Low VOC Vinyl Acrylic Dip Primer using
HALOX 550 WF Liquid Corrosion Inhibitor

Disperse bentone in water at mod agitation; adjust to pH 8.5

<table>
<thead>
<tr>
<th>% Wt</th>
<th>Class</th>
</tr>
</thead>
<tbody>
<tr>
<td>Water</td>
<td>12.84</td>
</tr>
<tr>
<td>Bentone LT</td>
<td>[1] 0.13 Thickener</td>
</tr>
</tbody>
</table>

Premix the next 2 ingredients before adding.

Premix Haloflex 202 and ammonia to pH 4 before adding to base

<table>
<thead>
<tr>
<th>% Wt</th>
<th>Class</th>
</tr>
</thead>
<tbody>
<tr>
<td>Haloflex 202</td>
<td>48.98 Resin</td>
</tr>
<tr>
<td>Ammonia Hydroxide (28%)</td>
<td>0.27 Amine</td>
</tr>
</tbody>
</table>

Add the following in order at low shear

Premix the next 2 ingredients before adding.

<table>
<thead>
<tr>
<th>% Wt</th>
<th>Class</th>
</tr>
</thead>
<tbody>
<tr>
<td>Monolite Black XBE-HD Paste</td>
<td>0.90 Pigment</td>
</tr>
<tr>
<td>HALOX FLASH-X 150</td>
<td>0.85 Flash Rust Inhibitor</td>
</tr>
<tr>
<td>Butyl Cellosolve</td>
<td>1.51 Solvent</td>
</tr>
</tbody>
</table>

TOTAL 100.00

Formulation Constants

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Density (g/L)</td>
<td>1346.93</td>
</tr>
<tr>
<td>Weight Pigment (%)</td>
<td>21.88</td>
</tr>
<tr>
<td>Volume Pigment (%)</td>
<td>10.53</td>
</tr>
<tr>
<td>Weight Solids (%)</td>
<td>55.85</td>
</tr>
<tr>
<td>Volume Solids (%)</td>
<td>40.74</td>
</tr>
<tr>
<td>PVC (%)</td>
<td>29.66</td>
</tr>
<tr>
<td>VOC (g/L)</td>
<td>66.37</td>
</tr>
</tbody>
</table>

Formula Properties

<table>
<thead>
<tr>
<th>Property</th>
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</tr>
</thead>
<tbody>
<tr>
<td>pH @ 25°C</td>
<td>5.0 - 6.0</td>
</tr>
<tr>
<td>Viscosity - Stormer KU</td>
<td>65 - 70</td>
</tr>
</tbody>
</table>

Supplier Key

[2] BASF Corporation
[3] Cognis Corporation
[4] Air Products
[5] HALOX
[6] Luzenac America, Inc.
[7] Avecia Neo-Resins
[8] The Dow Chemical Company

The information contained herein is correct to the best of our knowledge, but is intended only as a source of information. The recommendations or suggestions herein are made without guarantee of representation as to results, and we suggest that you evaluate the recommendations contained in this formulation in your own laboratory prior to use.

H202/Dip/550WF

HALOX® 1326 Summer St., Hammond, IN 46320, USA tel: 219.933.1560, www.halox.com

2009-02-11
Salt Spray – Cold Roll Steel – 544 hrs – 2.5 mils (62 µm)