



# FORMULATION

## Chromate Free 2K Epoxy Phenolic Etch Primer using HALOX® 430 JM and HALOX® 550

GRIND		LBS.	GALS.	FORMULA CONSTANTS
<b>Component A</b>				
<i>Pre-mix the following before adding.</i>				Density (lb/gal) 8.95
Mowital B 30 HH	[1]	65.67	7.15	Density (g/L) 1072.15
Isopropanol		131.35	20.02	Weight Pigment (%) 21.47
Xylene		98.51	13.59	Volume Pigment (%) 7.43
PM Solvent		32.84	4.28	Weight Solids (%) 41.03
<i>Mix well; then add:</i>				Volume Solids (%) 25.30
Phenodur PR 263 (70%)	[2]	82.09	9.28	PVC (%) 30.19
<i>Pre-mix the next 2 ingredients before adding.</i>				VOC (lb/gal) 5.22
Beckopox EP 301	[2]	55.00	6.16	VOC (g/L) 625.10
PM Solvent		27.10	3.53	
<i>Mix well; then add:</i>				
Bayferrox 120M	[3]	45.61	1.09	
HALOX® 430 JM	[6]	44.38	1.97	
Talcron 15-38	[4]	102.03	4.37	
<i>High speed disperse to 6+ NS Hegman grind.</i>				
<b>LETDOWN</b>				
<i>Pre-mix the following, then add to above under agitation.</i>				
Xylene		31.01	4.28	
Aerosil R972	[5]	3.65	0.20	
Additol XL 270	[2]	1.82	0.24	
Xylene		46.52	6.42	
Isopropanol		45.15	6.88	
HALOX® 550	[6]	9.00	1.09	
PM Solvent		45.15	5.89	
<b>Component B</b>				
Phosphoric Acid (85%)		6.84	0.48	
n-Butyl Alcohol		20.53	3.03	
<b>TOTAL</b>		<b>894.25</b>	<b>99.96</b>	

### FORMULA PROPERTIES

KU Viscosity @ 25°C 70-75

### SUPPLIER KEY

- [1] Kuraray Company, Ltd.
- [2] Allnex
- [3] Bayer Corporation
- [4] Barretts Minerals, Inc.
- [5] Evonik
- [6] HALOX®

NOTICE: Although the information and recommendations set forth herein (hereinafter "Information") are presented in good faith and believed to be correct as of the date hereof, ICL Performance Products LP ("ICL") makes no representations or warranties as to the completeness or accuracy thereof. Information is supplied upon the condition that the persons receiving same will make their own determination as to its suitability for their purposes prior to use. In no event will ICL be responsible for damages of any nature whatsoever resulting from the use or reliance upon Information or the product to which Information refers. Nothing contained herein is to be construed as a recommendation to use any product, process, equipment or formulation in conflict with any patent, and ICL makes no representation or warranty, express or implied, that the use thereof will not infringe any patent. NO REPRESENTATIONS OR WARRANTIES, EITHER EXPRESSED OR IMPLIED, OF MERCHANTABILITY, FITNESS FOR A PARTICULAR PURPOSE OR OF ANY OTHER NATURE ARE MADE HEREUNDER WITH RESPECT TO INFORMATION OR THE PRODUCT TO WHICH INFORMATION REFERS.

© 2013 HALOX® a Division of ICL Performance Products LP. All Rights Reserved.

**WE MAKE COATINGS BETTER.**

1326 Summer Street, Hammond, Indiana 46319 USA  
P: 219.933.1560 E: techservice@halox.com  
www.halox.com

**MOB30HH/430JM&550**

**2008-05-29**

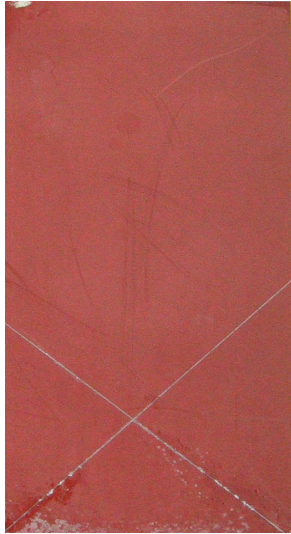


# Chromate Replacement in 2K Epoxy Phenolic Etch Primer

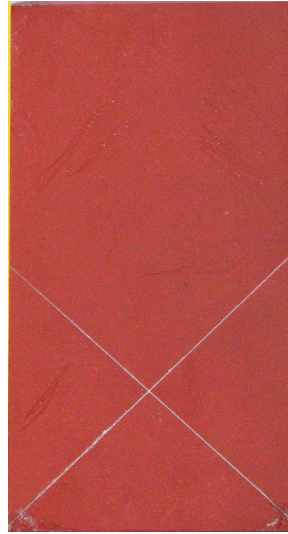
336 Hours - Salt Spray

Substrate: Hot Dipped Galvanized (G70)

16 Microns - % on total formula weight



7% Zinc Chromate

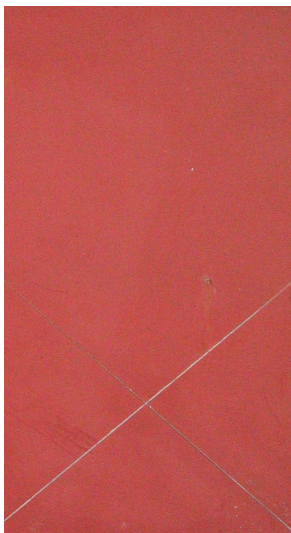


4% HALOX® 430JM/1% HALOX® 550

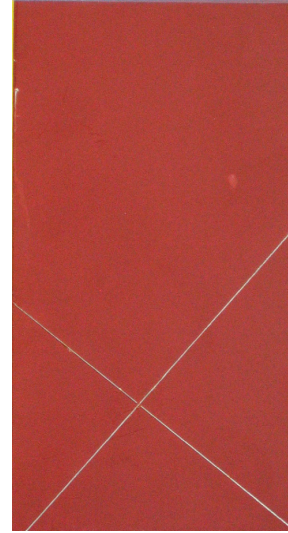
336 Hours - Salt Spray

Substrate: Aluminum 3003

24 Microns - % on total formula weight



7% Zinc Chromate



4% HALOX® 430JM/1% HALOX® 550