

Starting Formulation

SF 2020

Clear Baking Finish

EPON™ Resin 1007F / Methylon 75108

- Features
- Excellent resistance to corrosive media
 - Excellent resistance to physical abuse
 - Excellent adhesion and flexibility

Formula	Material	Supplier	Pounds	Gallons
	EPON Resin 1007F (40% nonvolatile)			
	EPON Resin 1007F	Hexion	241.3	24.32
	Ethyl 3-ethoxy propionate	Eastman Chemical Products, Inc.	181.1	23.16
	Xylene	Shell Chemical Co.	181.1	25.26
	Phenolic Resin, Flow Control Agents and Solvents			
	Methylon 75108	Durez Division of Occidental Chemical Corporation	80.6	8.11
	Silicone Resin SR 882M	GE Silicones	5.5	.63
	Ethyl 3-ethoxy propionate		43.3	5.54
	Xylene	Shell Chemical Co.	43.3	6.03
	Catalyst Solution (10% acid)			
	85% Phosphoric Acid		5.8	.45
	n-Butanol	Shell Chemical Co.	<u>44.3</u>	<u>6.50</u>
		Total Formulation	826.3	100.00

Mixing Instructions	Pounds	Gallons
Total Formulation	826.3	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 Methylon 75108, Silicone Resin SR 882M, solvents and catalyst solution.

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

Typical Formulation Table 1 / Formulation Properties
 Properties

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Properties

	<u>Units</u>	<u>Value</u>
-		
EPON Resin 1007F/ Methylon 75108 ratio (solids)	By weight	75/25
Nonvolatile content by weight	%	40.0
Weight per gallon	lb/gal	8.26

Baking Properties Table 2 / Recommended Baking Schedules

The baking schedules given here are designed for sheet steel and other objects of low heat capacity. In the case of tanks and other large objects, baking schedules must be adjusted to compensate for the time required to reach top temperature and the curing which takes place during the upheat and cooling periods.

Single-coat systems:	10 minutes at 400 °F, or 20 minutes at 375 °F, or 30 minutes at 350 °F, or 60 minutes at 300 °F
Multiple-coat systems:	
Bake between coats -	30 minutes at 190 °F, or 10 minutes at 300 °F
Bake after final coat -	60 minutes at 350 °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.

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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