

**Formula 2C: Clear ZEFFLE SE-310-1K**

Raw Materials	Parts per Hundred (% by Weight)
<b>Mill Base</b>	
Water	26.20
Dispersant (Disperbyk®-190, BYK-Altana: N.V.= 40%)	3.50
Titanium dioxide (Tipaque® CR-97, Ishihara Sangyo: specific gravity = 4.2)	70.00
Defoamer (BYK 028, BYK-Altana)	0.30
<b>Total</b>	<b>100.00</b>
<i>High-speed dispense with glass beads</i>	
<b>Letdown</b>	
ZEFFLE SE-310	68.22
Ammonia water (28%)	0.59
Mill base	24.07
Coalescent (Diethyl adipate)	5.11
Defoamer (BYK 028, BYK-Altana)	0.10
Thickener, 10% solid (ADEKA NOL UH-420)	1.91
<b>Total</b>	<b>100.00</b>

Paint Properties		
Solids content (approx.)	Mass %	51
Pigment volume concentration (PVC)	Mass %	15

**Formula 3C: Clear ZEFFLE GK-570-2K**

Materials	Parts per Hundred (% by Weight)
ZEFFLE GK-570	54.12
n-Butyl acetate	11.11
Methyl isobutyl ketone	20.89
Cyclohexanone	10.80
Rheological additive (BYK 410, BYK-Altana)	3.09
<b>Total</b>	<b>100.00</b>

Paint Properties		
Solids content (approx.)	Mass %	35

**Formulation: Hardener**

Materials	Parts per Hundred (% by Weight)
Isocyanate	50.9
n-Butyl acetate	49.1
<b>Total</b>	<b>100.00</b>

**Formula 1P: Pigmented ZEFFLE SE-2K**

Formulation: A Component

Materials	Parts per Hundred (% by Weight)
<b>Mill Base</b>	
Water	26.20
Dispersant (Disperbyk-190, BYK-Altana)	3.50
Titanium dioxide pigment (Tipaque CR-97, Ishihara Sangyo)	70.00
Defoamer (BYK 028, BYK-Altana)	0.30
<b>Total</b>	<b>100.00</b>
<i>High-speed grind with glass beads</i>	
<b>Letdown</b>	
ZEFFLE SE-2K	68.22
Ammonia water (28%)	0.59
Mill base	24.07
Coalescent (Diethyl adipate)	5.11
Defoamer (BYK 028, BYK-Altana)	0.10
Thickener, 10% solid (ADEKA NOL UH-420)	1.91
<b>Total</b>	<b>100.00</b>

Paint Properties		
Solids content (approx.)	Mass %	51
Pigment volume concentration (PVC)	Mass %	15
<i>Add Bayhydur XP-2700 to A component with good mixing</i>		
A component		20
Bayhydur XP-2700 (Covestro)		0.6

NCO/OH=1.3

**Formula 2P: Pigmented ZEFFLE SE-310-1K**

Materials	Parts per Hundred (% by Weight)
<b>Mill Base</b>	
Water	26.20
Dispersant (Disperbyk-190, BYK-Altana: N.V.= 40%)	3.50
Titanium dioxide pigment (Tipaque CR-97, Ishihara Sangyo: specific gravity= 4.2)	70.00
Defoamer (BYK 028, BYK-Altana)	0.30
<b>Total</b>	<b>100.00</b>
<i>High-speed grind with glass beads</i>	
<b>Letdown</b>	
ZEFFLE SE-310	68.22
Ammonia water (28%)	0.59
Mill base	24.07
Coalescent (Diethyl adipate)	5.11
Defoamer (BYK 028, BYK-Altana)	0.10
Thickener, 10% solid (ADEKA NOL UH-420)	1.91
<b>Total</b>	<b>100.00</b>

Paint Properties		
Solids content (approx.)	Mass %	51
Pigment volume concentration (PVC)	Mass %	15

**Formula 3P: Pigmented ZEFFLE GK-570-2K**

Materials	Parts per Hundred (% by Weight)
<b>Mill Base</b>	
Titanium dioxide pigment (Tipaque CR-97, Ishihara Sangyo: specific gravity = 4.2)	51.53
ZEFFLE GK-570	39.59
n-Butyl acetate	8.88
<b>Total</b>	<b>100.00</b>
<i>High-speed dispense with glass beads</i>	
<b>Cut Back</b>	
Mill base	67.59
ZEFFLE GK-570	17.54
n-Butyl acetate	3.60
Methyl isobutyl ketone	6.77
Cyclohexanone	3.50
Rheological additive (BYK 410, BYK-Altana)	1.00
<b>Total</b>	<b>100.00</b>

Paint Properties		
Solids content (approx.)	Mass %	64
Pigment volume concentration (PVC)	Mass %	50

**Formulation: Hardener**

Materials	Parts per hundred (% by Weight)
Isocyanate	30.1
n-Butyl acetate	69.9
<b>Total</b>	<b>100.00</b>