

ENCOR[®] 650

(FORMERLY EX 10-056.02)

EXTERIOR ARCHITECTURAL COATING APPLICATIONS

ARKEMA COATING RESINS

Product Benefits

ENCOR[®] 650 is a 100% acrylic resin at 50% solids content, designed for exterior architectural coating applications. ENCOR[®] 650 offers the formulation of cost-effective coatings with grain crack resistance, color retention, efflorescence resistance, and stain resistance.

ENCOR[®] 650 acrylic meets EnVia[®] standards. It is produced without APEO, benzophenone, formaldehyde or PFAS and is low VOC capable (0-50 g/L).¹

Typical Polymer Properties²

Total Solids, % by weight	50.0
Weight/Gallon, (lbs)	8.9
pH Value	9.0
Viscosity, Brookfield. cP, #3LVT at 60 rpm, 25±1 °C	550.0
Minimum Film Forming Temperature, °C	14.0

¹ These products meet the standards of Arkema Coating Resin's EnVia[®] program. These products are designed to assist formulators in meeting their sustainability and regulatory goals in their finished products.

² The data provided for these properties are typical values, intended only as guides, and should not be construed as sales specifications.

Product Safety

Please refer to the corresponding Safety Data Sheet.

Storage & Handling

ENCOR[®] 650 should be stored indoors in the original, unopened and undamaged container, in a dry place at storage temperatures not exceeding 85 °F (30 °C). Exposure to direct sunlight should be avoided.

The product is protected to prevent any microbial deterioration during normal conditions of storage but care should be taken to avoid accidental contamination during subsequent handling and processing.

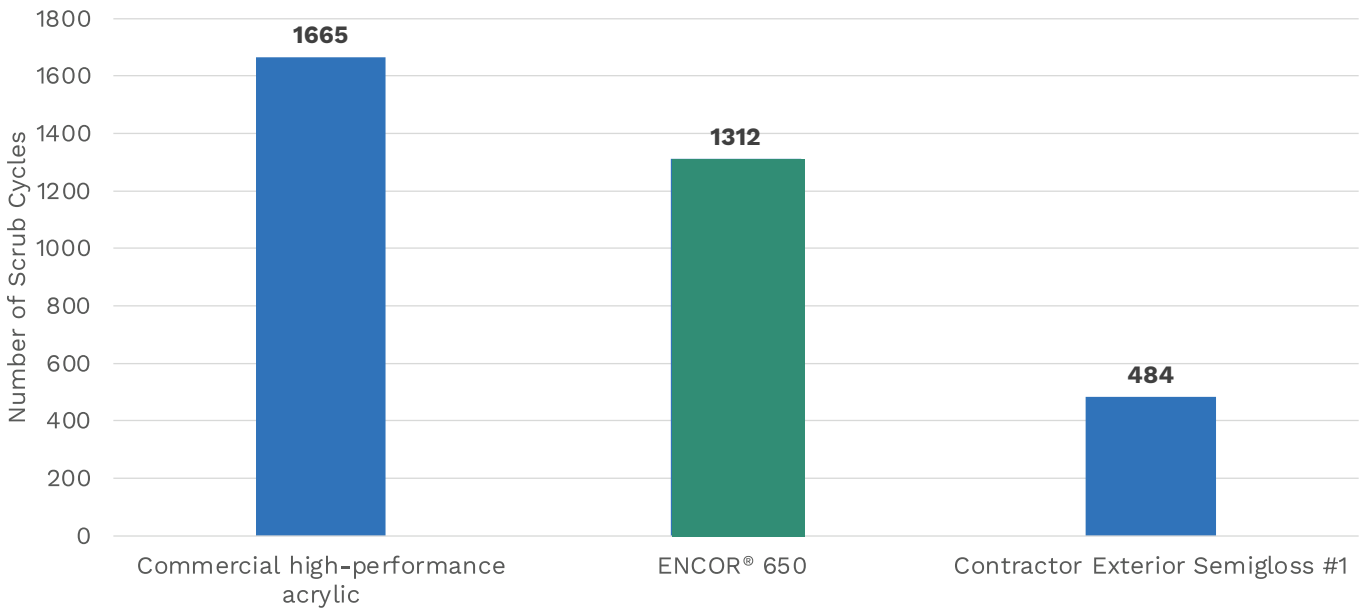
ENVIA[®]

ENCOR[®]

