

SHORT STUFF®

Suggested Starting Formulation

BLOCK FILLER CONTAINING SHORT STUFF® POLYETHYLENE E380F

MATERIALS:

	Pounds	Gallons
Part A:		
Epi-Rez® 510 Epoxy Resin.....	113.0	11.70
Epi-Rez® 5018 Epoxy Resin.....	37.2	4.03
Pluronic F-98 Surfactant 25%.....	7.5	.86
Drew L-475 Defoamer	2.0	.26
Mixer at low speed 3 minutes. Add:		
Rutile Titanium Dioxide.....	100.0	3.02
MiniFIBERS' SHORT STUFF® Polyethylene E380F.....	3.0	.40
Calcium Carbonate.....	150.0	6.67
Silica.....	100.0	4.55
Add water as needed for ease of dispersion.		
Water.....	152.0	18.24
	666.7	50.00
Part B:		
Epi-Cure® W50-8535 Curing Agent.....	151.0	17.30
Drew L-475 Defoamer.....	2.0	.26
Cab-O-Sil M5 Silica.....	5.0	.29
Mixer at low speed 5 minutes. Add:		
Celite® 499 Silica.....	25.0	1.31
MiniFIBERS' SHORT STUFF® Polyethylene E380F.....	3.0	.40
Magnesium Silicate.....	100.0	4.22
Add water as needed for ease of dispersion.		
Water.....	218.0	26.22
	504.0	50.00
CONSTANTS:		
Viscosity - Part A.....	Soft Paste	
Part B.....	88 Krebs Units	
Part A & B - Fresh.....	100 Krebs Units	
1/2 Hour.....	130 Krebs Units	
1 Hour.....	141 Krebs Units	
Weight per Gallon.....	11.71 lbs.	
Application.....	Brush or spray.	
	Reduce with water if needed.	
Cure.....	Room Temperature	
PVC.....	46.8%	
Total Weight Solids.....	61.0%	
Total Volume Solids.....	45.0%	
Vehicle Non-Volatile.....	37.7%	
Gloss.....	Flat	
Pencil Hardness.....	B 72 Hours Cure	
Resin Composition.....	66.5% Epoxy Resin	
	33.5% Curing Agent	

MINIFIBERS, INC.