Starting Formulation

SF 2502
Phenolic Clear Bake Coating
EPI-REZ™ Resin 3540-WY-55

Formula | Material | Supplier | Pounds | Gallons
---|---|---|---|---
Formulation | EPI-REZ Resin 3540-WY-55 | Hexion | 442.9 | 48.48
 | Water | | 115.5 | 13.87

Premix and add slowly under agitation:

Methylon 75108 | Occidental Chemical Corp., Durez Div. | 162.5 | 16.75
BUTYL OXITOL™ Glycol Ether | | 48.8 | 6.50
n-Butyl Alcohol | Shell Chemical Company | 43.9 | 6.50
Nacure XP333 | King Industries | 58.1 | 7.90

Total Formulation | | 871.7 | 100.00

Typical Film Properties

<table>
<thead>
<tr>
<th>Table 2 / Typical Film Properties(^1)</th>
<th>Units</th>
<th>Bonderite 1000</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry Film Thickness</td>
<td>mils</td>
<td>0.4</td>
</tr>
<tr>
<td>Reverse Impact, .</td>
<td>in.-lbs</td>
<td>&gt;160</td>
</tr>
<tr>
<td>MEK Resistance Double Rubs</td>
<td></td>
<td>100</td>
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<tr>
<td>Pencil Hardness</td>
<td></td>
<td>9H</td>
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</tbody>
</table>

\(^1\) Baked 15 minutes at 450 °F

General Information

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