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><strong>Total Weight</strong></td>
<td></td>
<td>1000.0</td>
</tr>
</tbody>
</table>

Mixing Instructions

Pounds

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.

Typical Formulation Properties

Table 1 / Formulation Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bake schedule</td>
<td>min./°F</td>
<td>15/350</td>
</tr>
<tr>
<td>Reverse impact resistance, Gardner</td>
<td>in•lb</td>
<td>pass 160</td>
</tr>
<tr>
<td>Flexibility, Zuhr Conical Mandrel</td>
<td></td>
<td>pass 1/8&quot;</td>
</tr>
<tr>
<td>Pencil hardness, ASTM D 3363</td>
<td></td>
<td>pass 5H</td>
</tr>
</tbody>
</table>

© and ™ Licensed trademarks of Hexion Inc.

DISCLAIMER

The information provided herein was believed by Hexion Inc. (“Hexion”) to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion’s terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion’s specifications. Nothing contained herein constitutes an offer for the sale of any product.
Cross hatch adhesion, 1/8" squares  pass

Solvent resistance

MIBK hrs  pass 2
MEK min.  pass 8

Gloss, 60°  %  100

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/

For literature and technical assistance, visit our website at www.hexion.com

® and ™ Licensed trademarks of Hexion Inc.

DISCLAIMER
The information provided herein was believed by Hexion Inc. (“Hexion”) to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion’s terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion’s specifications. Nothing contained herein constitutes an offer for the sale of any product.