Starting Formulation

SF 2020
Clear Baking Finish
EPON™ Resin 1007F / Methylon 75108

Features
- Excellent resistance to corrosive media
- Excellent resistance to physical abuse
- Excellent adhesion and flexibility

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total Formulation</td>
<td>EPON Resin 1007F (40% nonvolatile)</td>
<td>Hexion</td>
<td>241.3</td>
<td>24.32</td>
</tr>
<tr>
<td></td>
<td>EPON Resin 1007F</td>
<td>Hexion</td>
<td>241.3</td>
<td>24.32</td>
</tr>
<tr>
<td></td>
<td>Ethyl 3-ethoxy propionate</td>
<td>Eastman Chemical Products, Inc.</td>
<td>181.1</td>
<td>23.16</td>
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<tr>
<td></td>
<td>Xyylene</td>
<td>Shell Chemical Co.</td>
<td>181.1</td>
<td>25.26</td>
</tr>
<tr>
<td>Phenolic Resin, Flow Control Agents and Solvents</td>
<td>Methylon 75108</td>
<td>Durez Division of Occidental Chemical Corporation</td>
<td>80.6</td>
<td>8.11</td>
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<tr>
<td></td>
<td>Silicone Resin SR 882M</td>
<td>GE Silicones</td>
<td>5.5</td>
<td>0.63</td>
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<td>Ethyl 3-ethoxy propionate</td>
<td>Eastman Chemical Products, Inc.</td>
<td>43.3</td>
<td>5.54</td>
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<td></td>
<td>Xyylene</td>
<td>Shell Chemical Co.</td>
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<td>6.03</td>
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<td>Catalyst Solution (10% acid)</td>
<td>85% Phosphoric Acid</td>
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<td>5.8</td>
<td>0.45</td>
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<td>n-Butanol</td>
<td>Shell Chemical Co.</td>
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<td>6.50</td>
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<td>Total Formulation</td>
<td>Total Formulation</td>
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<td>826.3</td>
<td>100.00</td>
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</table>

Mixing Instructions

Prepare the EPON Resin 1007F solution (40% nonvolatile in ethyl 3-ethoxy propionate/xyylene, 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 Methylon 75108, Silicone Resin SR 882M, solvents and catalyst solution.

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

Typical Formulation Table 1 / Formulation Properties

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<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
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</thead>
<tbody>
<tr>
<td>EPON Resin 1007F/ Methylon 75108 ratio (solids)</td>
<td>By weight</td>
<td>75/25</td>
</tr>
<tr>
<td>Nonvolatile content by weight</td>
<td>%</td>
<td>40.0</td>
</tr>
<tr>
<td>Weight per gallon</td>
<td>lb/gal</td>
<td>8.26</td>
</tr>
</tbody>
</table>

Baking Properties  

Table 2 / Recommended Baking Schedules

The baking schedules given here are designed for sheet steel and other objects of low heat capacity. In the case of tanks and other large objects, baking schedules must be adjusted to compensate for the time required to reach top temperature and the curing which takes place during the upbeat and cooling periods.

Single-coat systems:

- 10 minutes at 400 °F, or
- 20 minutes at 375 °F, or
- 30 minutes at 350 °F, or
- 60 minutes at 300 °F

Multiple-coat systems:

- Bake between coats - 30 minutes at 190 °F, or
- 10 minutes at 300 °F
- Bake after final coat - 60 minutes at 350 °F

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.

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For product prices, availability, or order placement, please contact customer service:

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For literature and technical assistance, visit our website at [www.hexion.com](http://www.hexion.com)

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Page 2 of 3
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