Starting Formulation

SF 2007
Gloss White Enamel
EPON™ Resin 1009F / Methylon75202

Features
- Excellent resistance to detergents
- Good adhesion
- Excellent color retention on overbake

**Formula**

<table>
<thead>
<tr>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ethyl 3-ethoxy propionate</td>
<td>Eastman Chemical Products Inc.</td>
<td>169.4</td>
<td>21.64</td>
</tr>
<tr>
<td>Xylene</td>
<td>Shell Chemical Co.</td>
<td>171.8</td>
<td>23.97</td>
</tr>
</tbody>
</table>

**Add the following slowly with constant mixing**

- EPON Resin 1009F
  - Supplier: Hexion
  - Pounds: 234.2
  - Gallons: 23.60

**After the mixture is clear, add the following**

- Ti-Pure R-902
  - Supplier: Du Pont Co.
  - Pounds: 321.3
  - Gallons: 9.37

**Disperse to 7 ½ Hegman, reduce speed and add the following.**

- Methylon 75202
  - Supplier: Durez Division of Occidental Chemical Corp.
  - Pounds: 120.1
  - Gallons: 14.13

- SR 882M
  - Supplier: General Electric Company
  - Pounds: 5.4
  - Gallons: 0.57

Catalyst Solution (pre-mix)

- 85% Phosphoric acid
  - Supplier: Shell Chemical Co.
  - Pounds: 5.7
  - Gallons: 0.40

- n-Butanol
  - Supplier: Shell Chemical Co.
  - Pounds: 42.3
  - Gallons: 6.32

**Total Formulation**

- Pounds: 1,070.2
- Gallons: 100.00

**Mixing Instructions**

Prepare an EPON Resin 1009F solution (approximately 40% nonvolatile) with the ethyl 3-ethoxy propionate and xylene. Disperse the pigment in a portion of this solution using a suitable high-speed disperser. Combine the acid catalyst solution ingredients and mix with the remaining EPON Resin 1009F solution, BTL 75202 Methylon Resin, and the SR 882M. To minimize the potential of flocculation, this mixture should be aged for at least two days (preferably seven to ten days) before it is used to let down the dispersion.

**Typical Handling**
For spray application, reduce the formulation to 20 seconds in a No. 4 Ford Cup with ethyl 3-ethoxy propionate/toluene, 1/1 by weight.
This coating system should be baked for 30 minutes at 350 °F or 15 minutes at 400 °F.

### 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 1009F/Methylon 75202 ration (solids)</td>
<td>By weight</td>
<td>75/25</td>
</tr>
<tr>
<td>Nonvolatile content by weight</td>
<td>%</td>
<td>59.7</td>
</tr>
<tr>
<td>Weight per gallon</td>
<td>lb/gal</td>
<td>10.7</td>
</tr>
<tr>
<td>Pigment : Binder Weight Ratio</td>
<td></td>
<td>1.0/1.0</td>
</tr>
<tr>
<td>Volatile Organic Compound (VOC)</td>
<td>lb/gal</td>
<td>4.31</td>
</tr>
<tr>
<td></td>
<td>g/L</td>
<td>518</td>
</tr>
</tbody>
</table>

**Storage**

Recommendations regarding storage conditions can be obtained by visiting our web site at [www.hexion.com](http://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/](http://www.hexion.com/Contacts/)

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

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