



Formulation

Polyester Melamine Coil Coating Primer using HALOX 430 & HALOX 650 with a Blocked p-TSA Catalyst

GRIND	<u>LBS</u>	<u>GAL</u>	<u>% Wt</u>	<u>Supplier</u>
<i>Premix the next 3 ingredients before adding.</i>				
DYNAPOL L411	28.93	2.82	3.00	Degussa Corporation
Aromatic 150	33.75	4.49	3.50	Exxon Mobil Chemical
DBE	33.75	3.70	3.50	DuPont
Aerosil 200	2.89	0.16	0.30	Degussa Corporation
KRONOS 2310	53.01	1.59	5.50	KRONOS, Inc.
HALOX 430	71.33	3.26	7.40	HALOX
HALOX 650	1.00	0.08	0.10	HALOX

Sandmill to 6.0 minimum Hegman grind.

LETDOWN	<u>LBS</u>	<u>GAL</u>	<u>% Wt</u>	<u>Supplier</u>
<i>Premix the next 3 ingredients before adding.</i>				
DYNAPOL L411	173.49	16.88	18.00	Degussa Corporation
Aromatic 150	202.40	26.92	21.00	Exxon Mobil Chemical
DBE	202.40	22.18	21.00	DuPont
Cymel 303	82.89	8.27	8.60	Cytec Industries, Inc.

Premix the next 2 ingredients before adding.

EPON Resin 834	9.25	0.93	0.96	Hexion
DBE	2.31	0.25	0.24	DuPont
NACURE 2500 Catalyst*	10.99	1.37	1.14	King Industries, Inc.
Cyclohexanone	<u>55.52</u>	<u>6.99</u>	<u>5.76</u>	BASF Corporation

Mix well until uniform.

TOTAL	966.58	100.00	100.00	
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*NACURE 2500 Catalyst is blocked p-TSA (p-Toluene Sulfonic Acid) type catalyst, which unblocks at a temperature of 65 C

Formula Properties

PMT: 224 +/- 5°C
 T-Bend Adhesion: No delamination
 Pencil Hardness (primer only): minimum 2H
 Solvent Resistance (primer): > 100 MEK double rubs
 Solvent Resistance (primer & topcoat): > 100 MEK double rubs
 Viscosity (Ford 4mm): 180 +/- 10 seconds
 Viscosity should not exceed a 10 seconds increase after 30 days in the oven @ 55°C

Formula Constants

Density (lbs/gal)	9.64
% Weight Pigment	13.00
% Volume Pigment	4.90
% Weight Solids	43.97
% Volume Solids	34.14
% PVC	14.48
VOC (lbs/gal)	5.40

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.

HALOX[®] 430

Heavy Metal Free Corrosion Inhibitor

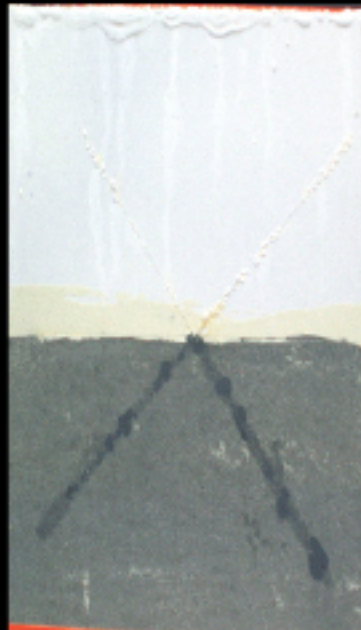
Polyester Melamine Primer and Topcoat

500 Hours Salt Spray - HDG Pretreated B1303 - 5 micron Primer/20 microns Topcoat

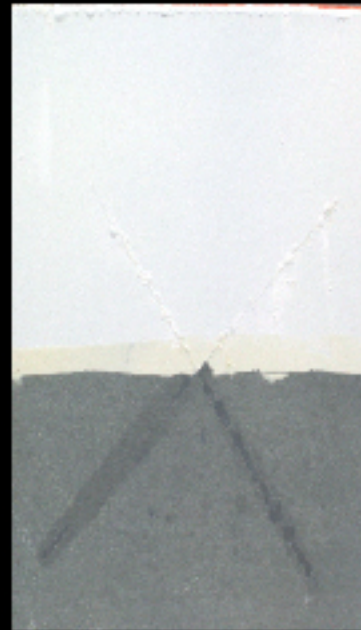
COATING



Blank Control



Competitor A - 7.5% tfw



HALOX 430[™] - 7.5% tfw

Polyester Melamine Primer and Topcoat

500 Hours Salt Spray - HDG Pretreated B1421 - 5 micron Primer/20 microns Topcoat

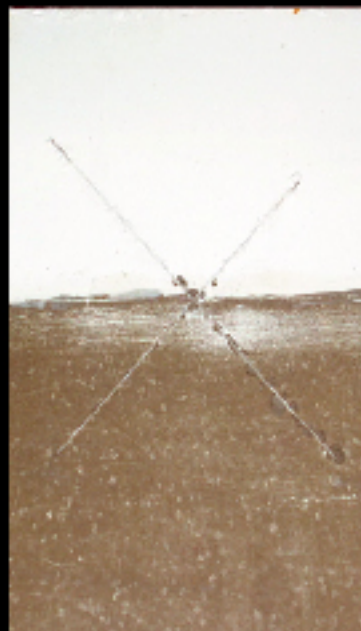
COIL



Blank Control



Competitor A - 7.5% tfw



HALOX 430[™] - 7.4% tfw
HALOX 650[™] - 0.1% tfw



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