

Starting Formulation

SF 2506

Clear Bake Coating

EPI-REZ™ Resin 3540-WY-55

Formula Material	Supplier	Pounds	Gallons
Formulation			
EPI-REZ Resin 3540-WY-55	Hexion	579.6	63.42
DI Water		113.7	13.65
Premix and add:			
Beetle Urea Formaldehyde Resin	Cytec Industries	80.7	8.92
n-Butyl Alcohol	Shell Chemical Company	43.2	6.40
Nacure XP333	King Industries	55.9	7.61
Total Formulation		873.1	100.00

Mixing Instructions	Pounds	Gallons
Total Formulation	873.1	100.00

Typical Formulation Table 1 / Formulation Properties Properties

	Units	Value
Total Weight Solids	%	45.7
Total Volume Solids	%	42.6
Pounds/Gallon	lbs/gal	8.73
Epoxy/Urea Catalyst (Active on resin solids)	%	80/20
Volatile Organic Compounds (VOC)	lbs/gal	2.19
	g/L	263
Viscosity, #4 Ford Cup	sec.	60 – 80
pH		7.1

Typical Film Table 2 / Film Performance Properties 1 Properties

	Units	Q-Panel	Bonderite 40	Bonderite 1000
Dry Film Thickness	mils	0.4	0.4	0.4
Reverse Impact	in. • lbs	100	60	>160
MEK Resistance Double Rubs		100	100	100

Generated: October 19, 2021
 Issue Date:
 Revision:

© and ™ Licensed trademarks of Hexion Inc.

DISCLAIMER

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.

Pencil Hardness

5H

5H

5H

1 Baked 10 minutes at 400 °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.

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.

Contact Information

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

www.hexion.com/Contacts/

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

Generated: October 19, 2021

Issue Date:

Revision:

® and ™ Licensed trademarks of Hexion Inc.

DISCLAIMER

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.