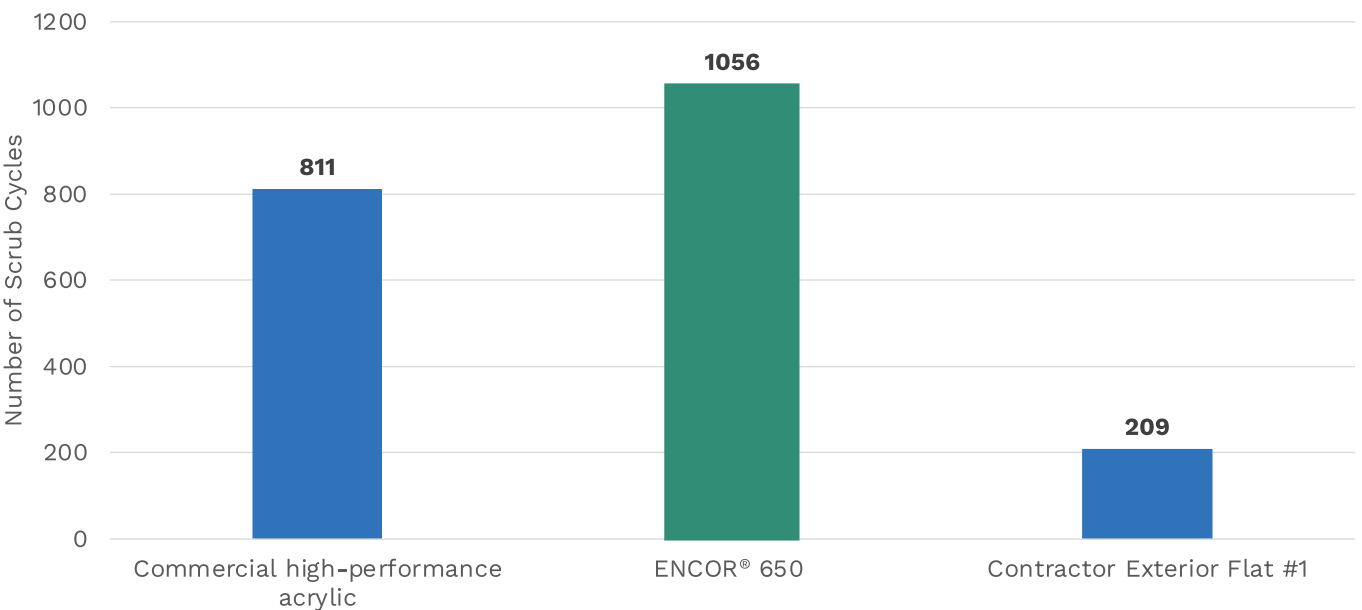
ENCOR® 650

EXTERIOR ARCHITECTURAL COATING APPLICATIONS

ENCOR® 650 Has Very Good Scrub Resistance in Semigloss Formulation



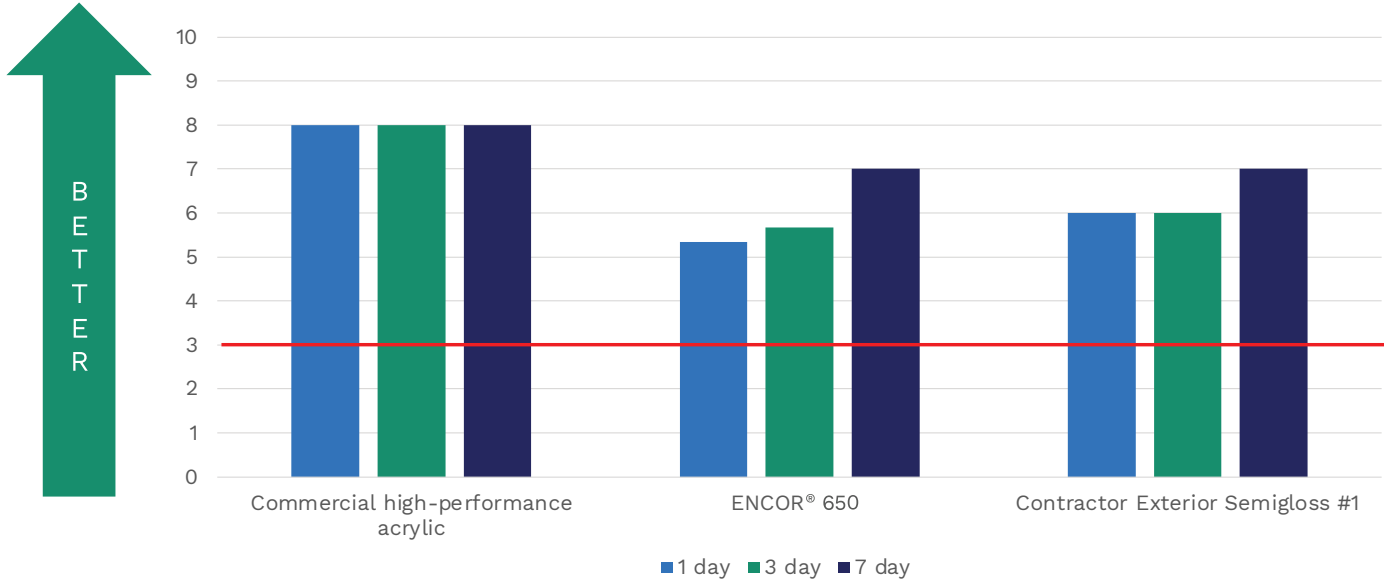
ENCOR® 650 Has Very Good Scrub Resistance in Flat Formulation



