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

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- 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><strong>Part A</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<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

*Mix above until clear solution, then add*

Material and Solvents

- Beckamine 21-511
  - Reichhold Chemicals, Inc.
  - 167.2 pounds / 19.34 gallons
- Ethyl 3-ethoxy propionate
  - 41.1 pounds / 5.26 gallons
- Xylene
  - Shell Chemical Co.
  - 41.1 pounds / 5.74 gallons

*Total Part A*

- 825.3 pounds / 100.00 gallons

Mixing Instructions

<table>
<thead>
<tr>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td></td>
</tr>
<tr>
<td>825.3</td>
<td>100.00</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 1 / Formulation Properties

<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>
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

General Information
These are starting formulations and are not proven in the user’s particular application but are simply meant to demonstrate the efficacy of the products and to assist in the development of the user’s own formulation. It is the user’s responsibility to fully-test and qualify the formulation, along with the ingredients, methods, applications or equipment identified herein (“Information”), by the user’s knowledgeable formulator or scientist, and to determine the appropriate use conditions and legal restrictions, prior to use of any Information.

Safety, Storage & Handling
Please refer to the MSDS for the most current Safety and Handling information.

Exposure to these materials should be minimized and avoided, if feasible, through the observance of proper precautions, use of appropriate engineering controls and proper personal protective clothing and equipment, and adherence to proper handling procedures. None of these materials should be used, stored, or transported until the handling precautions and recommendations as stated in the Material Safety Data Sheet (MSDS) for these and all other products being used are understood by all persons who will work with them. Questions and requests for information on Hexion Inc. ("Hexion") products should be directed to your Hexion sales representative, or the nearest Hexion sales office. Information and MSDSs on non-Hexion products should be obtained from the respective manufacturer.

Contact Information
For product prices, availability, or order placement, please contact customer service:
www.hexion.com/Contacts/

For literature and technical assistance, visit our website at www.hexion.com