

# Starting Formulation

SF 2014

Aluminum Baking Finish

EPON™ Resin 1007F / Beckamine 21-511

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
Pigment				
	Aluminum Powder MD-7100	Alcan Toyo America, Inc.	<u>99.3</u>	<u>4.80</u>
	Total Part A		99.3	4.80
Part B				
EPON Resin 1007F solution				
	EPON Resin 1007F	Hexion	400.7	45.53
	Ethyl 3-ethoxy propionate	Eastman Chemical Products, Inc.	75.1	9.59
	Toluene	Shell Chemical Co.	<u>75.1</u>	<u>10.48</u>
	Total Part B		550.9	65.6
Part C				
Urea Resin and Solvents				
	Beckamine 21-511	Reichhold Chemicals, Inc.	157.2	18.41
	Propylene glycol methyl ether acetate		44.8	4.93
	Toluene	Shell Chemical Co.	<u>39.6</u>	<u>6.26</u>
	Total Part C		241.6	29.6
	Total Part A & B & C		891.8	100.00

## Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	99.3	4.80
Part B	550.9	65.6
Part C	<u>241.6</u>	<u>29.6</u>
Part A + B + C	891.8	100.00

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Place the entire amount of Aluminum Powder MD-7100 in a separate container and slowly add the EPON Resin 1007F solution and then the Beckamine 21-511 solution, employing good agitation until a smooth consistency is obtained. Then, rapidly add the remaining vehicle solution. Continue to stir the mixture for approximately 20 minutes after all components are combined.

Typical Handling For spray or dip application, reduce with propylene glycol methyl ether acetate/toluene 1/1 Properties by weight.

This coating system should be baked for 20 minutes at 385 °F.

Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
EPON Resin 1007F/Beckamine 21-511 ratio (solids)	By weight	70/30
Nonvolatile content by weight	%	46.4
Weight per gallon	lb/gal	8.9
<b>Volatile Organic Compound (VOC)</b>	lb/gal	4.77
	g/L	572

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