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>
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<tr>
<td></td>
<td>HELOXY™ Modifier 8</td>
<td>Hexion</td>
<td>53.5</td>
<td>5.82</td>
</tr>
</tbody>
</table>

High speed disperse to texture of 7-8 Hegman reduce speed and add

<table>
<thead>
<tr>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>EPON Resin 828</td>
<td>Hexion</td>
<td>32.1</td>
<td>3.34</td>
</tr>
<tr>
<td>HELOXY™ Modifier 8</td>
<td>Hexion</td>
<td>53.5</td>
<td>5.82</td>
</tr>
</tbody>
</table>

Total Part A: 465.6 30.00

| Part B  | EPIKURE Curing Agent 8535-W-50 | Hexion | 216.0  | 24.80   |
|         | Glacial Acetic Acid |        | 2.0    | 0.24    |
|         | Water |                        | 374.0  | 44.96   |

Total Part B: 592.0 70.00

Total Part A & B: 1,057.6 100.00

Mixing Instructions

<table>
<thead>
<tr>
<th>Part A</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>465.6</td>
<td>30.00</td>
<td></td>
</tr>
<tr>
<td>592.0</td>
<td>70.00</td>
<td></td>
</tr>
<tr>
<td>1,057.6</td>
<td>100.00</td>
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</tbody>
</table>

Resin Composition

<table>
<thead>
<tr>
<th>Part A</th>
<th>% solids</th>
<th>Value</th>
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</thead>
<tbody>
<tr>
<td>66.5</td>
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<td></td>
</tr>
<tr>
<td>Part B</td>
<td>% solids</td>
<td>Value</td>
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<tr>
<td>33.5</td>
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<td></td>
</tr>
<tr>
<td>Part A + B</td>
<td>% solids</td>
<td>Value</td>
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<tr>
<td>100.0</td>
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<td></td>
</tr>
</tbody>
</table>

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

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

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Mix ratio Part A : Part B

By volume

30 : 70

By weight

0.78 : 1.0

Weight per gallon

lb/gal

10.58

Total weight solids

% 53.2

Total volume solids

% 45.8

Pigment volume concentration (PVC)

% 17.5

Volatile Organic Compound (VOC)

lb/gal

0.41

g/L

49.2

Viscosity @ 25°C

Part A & B - Fresh

KU

75 - 85

Part A & B - 1 Hour

KU

off scale

Gloss (60° Angle)

Units

98

Pencil Hardness, 72 Hours cure

B

Volatile composition

Water

lbs

477.7

Organic

lbs

17.3

Reduction for Spray Table 2 / Reduction for Conventional Spray (By Volume)

Properties

Units Value

Parts A and B

Parts 17

Water

Parts 1

Storage

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

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