

**Starting Point  
Formulation**

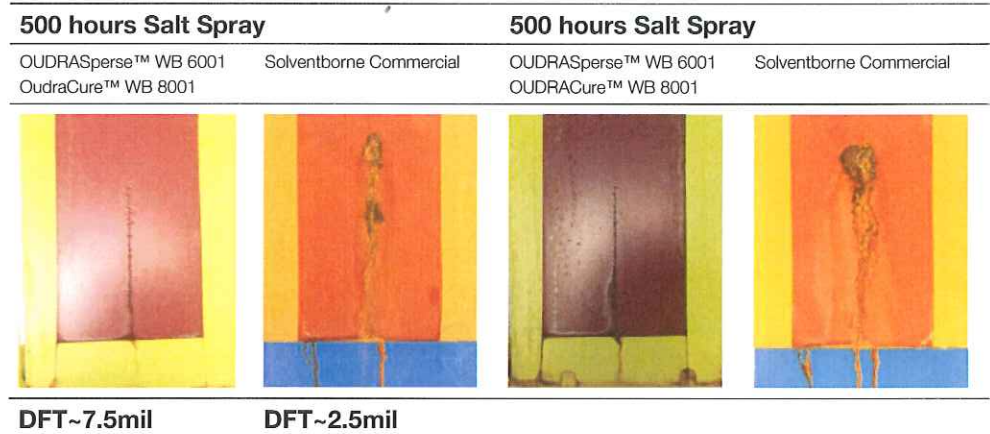
**Anticorrosive Primer for Metal Protection (<50 g/L)  
WBED-6001-01**

<b>Ingredients</b>	<b>kg</b>	<b>L</b>
<b>Part A</b>		
<i>On high-speed mixer, disperse following in order</i>		
Water	26.5	26.49
Sodium Nitrite (15%)	4.0	3.70
Byk-019	0.9	0.90
Tego Airex 902W	1.3	1.32
Disperbyk 194	5.3	1.31
Red iron oxide	25.8	5.07
Blanc Fixe N	30.1	7.34
Wollastocoat 10 ES	43.0	14.83
Halox SW-111	33.7	11.81
Mica 325	3.5	1.28
<i>Reduce mixing speed and add</i>		
OUDRASperse™ WB 6001 Epoxy Dispersion	234.4	217.16
PRIMAL™ RM-8W Rheology Modifier*	0.9	0.87
Water	1.1	1.13
Spheriglass 5000	25.8	10.33
DOW CORNING™ Z-6040 Silane	2.5	9.00
<b>Part A subtotal</b>	<b>439.3</b>	<b>309.60</b>
<b>Part B</b>		
OUDRACure™ WB 8001 Curing Agent	50.8	47.62
Water	14.1	14.19
DOWANOL™ PM Glycol Ether	4.5	4.95
DOWANOL PPh	2.2	2.11
Part B Subtotal	71.8	68.93
<b>Totals</b>	<b>511.1</b>	<b>378.54</b>
PVC	30.5%	
Volume Solids	43.8%	
Weight Solids	58.2%	
Density (lb/gal)	11.3	
VOC (g/L)	40	
Stoichiometry (epoxy: amine)	1.33: 1.0	

\*PRIMAL RM- 8W is known as ACRYSQL RM-8W in North America

\*\*PRIMAL RM-2020 is known as ACRYSQL RM-2020 in North America

Comparison of Red Oxide Primer Formulation to a Commercial SB Primer. Coatings applied over blasted hot-rolled steel and cured for 7 days at 77 F and 50% RH.



Typical Primer Coating Performance (2-2.5 mils cured 7 days at 77 F, 50% RH)		
Property Class	Performance Property	WBED-6001 -01
Pot Life	Pot Life (hours)	1.5
	Delta KU (2.25 hours)	15
Cure Time (hrs)	Tack Free	3.1
	Dry Through	7.5
Gloss	20 Deg	21
	60 Deg	65
	85 Deg	81
Hardness	Konig 1 Day/1 Week/2 Week (sec)	39/64/79
	Pencil 1 Day/1 Week/2 Week	F/3H/3H
Flexibility	Direct Impact (in-lbs)	20
	Reverse Impact (in-lbs)	<4
	Mandrel Bend (inches)	0.25
Adhesion	Cold Rolled Steel (Dry/Wet)	5B/5B
	Treated Aluminum (Dry/Wet)	5B/5B