Starting Formulation

SF 2004
Clear Baking Coating
EPON™ Resin 1007F / Beetle 227-8

Features
- Good initial color and color retention
- Superior to Formulation No. 2002 in flexibility, exterior durability and package stability

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Ethyl 3-ethoxy propionate</td>
<td>Eastman Chemical Products, Inc.</td>
<td>173.1</td>
<td>22.13</td>
</tr>
<tr>
<td></td>
<td>Xylen</td>
<td>Shell Chemical Co.</td>
<td>173.1</td>
<td>24.15</td>
</tr>
</tbody>
</table>

Slowly add the following with constant mixing,

|         | EPON Resin 1007F   | Hexion               |        |         |
|         | Beetle 227-8       | Cytec Industries Inc.| 198.1  | 23.85   |
|         | Ethyl 3-ethoxy propionate |               | 24.7   | 3.15    |
|         | Xylen              |                      | 24.7   | 3.44    |

Total Part A 824.5 23.85

Mixing Instructions

Prepare the EPON Resin 1007F solution (40% nonvolatile in ethyl 3-ethoxy propionate/xylen, 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 Beetle 227-8 and remaining solvents.

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

This coating should be baked for 20 minutes at 385°F.

Typical Formulation Properties

<table>
<thead>
<tr>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>EPON Resin 1007F/Beetle 227-8 ratio (solids)</td>
<td>By weight</td>
</tr>
<tr>
<td>Nonvolatile content by weight</td>
<td>%</td>
</tr>
</tbody>
</table>

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Weight per gallon lb/gal 8.24
Volatile Organic Compound (VOC) lb/gal 4.94 g/L 593

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