



FORMULATION

High Gloss D.T.M. Water-Based Acrylic using HALOX® 550

GRIND

		<u>LBS.</u>	<u>GALS.</u>
Water		64.71	7.75
Tamol 681	[1]	6.38	0.71
Surfynol 104A	[2]	1.96	0.27
Drewplus L-405	[3]	0.98	0.12
Acrynol RM-825	[1]	0.98	0.11
Ti-Pure R-706	[4]	185.87	5.57
HALOX® 550	[6]	19.62	2.37

High speed disperse to 5+ NS Hegman grind.

LETDOWN

EPS 2504	[5]	563.19	64.89
Water		71.76	8.60
Ammonia Hydroxide (28%)		1.96	0.26
Texanol		69.93	8.82
HALOX® FLASH-X 150	[6]	4.90	0.53

FORMULA CONSTANTS

Density lbs./gal.	9.92
Density g/l	1189.09
% Pigment/Wt.	18.73
% Pigment/Vol.	5.57
% Solids/Wt.	44.69
% Solids/Vol.	33.71
% PVC	16.70
VOC lbs./gal.	1.77
VOC g/l	211.79

FORMULA PROPERTIES

pH @ R.T.	8.5-9.0 pH
KU Visc. @ 25 °C	85-90
ICI	0.20-0.30
Gloss @ 60°	75-80

SUPPLIER KEY

- [1] The Dow Chemical Company
- [2] Air Products
- [3] Ashland Chemical Company
- [4] DuPont Chemicals
- [5] Engineered Polymer Solutions, Inc.
- [6] HALOX®

TOTAL

992.23

100.00

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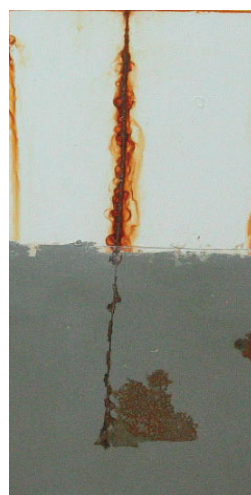
Substrate: Cold Rolled Steel - 50 microns D.F.T.
168 Hours - Salt Spray



Control - Blank



HALOX® 550
2%



Modified Zinc Phosphate
1%



Modified Zinc Phosphate
5%

Gloss at 60

