



# Formulation

## Chromate Free 2K Epoxy Phenolic Etch Primer using HALOX CW-491

### COMPONENT A:

<u>GRIND</u>		<u>LBS./100 GALS.</u>	<u>GRAMS/LITER</u>
<i>Premix the following 4 ingredients and mix until uniform.</i>			
Mowital B 30HH	[1]	65.88	79.06
Isopropanol		131.76	158.11
Xylene/ Xylol		98.82	118.58
Eastman PM	[2]	32.94	39.53
Phenodur PR 263	[3]	82.35	98.82
<i>Premix the following 2 ingredients and mix until uniform.</i>			
Beckopox EP 301	[3]	55.17	66.20
Eastman PM	[2]	27.18	32.62
Bayferrox 120M	[4]	45.75	54.90
HALOX CW-491		71.50	85.80
Microcalc MP 1538	[5]	102.35	122.82
<i>High speed disperse to 6+ NS Hegman grind.</i>			
<u>LETDOWN</u>			
<i>Premix the following, then add to above under agitation.</i>			
Xylene/ Xylol		31.11	37.33
Aerosil R 972	[6]	3.66	4.39
Additol XL 270	[3]	1.83	2.20
Xylene/ Xylol		46.67	56.00
Isopropanol		45.29	54.35
Eastman PM	[2]	45.29	54.35
<u>COMPONENT B:</u>			
Phosphoric Acid (85%)		6.86	8.23
n-Butanol		20.59	24.71
<b>TOTAL</b>		<b>915.00</b>	<b>1098.00</b>

### FORMULA CONSTANTS

% Pigment/Wt.	24.40
% Pigment/Vol.	8.78
% Solids/Wt.	43.10
% Solids/Vol.	26.87
% PVC	32.68
VOC lbs./gal.	5.21
VOC g/l	624.63

### FORMULA PROPERTIES

Density lbs./gal.	9.15
KU Visc. @ 77°F	70-75
Application	Spray
Induction Time	20 minutes
Pot Life	8+ hours
<i>Package Stability is EQUAL to Control Formula without Inhibitor.</i>	

### SUPPLIER KEY

- [1] Clariant Corp.
- [2] Eastman Chemical Co.
- [3] Vianova Resins, Inc.
- [4] Bayer Corp.
- [5] Specialty Mineral, Inc.
- [6] Degussa Corp.

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.

**MB30HH/491**

**WN-031700**

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