

Starting Formulation

SF 2502

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

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Formulation				
	EPI-REZ Resin 3540-WY-55	Hexion	442.9	48.48
	Water		115.5	13.87
<i>Premix and add slowly under agitation:</i>				
	Methylon 75108	Occidental Chemical Corp., Durez Div.	162.5	16.75
	BUTYL OXITOL™ Glycol Ether		48.8	6.50
	n-Butyl Alcohol	Shell Chemical Company	43.9	6.50
	Nacure XP333	King Industries	<u>58.1</u>	<u>7.90</u>
	Total Formulation		871.7	100.00

Typical Film Properties Table 2 / Typical Film Properties¹

	<u>Units</u>	<u>Bonderite</u> <u>1000</u>
Dry Film Thickness	mils	0.4
Reverse Impact,.	in.·lbs	>160
MEK Resistance Double Rubs		100
Pencil Hardness		9H

¹ Baked 15 minutes at 450 °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.

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Generated: October 19, 2021
Issue Date:
Revision:

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