

Starting Formulation

SF 2007

Gloss White Enamel

EPON™ Resin 1009F / Methylon75202

- Features
- Excellent resistance to detergents
 - