



Formulation

Chromate Free 2K Epoxy Phenolic Etch Primer using HALOX 650

COMPONENT A:

<u>GRIND</u>		<u>LBS.</u>	<u>GALS.</u>	<u>%Wt/Wt.</u>
<i>Premix the following 4 ingredients and mix until uniform.</i>				
Mowital B 30 HH	[1]	66.10	7.20	7.20
Isopropanol		132.19	20.15	14.40
Xylene		99.14	13.65	10.80
Eastman PM Solvent	[2]	33.05	4.31	3.60
Phenodur PR 263 (70%)	[3]	91.80	10.38	10.00
<i>Premix the following 2 ingredients and mix until uniform.</i>				
Beckopox EP 301	[3]	61.23	6.86	6.67
Eastman PM Solvent	[2]	30.57	3.99	3.33
Bayferrox 120M	[4]	119.34	2.86	13.00
Nyral 400	[5]	82.62	3.47	9.00
HALOX 650		3.86	0.30	0.42

High speed disperse to 6+ NS Hegman grind.

LETDOWN

<i>Premix the following 3 ingredients before adding.</i>				
Xylene		27.54	3.79	3.00
Aerosil R972	[6]	6.15	0.34	0.67
Additol XL 270	[3]	3.03	0.40	0.33
<i>Premix the following 3 ingredients before adding.</i>				
Xylene		44.61	6.14	4.86
Isopropanol		44.61	6.80	4.86
Eastman PM Solvent	[2]	44.61	5.82	4.86

COMPONENT B:

Phosphoric Acid (85%)		6.88	0.49	0.75
n-Butyl Alcohol		20.65	3.05	2.25
TOTAL		<u>917.98</u>	<u>100.00</u>	<u>100.00</u>

FORMULA CONSTANTS

% Pigment/Wt.	22.42
% Pigment/Vol.	6.64
% Solids/Wt.	43.11
% Solids/Vol.	25.93
% PVC	26.52
VOC lbs./gal.	5.22
VOC g/L	625.41

FORMULA PROPERTIES

Density	9.18 lbs./gal.
Density	1100.13 g/L
Stormer Viscosity @ 25°C	70-75 KU
Application	Spray
Induction Time	20 minutes
Pot Life	8+ hours

SUPPLIER KEY

- [1] Kurary Company, Ltd.
- [2] Eastman Chemical Company
- [3] UCB Surface Specialties
- [4] Bayer Corporation
- [5] R.T. Vanderbilt Company, Inc.
- [6] Degussa Corporation

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. Data and results supplied in-part by Ciba Specialty Chemicals and based on controlled or laboratory work.

MOB30HH/650

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