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VANDERBILT

Minerals Formula

Formula 020503
Black Gloss Enamel Water-Reducible Alkyd Coating
ACTIV-8^{®1} Drier, Stabilizer and Accelerator

	Pounds	Gallons	Kilograms	Liters
GRIND				
Kelsol [®] 3961-B2G-75 ²	145.0	16.6	17.39	16.56
<i>Preblend the next four items and add:</i>				
Arcosolv [®] PnB ³	20.0	2.8	2.40	2.75
Calcium sulfonate corrosion inhibitor	20.0	2.5	2.40	2.50
ACTIV-8¹ Drier, Stabilizer and Accelerator	2.0	0.3	0.24	0.25
Cobalt Hydrocure [®] II ⁴	4.8	0.6	0.58	0.63
AMP-95 ⁵	10.0	1.3	1.20	1.27
<i>Measure pH and adjust to 8.0 to 8.5 with AMP-95.</i>				
<i>Mix at slow speed for 5 minutes.</i>				
Raven [®] 1255 ⁶	17.5	1.2	2.10	1.20
Water	250.7	30.0	29.98	29.98
<i>Steel ball mill to 7 Hegman fineness. Transfer to let down tank.</i>				
LET DOWN				
Kelsol 3961-B2G-75 ²	115.0	13.1	13.79	13.13
AMP-95 ⁵	5.0	0.6	0.60	0.64
<i>Adjust pH to 8.0 to 8.5</i>				
<i>Premix the next two items and add:</i>				
Arcosolv PnB ³	10.0	1.4	1.20	1.38
Water	245.2	29.4	29.68	29.68
<i>Mix at slow speed for 10 minutes.</i>				
TOTALS	845.2	99.8	101.56	99.97
PAINT PROPERTIES				
Density	8.5 lbs/gal		1.06 g/ml	
% Solids by weight	25.1			
% Solids by volume	21.1			
% PVC	5.7			
Pigment to binder ratio	0.90:1			
Calculated VOC	2.71 lbs/gal		325 g/l	

RAW MATERIAL SUPPLIERS

- ¹Vanderbilt Minerals, LLC, Norwalk, CT
- ²Reichhold, Inc., Research Triangle Park, NC
- ³Lyondell Chemical Company, Rotterdam, The Netherlands
- ⁴OM Group, Inc., Cleveland, OH
- ⁵Angus Chemical Company, Buffalo Grove, IL
- ⁶Columbian Chemicals Company, Marietta, GA

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- Cobalt Hydrocure is a registered trademark of OM Group, Inc.
- Kelsol is a registered trademark of Reichhold Chemical, Inc.
- Raven is a registered trademark of Columbian Chemical Company.

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Vanderbilt Minerals, LLC, 33 Winfield Street, P.O. Box 5150, Norwalk, CT 06856-5150
Telephone: (800) 562-2476 - Fax: (203) 855-1220 - Web Site: vanderbiltminerals.com

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