

Starting Formulation

SF 2002

Clear Baking Coating

EPON™ Resin 1007 / Beckamine 21-511

- Features
- Good initial color and color retention
 - Can be cured at 250 °F minimum

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	Ethyl 3-ethoxy propionate	Eastman Chemical Products, Inc	173.3	22.17
	Xylene	Shell Chemical Co.	173.3	24.18
<i>Slowly add the following with constant mixing</i>				
	EPON Resin 1007F	Hexion	231.3	23.31
<i>Mix above until clear solution, then add</i>				
Urea Resin and Solvents				
	Beckamine 21-511	Reichhold Chemicals, Inc.	167.2	19.34
	Ethyl 3-ethoxy propionate		41.1	5.26
	Xylene	Shell Chemical Co.	<u>41.1</u>	<u>5.74</u>
	Total Part A		825.3	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	825.3	100.00

Prepare the EPON Resin 1007F solution (40% nonvolatile in ethyl 3-ethoxy propionate/xylene, 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 Beckamine 21-511 and remaining solvents.

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

Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
EPON Resin 1007F/Beckamine 21-511	By weight	70/30

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Nonvolatile content by weight	%	40.0
Weight per gallon	lbs	8.25
Volatile Organic Compound (VOC)	lb/gal	4.95
	g/L	594

Recommended Baking Schedules Any of the baking schedules given here may be used for this coating. For pigmented finishes based on this type of vehicle, a bake schedule as high as 20 minutes at 385 °F may be required for complete cure.

- 1 minute at 450 °F, or
- 3 minutes at 400 °F, or
- 6 minutes at 350 °F, or
- 20 minutes at 300 °F, or
- 60 minutes at 250 °F

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.

Safety, Storage & Handling

Please refer to the MSDS for the most current Safety and Handling information.

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Contact Information

For product prices, availability, or order placement, please contact customer service:

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For literature and technical assistance, visit our website at www.hexion.com

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