Starting Formulation

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

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Formulation</td>
<td>EPI-REZ Resin 3540-WY-55</td>
<td>Hexion</td>
<td>442.9</td>
<td>48.48</td>
</tr>
<tr>
<td></td>
<td>Water</td>
<td></td>
<td>115.5</td>
<td>13.87</td>
</tr>
</tbody>
</table>

**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 2 / Typical Film Properties

<table>
<thead>
<tr>
<th>Units</th>
<th>Bonderite</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry Film Thickness</td>
<td>mils</td>
</tr>
<tr>
<td>Reverse Impact,</td>
<td>in.-lbs</td>
</tr>
<tr>
<td>MEK Resistance Double Rubs</td>
<td>100</td>
</tr>
<tr>
<td>Pencil Hardness</td>
<td>9H</td>
</tr>
</tbody>
</table>

1 Baked 15 minutes at 450 °F

General Information

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