



Formulation

PARALOID™ Edge 1100 Automotive Refinish Primer Surfacers*

Material Name	Pounds	Gallons	Level (wt %)
PART A			
GRIND			
PARALOID™ Edge 1100 resin (56.7 wt % in xylene; EW = 589)	303.4	36.72	34.4
BYK Disperbyk 110 dispersant	8.4	1.13	0.9
Tiona 695 titanium dioxide	37.0	1.11	4.2
Nicron 665 talc	37.0	1.58	4.2
Grace CS311 ion exchanged silica	60.0	4.00	6.8
Halox 650 organic diacid	13.1	1.02	1.5
Bartyes Mitiwite B1 barium sulfate	42.3	1.18	4.8
GRIND SUB-TOTAL	501.1	46.73	
<i>Grind to Hegman 6+</i>			
LETDOWN			
Xylene	17.8	2.49	2.0
Toluene	135.3	18.85	15.3
Methyl ethyl ketone	65.8	9.74	7.5
Diacetone alcohol	17.5	2.24	2.0
PART A TOTAL	737.5	80.03	
PART B			
Ethanol	87.9	13.34	10.0
PARALOID™ Edge XL-195 (95 wt %; EW = 74)	38.1	4.43	4.3
<i>Add ethanol to XL-195 (there will be up to a ~15°C exotherm), mix for 20 min before adding the XC-315</i>			
King Catalyst XC-315	18.4	2.20	2.1
PART B TOTAL	144.4	19.97	
TOTALS	881.9	100.00	

*Note: Formulation should be applied on cold rolled steel (sanded with 80 grit sand paper). For optimal corrosion protection, it is recommended that this formulation is applied over a commercial etch primer.

Formulation Constants

Total PVC (%)	24.8
Volume Solids (%)	46.7
Weight Solids (%0	35.7
VOC (g/L)**	565

**Manufacturer may need to check against local regulations to ensure VOC compliance

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