



Formulation

Chromate Free 2K Epoxy Phenolic Etch Primer using HALOX SZP JM and HALOX 550

		<u>% Wt</u>	<u>Class</u>
<i>COMPONENT A:</i>			
<i>GRIND</i>			
<i>Premix the following before adding.</i>			
Mowital B 30 HH	[1]	7.38	Resin
Isopropanol	[2]	14.76	Solvent
Xylene	[3]	11.07	Solvent
Eastman PM Solvent	[4]	3.69	Solvent
<i>Mix well; then add:</i>			
Phenodur PR 263 (70%)	[5]	9.23	Resin
<i>Premix the next 2 ingredients before adding.</i>			
Beckopox EP 301	[5]	6.18	Resin
Eastman PM Solvent	[4]	3.05	Solvent
<i>Mix well; then add:</i>			
Bayferrox 120M	[6]	5.13	Pigment
SZP-391JM		4.99	Inhibitor
Microtalc MP 15-38	[7]	11.47	Talc
<i>High speed disperse to 6+ NS Hegman grind.</i>			
<i>LETDOWN</i>			
<i>Premix the following, then add to above under agitation.</i>			
Xylene	[3]	3.49	Solvent
Aerosil R972	[8]	0.41	Thickener
Additol XL 270	[5]	0.21	Dispersant
Xylene	[3]	5.23	Solvent
Isopropanol	[2]	5.07	Solvent
HALOX 550		0.51	Inhibitor
Eastman PM Solvent	[4]	5.07	Solvent
<i>COMPONENT B:</i>			
Phosphoric Acid (85%)	[9]	0.77	Additive
n-Butyl Alcohol	[4]	2.31	Solvent
TOTAL		100.00	

Formula Constants

Density (g/L)	1076.48
Weight Pigment (%)	21.58
Volume Pigment (%)	7.14
Weight Solids (%)	41.52
Volume Solids (%)	25.46
PVC (%)	29.16
VOC (g/L)	628.76

Formula Properties

KU Viscosity @ 25C	70 - 75
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Supplier Key

[1]	Kurary Company, Ltd.
[2]	Eastmann Chemical Company
[3]	Ashland Chemical Company
[4]	Eastman Chemical Company
[5]	CYTEC
[6]	Bayer Corporation
[7]	Barretts Minerals, Inc.
[8]	Degussa Corporation
[9]	Albright and Wilson Americas Inc.

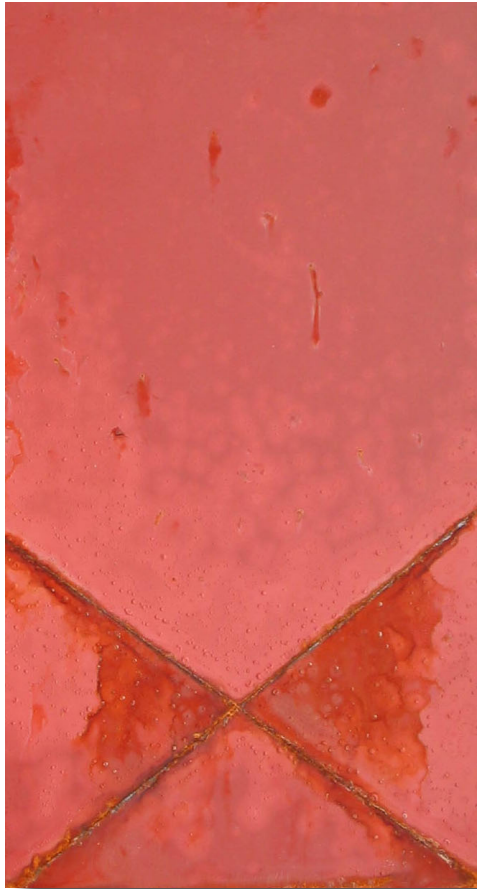
The information contained herein is correct to the best of our knowledge, but is intended only as a source of information. The recommendations or suggestions herein are made without guarantee of representation as to results, and we suggest that you evaluate the recommendations contained in this formulation in your own laboratory prior to use.

MOB30HH/391JM&550e



Chromate Replacement in 2K Epoxy Phenolic Etch Wash Primer System

Substrate: Cold Rolled Steel
72 Hours Salt Spray
12 microns- Dry Film Thickness



**5% 391 JM
0.5% HALOX 550**



7% ZnCrO4



5% 391 JM