Starting Formulation

SF 2804
Clear Powder Coating
EPON™ Resin 2024 / EPIKURE™ Curing Agent P-108

Features
- Very good general purpose powder coating
- Good film appearance
- Rapid cure speed
- Very good storage stability

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
</tr>
</thead>
<tbody>
<tr>
<td>Formulation</td>
<td>EPON Resin 2024</td>
<td>Hexion</td>
<td>953.0</td>
</tr>
<tr>
<td></td>
<td>EPIKURE Curing Agent P-108</td>
<td>Hexion</td>
<td>47.0</td>
</tr>
<tr>
<td></td>
<td>Total Weight</td>
<td></td>
<td>1000.0</td>
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</table>

Mixing Instructions

Powder coatings are generally manufactured by the melt mix technique. The highest level of gloss and performance for thin film applications is achieved by the melt mix method. All the components are dry blended, usually in a high intensity mixer. This homogeneous blend is processed through an appropriate single or twinscrew extruder and cooled to a friable solid. The dispersed extrudate is then pulverized to yield a suitable particle size distribution and sieved to eliminate coarse particles which could detract from the appearance of the coating.

Typical Handling Properties

Powder coatings can be applied by electrostatic spray, fluidized bed, electrostatic fluidized bed, and flocking gun methods. The electrostatic techniques are recommended where the optimum in film appearance is desired at thin film thicknesses. Further improvements in appearance can be realized if the substrate is heated prior to application of powder. This heating of the substrate allows the coating to achieve minimal viscosity before curing begins.

This coating will cure in 5 to 7 minutes at 400 °F or 10 to 15 minutes at 350 °F.

<table>
<thead>
<tr>
<th>Typical Formulation Properties</th>
<th>Table 1 / Formulation Properties</th>
</tr>
</thead>
<tbody>
<tr>
<td>Units</td>
<td>Value</td>
</tr>
<tr>
<td>Bake schedule</td>
<td>min./°F</td>
</tr>
<tr>
<td>Reverse impact resistance, Gardner</td>
<td>in*lbf</td>
</tr>
<tr>
<td>Flexibility, Zuhr Conical Mandrel</td>
<td>pass 1/8&quot;</td>
</tr>
<tr>
<td>Pencil hardness, ASTM D 3363</td>
<td>pass 5H</td>
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</table>

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Cross hatch adhesion, 1/8" squares  pass
Solvent resistance
MIBK  hrs  pass 2
MEK  min.  pass 8
Gloss, 60°  %  100

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