## Starting Formulation

### SF 2504

**Clear Bake Coating**  
**EPI-REZ™ Resin 3540-WY-55**

<table>
<thead>
<tr>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>EPI-REZ Resin 3540-WY-55</td>
<td>Hexion</td>
<td>439.6</td>
<td>48.07</td>
</tr>
<tr>
<td>Methyl Isobutyl Ketone</td>
<td>Shell Chemical Company</td>
<td>98.8</td>
<td>14.81</td>
</tr>
<tr>
<td>Deionized Water</td>
<td></td>
<td>98.8</td>
<td>11.85</td>
</tr>
<tr>
<td>Silwet L-7604 Surfactant</td>
<td>Union Carbide Corp.</td>
<td>2.4</td>
<td>0.28</td>
</tr>
<tr>
<td>Santolink EP-560</td>
<td>Monsanto Co.</td>
<td>193.3</td>
<td>21.15</td>
</tr>
<tr>
<td>Dimethylethanolamine</td>
<td></td>
<td>19.1</td>
<td>2.54</td>
</tr>
<tr>
<td>Nacure XP333</td>
<td>King Industries</td>
<td>9.1</td>
<td>1.30</td>
</tr>
<tr>
<td><strong>Total Formulation</strong></td>
<td></td>
<td>861.1</td>
<td>100.00</td>
</tr>
</tbody>
</table>

### Mixing Instructions

<table>
<thead>
<tr>
<th></th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Total Formulation</strong></td>
<td>861.1</td>
<td>100.00</td>
</tr>
</tbody>
</table>

### Typical Formulation

#### Table 1 / Formulation Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Total Weight Solids</td>
<td>%</td>
<td>46.8</td>
</tr>
<tr>
<td>Total Volume Solids</td>
<td>%</td>
<td>42.7</td>
</tr>
<tr>
<td>Pounds/Gallon</td>
<td>lbs/gal</td>
<td>8.61</td>
</tr>
<tr>
<td>Epoxy/Phenolic, solids</td>
<td>%</td>
<td>60/40</td>
</tr>
<tr>
<td>Volatile Organic Compounds (VOC)</td>
<td>lbs/gal</td>
<td>2.90</td>
</tr>
<tr>
<td>Viscosity, Brookfield #5 spindle at 50 rpm</td>
<td>cP</td>
<td>1,200</td>
</tr>
</tbody>
</table>

#### Table 2 / Film Performance Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry Film Thickness</td>
<td>mils</td>
<td>0.5</td>
</tr>
<tr>
<td>Reverse Impact,</td>
<td>in.-lbs</td>
<td>160</td>
</tr>
<tr>
<td>MEK Resistance Double Rubs</td>
<td></td>
<td>100</td>
</tr>
<tr>
<td>Pencil Hardness</td>
<td></td>
<td>6H</td>
</tr>
</tbody>
</table>

1 Baked 10 minutes at 400 °F

### 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.

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