



# FORMULATION

## Water Based Acrylic for Weld Seam Flash Rusting using HALOX® SZP-391 JM and HALOX® 570 LS

| <u>Grind</u>      |     | <u>% Wt./Wt.</u> | <u>Class</u>        |
|-------------------|-----|------------------|---------------------|
| Water             |     | 5.15             |                     |
| Bentone LT        | [1] | 0.10             | Thickener           |
| Disperbyk 190     | [2] | 5.32             | Dispersant          |
| Byk 22            | [2] | 1.15             | Defoamer            |
| Ti02 R-900        | [3] | 10.19            | Pigment             |
| Hubercarb G3      | [4] | 10.19            | Pigment             |
| HALOX® SZP-391 JM | [5] | 5.00             | Corrosion Inhibitor |

High Speed Disperse to a 5.0+ N.S.

| <u>Letdown</u> |     |       |       |
|----------------|-----|-------|-------|
| NeoCryl A-6099 | [6] | 50.58 | Resin |

Premix the next three items; then add slowly under agitation.

|                 |     |      |            |
|-----------------|-----|------|------------|
| Benzoflex 9-88  | [7] | 2.80 | Surfactant |
| Water           |     | 1.08 |            |
| Butylcellosolve | [8] | 4.99 | Coalescent |

Mix for 5 min.; then add:

|               |     |      |           |
|---------------|-----|------|-----------|
| HALOX® 570 LS | [5] | 3.00 | Inhibitor |
| Water         |     | 0.23 |           |
| Acrysol RM 8W | [8] | 0.23 | Thickener |

|              |  |               |  |
|--------------|--|---------------|--|
| <b>TOTAL</b> |  | <b>100.00</b> |  |
|--------------|--|---------------|--|

### FORMULA CONSTANTS

|               |        |
|---------------|--------|
| % Solids/Wt.  | 49.89  |
| % Solids/Vol. | 37.26  |
| VOC g/l       | 136.99 |

### FORMULA PROPERTIES

|                   |       |
|-------------------|-------|
| Density lbs./gal. | 10.45 |
| KU Visc. @ R.T.   | 85-95 |

### SUPPLIER KEY

- [1] Elementis Specialties
- [2] BYK
- [3] Dupont
- [4] Huber Engineered Materials
- [5] ICL\ Advanced Additives
- [6] DSM
- [7] Eastman
- [8] Dow Chemical

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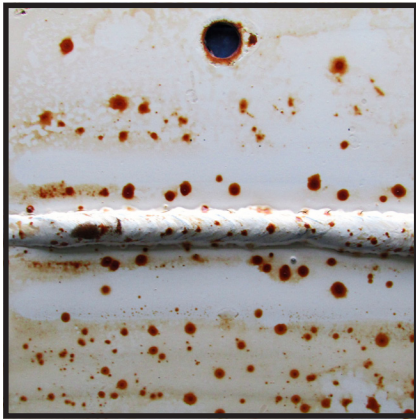


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**Weld Seam Flash Rusting  
Water Based Styrene Acrylic DTM  
2 HRS. @ 90-95% Relative Humidity @ 90°F (32°C)**



**No Inhibitor**



**Sodium Nitrite**



**3% HALOX® 570 LS**

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