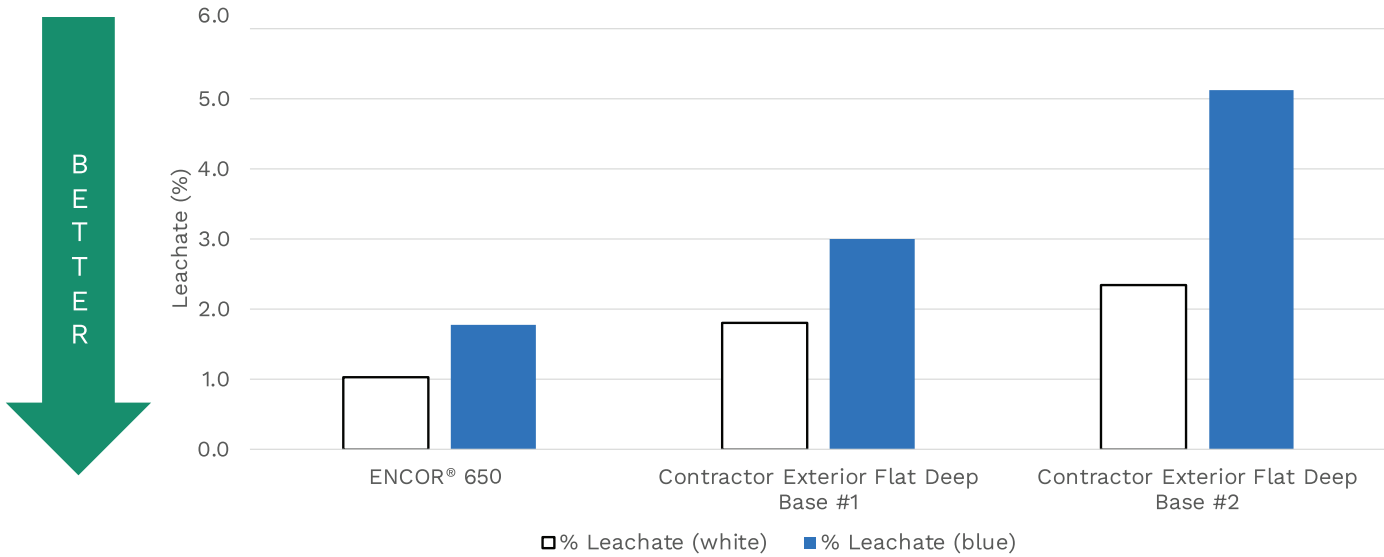
ENCOR® 650

EXTERIOR ARCHITECTURAL COATING APPLICATIONS

ENCOR® 650 Can Achieve Ambient Temperature Block Resistance in Semigloss Formulation Without Perfluorinated Surfactant



