Starting Formulation

SF 2002
Clear Baking Coating
EPON™ Resin 1007 / Beckamine 21-511

Features
- Good initial color and color retention
- Can be cured at 250 °F minimum

Formula

<table>
<thead>
<tr>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ethyl 3-ethoxy propionate</td>
<td>Eastman Chemical Products, Inc</td>
<td>173.3</td>
<td>22.17</td>
</tr>
<tr>
<td>Xylene</td>
<td>Shell Chemical Co.</td>
<td>173.3</td>
<td>24.18</td>
</tr>
</tbody>
</table>

*Slowly add the following with constant mixing*

EPON Resin 1007F | Hexion | 231.3 | 23.31 |

*Mix above until clear solution, then add*

Urea Resin and Solvents

<table>
<thead>
<tr>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Beckamine 21-511</td>
<td>Reichhold Chemicals, Inc.</td>
<td>167.2</td>
<td>19.34</td>
</tr>
<tr>
<td>Ethyl 3-ethoxy propionate</td>
<td></td>
<td>41.1</td>
<td>5.26</td>
</tr>
<tr>
<td>Xylene</td>
<td>Shell Chemical Co.</td>
<td>41.1</td>
<td>5.74</td>
</tr>
</tbody>
</table>

Total Part A 825.3 100.00

Mixing Instructions

<table>
<thead>
<tr>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>825.3</td>
</tr>
</tbody>
</table>

Prepare the EPON Resin 1007F solution (40% nonvolatile in ethyl 3-ethoxy propionate/xylene, 1/1 by weight) called for in the formula. This is most easily accomplished by charging the solvents in a suitable container and slowly adding the EPON Resin 1007F under constant agitation. When the EPON Resin 1007F is completely dissolved, mix the Beckamine 21-511 and remaining solvents.

Typical Handling For spray application, reduce the formulation to 20 seconds in a No. 4 Ford Cup with diacetone alcohol/xylene, 1/1 by weight.

Typical Formulation

<table>
<thead>
<tr>
<th>Properties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>EPON Resin 1007F/Beckamine 21-511</td>
<td>By weight</td>
<td>70/30</td>
</tr>
</tbody>
</table>

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Nonvolatile content by weight % 40.0
Weight per gallon Lbs 8.25
Volatile Organic Compound (VOC) lb/gal 4.95 g/L 594

Recommended Baking Schedules
Any of the baking schedules given here may be used for this coating. For pigmented finishes based on this type of vehicle, a bake schedule as high as 20 minutes at 385 °F may be required for complete cure.

1 minute at 450 °F, or
3 minutes at 400 °F, or
6 minutes at 350 °F, or
20 minutes at 300 °F, or
60 minutes at 250 °F

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at[www.hexion.com](http://www.hexion.com)

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