# Guide formulation

Epoxy guide formulation for high gloss white 1 coat epoxy enamels for steel & aluminium

<table>
<thead>
<tr>
<th>Product</th>
<th>% by weight</th>
<th>Supplier</th>
</tr>
</thead>
<tbody>
<tr>
<td>Razeen SR 5014 (EEW 650-850 is acceptable)</td>
<td>58.200</td>
<td><a href="http://www.jana-ksa.net">www.jana-ksa.net</a></td>
</tr>
<tr>
<td>G92Worlee (phenolic catalysed)</td>
<td>10.300</td>
<td><a href="http://www.worlee.de">www.worlee.de</a></td>
</tr>
<tr>
<td>Resiflow P-65F (PV88 as alternative)</td>
<td>1.200</td>
<td><a href="http://www.worlee.de">www.worlee.de</a></td>
</tr>
<tr>
<td>Sensowhite 4</td>
<td>8.000</td>
<td><a href="http://www.sensopolis.com">www.sensopolis.com</a></td>
</tr>
<tr>
<td>Nanoguard ACP DCP</td>
<td>4.300</td>
<td><a href="http://www.sensopolis.com">www.sensopolis.com</a></td>
</tr>
<tr>
<td>Tiona 595 (Titanium Dioxide)</td>
<td>17.500</td>
<td><a href="http://www.cristal.com">www.cristal.com</a></td>
</tr>
<tr>
<td>Benzoin</td>
<td>0.500</td>
<td></td>
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**Total**

100.00

**Premix:**

2 min approx. 1200 rpm

**Extrusion:**

Prism TSE 16, heating zone: 110°C, shaft speed: approx. 350rpm

**Grinding:**

Retsch ZM 100, 16000 rpm

**Sieving:**

140μm

**Application:**

40 - 100 microns (typical 60 - 90)

**Cure schedule:**

- Fast Curing 2 minutes @ 200 °C
- Medium Fast Cure 5 minutes @ 160 °C
- Low Temperature Cure 20 minutes @ 120 °C
Coatings can be cured in 2 minutes at 200 °C or low temperature cured in 20 Minutes at 120 °C while maintaining both mechanical (160 reverse inch pounds impact) and chemical resistance (100+ MEK double rubs) properties.

Application and properties

Hardener G-92 is intended for high gloss decorative powder coatings with smooth surface appearance as well as for corrosion protection applications. A major advantage is the ability to cure at low temperature. Low temperature curing systems for energy saving coating processes or for heat sensitive substrates can be formulated with Hardener G-92. Epoxy Hardener G-92 can 15 to 25% of the binder depending flexibility & speed of cure.

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