499 Silica	Johns-Manville Products Corp.	8.0	0.42
<i>High speed disperse to 6 + PC and add:</i>				
	EPI-REZ Resin 3540-WY-55	Westlake Epoxy	499.4	54.64
	Water		108.5	13.02
<i>Premix and add:</i>				
	Beetle 80	American Cyanamid Company	68.7	7.59
	Nacure XP333	King Industries	48.1	6.54
	n-Butyl Alcohol	Shell Chemical Company	<u>39.4</u>	<u>5.84</u>
	Total Forumulation		974.1	100.00

Mixing Instructions	Pounds	Gallons
Total Formulation	974.1	100.00

Typical Formulation Table 1 / Formulation Properties Properties

	Units	Value
Total Weight Solids	%	50.9
Total Volume Solids	%	40.8
Pounds/Gallon	lbs/gal	9.74

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PVC	%	10.32
Epoxy/Urea Catalyst (Active on resin solids)	%	80/20
Volatile Organic Compounds (VOC)	lbs/gal	2.12
	g/L	254
Viscosity, #4 Ford Cup	sec.	60-80
pH		2

Reduction for conventional spray application: 20 parts Starting Formulation No. 2508 1 part water

Typical Film Properties Table 2 / Film Performance Properties ¹

	<u>Units</u>	<u>Q-Panel</u>	<u>Bonderite 40</u>	<u>Bonderite 1000</u>
Dry Film Thickness	mils	0.4	0.4	0.4
Reverse Impact	in.-lbs	40	20	>160
MEK Resistance Double Rubs		100	100	100
Pencil Hardness		5H	5H	5H

¹ Baked 10 minutes at 400 °F

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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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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