Starting Formulation

SF 1009

Gloss White Enamel

EPON™ Resin 828 / EPIKURE™ Curing Agent 3175

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>EPON Resin 828</td>
<td>Hexion</td>
<td>291.1</td>
<td>30.17</td>
</tr>
<tr>
<td></td>
<td>Ti-PURE® R960 HG</td>
<td>Du Pont Company</td>
<td>508.4</td>
<td>15.74</td>
</tr>
<tr>
<td></td>
<td>BENTONE® SD-2 Thixotrope</td>
<td>Elementis Specialties Inc.</td>
<td>7.0</td>
<td>0.52</td>
</tr>
<tr>
<td></td>
<td>BUSPERSE® 47, Dispersant/Viscosity Depressant</td>
<td>Buckman Laboratories</td>
<td>2.3</td>
<td>0.31</td>
</tr>
<tr>
<td></td>
<td>EASTMAN® EP, 2-Propoxethanol</td>
<td>Eastman Chemical Products, Inc.</td>
<td>4.5</td>
<td>0.59</td>
</tr>
<tr>
<td></td>
<td><strong>High Speed Disperse to GrindHegman 7-8</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>EASTMAN EP, 2-Propoxethanol</td>
<td>Eastman Chemical Products, Inc.</td>
<td>123.9</td>
<td>16.34</td>
</tr>
<tr>
<td></td>
<td>BUSPERSE 47, Dispersant/Viscosity Depressant</td>
<td>Buckman Laboratories</td>
<td>2.3</td>
<td>0.31</td>
</tr>
<tr>
<td></td>
<td>Methyl propyl ketone</td>
<td></td>
<td>74.1</td>
<td>11.02</td>
</tr>
<tr>
<td></td>
<td><strong>Total Part A</strong></td>
<td></td>
<td>1,013.6</td>
<td>75.00</td>
</tr>
</tbody>
</table>

| Part B  | EPIKURE Curing Agent 3175 | Hexion | 158.3 | 19.69 |
|         | EASTMAN EP, 2-Propoxethanol | | 40.0 | 5.31 |
|         | **Total Part B** | | 198.5 | 25.00 |

| **Total Part A & B** | | 1,212.1 | 100.00 |

Mixing Instructions

Disperse the pigments in a suitable portion of the vehicle using high speed dispersing equipment. Let down the pigment dispersion with the remaining vehicle. Charge the two ingredients of the curing agent component to a separate suitable container and mix thoroughly. Package the base component and the curing agent component separately to be combined just prior to use.

Generated: December 23, 2019
Issue Date: Revision:
Typical Formulation

Table 1 / Formulation Properties

<table>
<thead>
<tr>
<th>Properties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mix ratio Part A : Part B</td>
<td>By volume</td>
<td>3 : 1</td>
</tr>
<tr>
<td></td>
<td>By weight</td>
<td>5.11:1.0</td>
</tr>
<tr>
<td>Total weight solids</td>
<td>%</td>
<td>80.0</td>
</tr>
<tr>
<td>Total volume solids</td>
<td>%</td>
<td>66.7</td>
</tr>
<tr>
<td>Pigment volume concentration (PVC)</td>
<td>%</td>
<td>24.4</td>
</tr>
<tr>
<td>Volatile Organic Compound (VOC)</td>
<td>lb/gal</td>
<td>2.43</td>
</tr>
<tr>
<td></td>
<td>g/L</td>
<td>292</td>
</tr>
<tr>
<td>Induction Time</td>
<td>minutes</td>
<td>30</td>
</tr>
<tr>
<td>Potlife</td>
<td>hrs</td>
<td>6</td>
</tr>
<tr>
<td>Viscosity @ 25°C</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Part A</td>
<td>KU</td>
<td>64</td>
</tr>
<tr>
<td>Part B</td>
<td>KU</td>
<td>61</td>
</tr>
<tr>
<td>Part A &amp; B</td>
<td>KU</td>
<td>64</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)