



Formulation

High Performance Bare Metal Primer using HALOX 430

<u>GRIND</u>		<u>LBS.</u>	<u>GALS.</u>	<u>% Wt/Wt.</u>
Water		94.33	11.30	9.20
Butyl Cellosolve Solvent	[1]	35.89	4.77	3.50
Tamol 681	[2]	10.25	1.14	1.00
Troysol LAC	[3]	2.05	0.23	0.20
AMP-95	[4]	3.08	0.39	0.30
Drewplus L-493	[5]	1.03	0.14	0.10

Add the following at high speed and disperse to a 5+ NS Hegman grind.

Y.I.O. YO-2087	[6]	51.27	1.52	5.00
HALOX 430		51.27	2.35	5.00
Nyral 400	[7]	128.16	5.39	12.50

LETDOWN

Water		114.83	13.76	11.20
Maincote PR-71	[2]	481.89	52.49	47.00
Dibutyl Phthalate	[8]	7.18	0.82	0.70
Ammonia (28%)		3.08	0.41	0.30

Add grind portion under agitation and mix until uniform.
Then add the following in the order listed.

Ethanol (95%)	[8]	18.46	2.73	1.80
HALOX FLASH-X 150		5.13	0.55	0.50

Add slowly while mixing at high speed. DO NOT AERATE!

Acrysol RM 8W	[2]	12.30	1.42	1.20
Acrysol RM-1020	[2]	5.13	0.59	0.50

Mix until uniform.

TOTAL		1025.33	100.00	100.00
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FORMULA CONSTANTS

% Pigment/Wt.	22.50
% Pigment/Vol.	9.26
% Solids/Wt.	47.13
% Solids/Vol.	34.03
% PVC	27.91
VOC lbs./gal.	1.60
VOC g/L	191.50

FORMULA PROPERTIES

Density	10.25 lbs./gal.
Density	1228.72 g/L
pH @ 25°C	9.0-9.5
Stormer Viscosity @ 25°C	90-95 KU
ICI Viscosity @ 25°C	0.80-1.00 poise

(Should not exceed a 20 KU increase after
30 days in the oven at 55°C)

SUPPLIER KEY

- [1] The Dow Chemical Company
- [2] Rohm and Haas Company
- [3] Troy Corporation
- [4] ANGUS Chemical Company
- [5] Ashland Chemical Co., Drew Industrial Div.
- [6] Elementis Pigments Inc.
- [7] R.T. Vanderbilt Company, Inc.
- [8] Eastman 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.