## Starting Formulation

### SF 1801

Clear Enamel (Maximum Solvent and Abrasion Resistance)

**EPI-REZ™ Resin 5522-WY-55 / EPIKURE™ Curing Agent 8290-Y-60**

<table>
<thead>
<tr>
<th>Formula Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Part A</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>EPI-REZ Resin 5522-WY-55</td>
<td>Hexion</td>
<td>477.2</td>
<td>53.31</td>
</tr>
<tr>
<td>CYCLO SOL 63</td>
<td>Shell Chemical Co.</td>
<td>32.3</td>
<td>4.37</td>
</tr>
<tr>
<td>Ektasol-EP, 2-Propoxyethanol</td>
<td>Eastman Chemical Products, Inc.</td>
<td>33.2</td>
<td>4.37</td>
</tr>
<tr>
<td>Water</td>
<td></td>
<td>107.9</td>
<td>12.95</td>
</tr>
<tr>
<td>Total Part A</td>
<td></td>
<td>650.6</td>
<td>75.00</td>
</tr>
</tbody>
</table>

| **Part B**                        |                                 |        |         |
| EPIKURE Curing Agent 8290-Y-60    | Hexion                          | 145.8  | 16.51   |
| Patcote 847 Defoamer              | C.J. Patterson Co.              | 4.0    | 0.56    |
| Water                             |                                 | 66.1   | 7.93    |
| Total Part B                      |                                 | 215.9  | 25.00   |

| **Total Part A & B**              |                                 | 866.5  | 100.00  |

### Mixing Instructions

<table>
<thead>
<tr>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td>650.6</td>
</tr>
<tr>
<td>Part B</td>
<td>215.9</td>
</tr>
<tr>
<td>Part A + B</td>
<td>866.5</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**

<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 weight</td>
<td>3 : 1</td>
</tr>
</tbody>
</table>

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Mix Ratio Part A: Part B

By weight
3 : 1

Total weight solids % 40.4

Total volume solids % 36.0

Volatile Organic Compound (VOC) lb/gal 2.84
g/L 340

Induction Time min. 30

Viscosity @ 25°C

<table>
<thead>
<tr>
<th></th>
<th>Part A</th>
<th>Part B</th>
<th>Part A + B</th>
</tr>
</thead>
<tbody>
<tr>
<td>KU</td>
<td>68</td>
<td>64</td>
<td>75</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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