Starting Formulation

SF 2004

Clear Baking Coating
EPON™ Resin 1007F / Beetle 227-8

Features
- Good initial color and color retention
- Superior to Formulation No. 2002 in flexibility, exterior durability and package stability

Formula

<table>
<thead>
<tr>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Ethyl 3-ethoxy propionate</td>
<td>Eastman Chemical Products, Inc.</td>
<td>173.1</td>
<td>22.13</td>
</tr>
<tr>
<td>Xylenene</td>
<td>Shell Chemical Co.</td>
<td>173.1</td>
<td>24.15</td>
</tr>
</tbody>
</table>

Slowly add the following with constant mixing,

| EPON Resin 1007F                | Hexion            | 230.8  | 23.28   |
| Beeta 227-8                     | Cytec Industries Inc. | 198.1  | 23.85   |
| Ethyl 3-ethoxy propionate       |                    | 24.7   | 3.15    |
| Xylene                          |                    | 24.7   | 3.44    |

Mix until clear solution, then add

Total Part A

<table>
<thead>
<tr>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>824.5</td>
<td>23.85</td>
</tr>
</tbody>
</table>

Mixing Instructions

Prepare the EPON Resin 1007F solution (40% nonvolatile in ethyl 3-ethoxy propionate/xylenene, 1/1 by weight) called for in the formula. This is most easily accomplished by charging the solvents in a suitable container and slowly adding the EPON Resin 1007F under constant agitation. When the EPON Resin 1007F is completely dissolved, mix the Beetle 227-8 and remaining solvents.

Typical Handling
For spray application, reduce the formulation to a No. 4 Ford Cup viscosity of 20 seconds with diacetone alcohol/xylenene, 1/1 by weight.

This coating should be baked for 20 minutes at 385 °F.

Typical Formulation Table 1 / Formulation Properties

<table>
<thead>
<tr>
<th>Properties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>EPON Resin 1007F/Beetle 227-8 ratio (solids)</td>
<td>By weight</td>
<td>70/30</td>
</tr>
<tr>
<td>Nonvolatile content by weight</td>
<td>%</td>
<td>40.0</td>
</tr>
</tbody>
</table>

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Weight per gallon  
8.24 lb/gal

Volatile Organic Compound (VOC)  
4.94 lb/gal
593 g/L

Storage  Recommendations regarding storage conditions can be obtained by visiting our web site at 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.

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