## Starting Formulation

### SF 1802

Clear Enamel (For Maximum Solvent and Abrasion Resistance)

**EPI-REZ™ Resin 5522-WY-55 / EPIKURE™ Curing Agent 8290-Y-60**

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Part A</strong></td>
<td>EPI-REZ Resin 5522-WY-55</td>
<td>Hexion</td>
<td>490.6</td>
<td>54.82</td>
</tr>
<tr>
<td></td>
<td>Michemlube 743 Mar and Slip Agent</td>
<td>Michelman Chemicals</td>
<td>41.0</td>
<td>5.00</td>
</tr>
<tr>
<td></td>
<td>CYCLO SOL 63</td>
<td>Shell Chemical Co.</td>
<td>32.3</td>
<td>4.37</td>
</tr>
<tr>
<td></td>
<td>Ektasolve EP, 2-Propoxyethanol</td>
<td>Eastman Chemical Products</td>
<td>33.2</td>
<td>4.37</td>
</tr>
<tr>
<td></td>
<td>DI Water</td>
<td></td>
<td>53.6</td>
<td>6.44</td>
</tr>
<tr>
<td></td>
<td><strong>Total Part A</strong></td>
<td></td>
<td>650.7</td>
<td>75.00</td>
</tr>
<tr>
<td><strong>Part B</strong></td>
<td>EPIKURE Curing Agent 8290-Y-60</td>
<td>Hexion</td>
<td>145.8</td>
<td>16.51</td>
</tr>
<tr>
<td></td>
<td>DeeFo PI-4 Concentrate Defoamer</td>
<td>Münzing Additives</td>
<td>4.0</td>
<td>0.49</td>
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<tr>
<td></td>
<td>DI Water</td>
<td></td>
<td>66.6</td>
<td>8.00</td>
</tr>
<tr>
<td></td>
<td><strong>Total Part B</strong></td>
<td></td>
<td>216.4</td>
<td>25.00</td>
</tr>
<tr>
<td></td>
<td><strong>Total Part A &amp; B</strong></td>
<td></td>
<td>867.1</td>
<td>100.00</td>
</tr>
</tbody>
</table>

### Mixing Instructions

<table>
<thead>
<tr>
<th></th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>650.7</td>
<td>75.00</td>
</tr>
<tr>
<td>Part B</td>
<td>216.4</td>
<td>25.00</td>
</tr>
<tr>
<td>Part A + B</td>
<td>867.1</td>
<td>100.00</td>
</tr>
</tbody>
</table>

### Resin Composition

<table>
<thead>
<tr>
<th></th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>% solids</td>
<td>75.0</td>
</tr>
<tr>
<td>Part B</td>
<td>% solids</td>
<td>25.0</td>
</tr>
<tr>
<td>Part A + B</td>
<td>% solids</td>
<td>100.0</td>
</tr>
</tbody>
</table>

### Typical Formulation Table 1 / Formulation Properties

<table>
<thead>
<tr>
<th>Properties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
</table>
Mix Ratio, Part A: Part B

<table>
<thead>
<tr>
<th></th>
<th>By volume</th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Total weight solids</td>
<td>%</td>
<td>41.8</td>
</tr>
<tr>
<td>Total volume solids</td>
<td>%</td>
<td>37.6</td>
</tr>
<tr>
<td>Volatile Organic Compound (VOC)</td>
<td>lb/gal</td>
<td>2.74</td>
</tr>
<tr>
<td></td>
<td>g/L</td>
<td>329</td>
</tr>
<tr>
<td>Induction Time</td>
<td>min.</td>
<td>30</td>
</tr>
<tr>
<td>Viscosity @ 25°C</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Part A</td>
<td>KU</td>
<td>58</td>
</tr>
<tr>
<td>Part B</td>
<td>KU</td>
<td>68</td>
</tr>
<tr>
<td>Part A + B</td>
<td>KU</td>
<td>85</td>
</tr>
</tbody>
</table>

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at www.hexion.com

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