Starting Formulation

SF 1607

White Enamel

EPON™ Resin 828 / EPIKURE™ Curing Agent 8535-W-50

<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>Rutile Titanium Dioxide</td>
<td>Hexion</td>
<td>250.0</td>
<td>7.34</td>
</tr>
<tr>
<td></td>
<td>EPON Resin 828</td>
<td>Hexion</td>
<td>130.0</td>
<td>13.50</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>High speed disperse to texture of 7-8 Hegman reduce speed and add</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>EPON Resin 828</td>
<td>Hexion</td>
<td>32.1</td>
<td>3.34</td>
</tr>
<tr>
<td></td>
<td>HELOXY™ Modifier 8</td>
<td>Hexion</td>
<td>53.5</td>
<td>5.82</td>
</tr>
<tr>
<td></td>
<td>Total Part A</td>
<td></td>
<td>465.6</td>
<td>30.00</td>
</tr>
<tr>
<td>Part B</td>
<td>EPIKURE Curing Agent 8535-W-50</td>
<td>Hexion</td>
<td>216.0</td>
<td>24.80</td>
</tr>
<tr>
<td></td>
<td>Glacial Acetic Acid</td>
<td></td>
<td>2.0</td>
<td>0.24</td>
</tr>
<tr>
<td></td>
<td>Water</td>
<td></td>
<td>374.0</td>
<td>44.96</td>
</tr>
<tr>
<td></td>
<td>Total Part B</td>
<td></td>
<td>592.0</td>
<td>70.00</td>
</tr>
<tr>
<td></td>
<td>Total Part A &amp; B</td>
<td></td>
<td>1,057.6</td>
<td>100.00</td>
</tr>
</tbody>
</table>

Mixing Instructions

<table>
<thead>
<tr>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>465.6</td>
</tr>
<tr>
<td>Part B</td>
<td>592.0</td>
</tr>
<tr>
<td>Part A + B</td>
<td>1,057.6</td>
</tr>
</tbody>
</table>

Resin Composition

<table>
<thead>
<tr>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>% solids</td>
</tr>
<tr>
<td>Part B</td>
<td>% solids</td>
</tr>
<tr>
<td>Part A + B</td>
<td>% solids</td>
</tr>
</tbody>
</table>

Typical Formulation Table 1 / Formulation Properties - Room Temperature Cure (Brush or Spray)

<table>
<thead>
<tr>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td></td>
</tr>
</tbody>
</table>

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Mix ratio Part A : Part B

<table>
<thead>
<tr>
<th>Mix ratio Part A : Part B</th>
<th>By volume</th>
<th>30 : 70</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>By weight</td>
<td>0.78 : 1.0</td>
</tr>
</tbody>
</table>

Weight per gallon

<table>
<thead>
<tr>
<th>Weight per gallon</th>
<th>lb/gal</th>
<th>10.58</th>
</tr>
</thead>
</table>

Total weight solids

<table>
<thead>
<tr>
<th>Total weight solids</th>
<th>%</th>
<th>53.2</th>
</tr>
</thead>
</table>

Total volume solids

<table>
<thead>
<tr>
<th>Total volume solids</th>
<th>%</th>
<th>45.8</th>
</tr>
</thead>
</table>

Pigment volume concentration (PVC)

<table>
<thead>
<tr>
<th>Pigment volume concentration (PVC)</th>
<th>%</th>
<th>17.5</th>
</tr>
</thead>
</table>

Volatile Organic Compound (VOC)

<table>
<thead>
<tr>
<th>Volatile Organic Compound (VOC)</th>
<th>lb/gal</th>
<th>0.41</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>Volatile Organic Compound (VOC)</th>
<th>g/L</th>
<th>49.2</th>
</tr>
</thead>
</table>

Viscosity @ 25°C

<table>
<thead>
<tr>
<th>Viscosity @ 25°C</th>
<th>Part A &amp; B - Fresh</th>
<th>KU</th>
<th>75 - 85</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Part A &amp; B - 1 Hour</td>
<td>KU</td>
<td>off scale</td>
</tr>
</tbody>
</table>

Gloss (60° Angle)

<table>
<thead>
<tr>
<th>Gloss (60° Angle)</th>
<th>Units</th>
<th>98</th>
</tr>
</thead>
</table>

Pencil Hardness, 72 Hours cure

<table>
<thead>
<tr>
<th>Pencil Hardness, 72 Hours cure</th>
<th>B</th>
</tr>
</thead>
</table>

Volatiles Composition

<table>
<thead>
<tr>
<th>Volatiles Composition</th>
<th>Water</th>
<th>lbs</th>
<th>477.7</th>
</tr>
</thead>
</table>

<table>
<thead>
<tr>
<th>Volatiles Composition</th>
<th>Organic</th>
<th>lbs</th>
<th>17.3</th>
</tr>
</thead>
</table>

Reduction for Spray Properties

<table>
<thead>
<tr>
<th>Reduct for Spray Properties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Parts A and B</td>
<td>Parts</td>
<td>17</td>
</tr>
<tr>
<td>Water</td>
<td>Parts</td>
<td>1</td>
</tr>
</tbody>
</table>

Storage

Recommendations regarding storage conditions can be obtained by visiting our web site at www.hexion.com

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