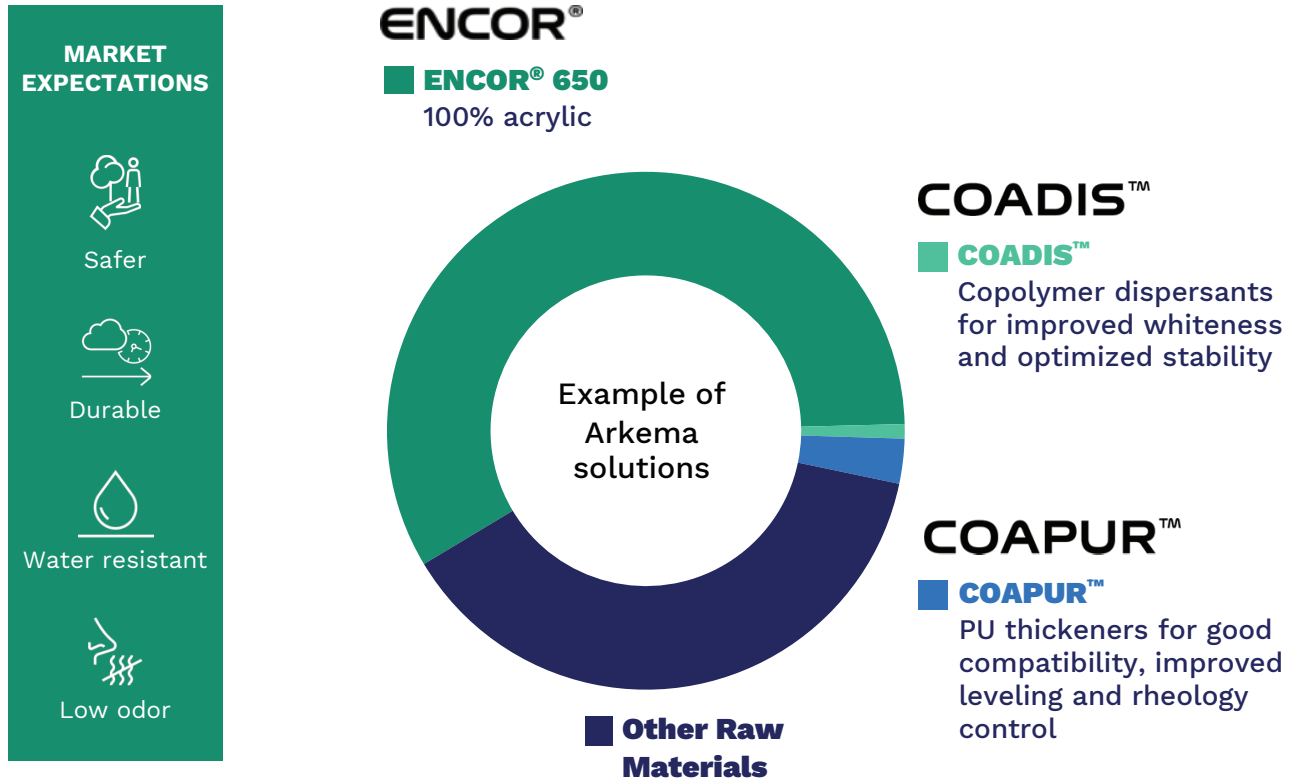
ENCOR® 650 Has Very Good Surfactant Leach Resistance in Matte Deep Base Formulation



ENCOR® 650

EXTERIOR ARCHITECTURAL COATING APPLICATIONS

Arkema Solutions Meet Market Expectations While Delivering Required Performance



ENCOR® 650: Exterior Semigloss Starting Point Formulation

Ingredient	Weight (lbs.)	Volume (Gallons)
Grind Base		
Water	25.0	3.0
NATROSOL™ PLUS 330	1.0	0.1
TI-PURE™ R-746 (slurry)	325.0	16.8
BYK® 024	2.0	0.2
COADIS™ 173	9.0	0.9
NaOH (10%)	1.5	0.2
RHODOLINE® 4188	2.5	0.3
MINEX® 7	10.0	0.5
COAPUR™ XS 71	3.0	0.3
COAPUR™ 3025	22.0	2.5
Thindown		
DREWPLUS™ T-4507	2.0	0.3
ACTICIDE® MBS	2.0	0.2
POLYPHASE® 663	18.0	2.0
ENCOR® 650	513.0	58.2
TEXANOL™ Ester Alcohol	17.0	2.0
OPTIFILM™ 400	3.8	0.5
Water	100.0	12.0
Total	1056.8	100.0

Property	Value
Weight solids (%)	50.5
Volume solids (%)	37.2
PVC (%)	26.5
VOC (g/L)	<50

ENCOR® 650: Exterior Flat Starting Point Formulation

Ingredient	Weight (lbs.)	Volume (Gallons)
Grind Base		
Water	130.0	15.6
NATROSOL™ PLUS 330	3.0	0.3
AEPD™ VOX 1000	3.0	0.3
DREWPLUS™ T-4507	3.0	0.4
TAMOL™ 165A	11.6	1.3
CARBOWET® DC-01	2.0	0.3
TI-PURE™ R-746	230.0	6.9
MINEX® 7	50.0	2.3
MINEX® 4	150.0	6.9
MINEX® 3	12.5	0.6
DIAFIL® 525	20.0	1.1
Thindown		
ENCOR® 650	362.4	41.1
TEXANOL™ Ester Alcohol	12.7	1.4
COAPUR™ 2020 W	15.0	1.7
COAPUR™ 817 W	3.0	0.3
DREWPLUS™ T-4507	2.0	0.3
ACTICIDE® MBS	2.0	0.2
POLYPHASE® 663	18.0	2.0
Water	142.1	17.1
Total	1172.3	100.1

Property	Value
Weight solids (%)	56.5
Volume solids (%)	39.0
PVC (%)	50.4
VOC (g/L)	<50

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The logo for ARKEMA, featuring the word "ARKEMA" in a bold, sans-serif font. The letters "A", "R", "K", "E", and "M" are in a dark blue color, while the letter "A" at the end is in a light green color.