Formulation

Water Base Acrylic Gloss DTM using HALOX 515

		LBS	GALS
GRIND			
Water		60.00	7.19
Tamol 681	[1]	9.00	1.00
Drewplus T-4310	[2]	1.00	0.13
Triton CF-10	[3]	2.00	0.22
Ammonia Hydroxide (28%)		1.00	0.13
Ti-Pure R-706	[4]	205.00	6.14
High speed disperse to 7+ NS Hegman grind.			
LETDOWN			
Maincote HG-86	[1]	577.00	67.25
Water		36.00	4.31
Ammonia Hydroxide (14%)		2.00	0.27
Add grind portion under agitation and mix until uniform.			
Texanol	[5]	37.70	4.75
Propylene Glycol	[3]	10.00	1.15
Methanol	[6]	35.00	5.28
HALOX 515	[7]	20.10	2.27
Ammonia Hydroxide (14%)		1.30	0.17
Adjust pH to 9.5 with ammonia.			
Water		6.00	0.72
Acrysol RM-8W	[1]	1.00	0.12
Acrysol RM-12W	[1]	2.00	0.23
TOTAL		1,006.10	101.34

Formula Constants

Density (lb/gal)	9.93
Density (g/L)	1189.73
Weight Pigment (%)	20.38
Volume Pigment (%)	6.06
Weight Solids (%)	46.28
Volume Solids (%)	34.82
PVC (%)	17.89
VOC (lb/gal)	1.86
VOC (g/L)	222.38

Formula Properties

pH @ 25°C	9.0 - 9.5
Viscosity - Stormer (KU) @ 25°C	80 - 90
Viscosity - ICI (Poise) @ 25°C	0.2 - 0.5
Gloss @ 60°	78 - 82

Supplier Key

[1] Rohm and Haas
[2] Ashland Nederlands bv, Drew Ameroid GmbH
[3] The Dow Chemical Company
[4] DuPont Chemicals
[5] Eastman Chemical Company
[6] Ashland Chemical Company
[7] HALOX

HG86/515

Water Base Acrylic Gloss DTM using HALOX 515

336 Hours Salt Spray - Cold Rolled Steel - 2.0 mils (50 microns)

Blank

2% HALOX 515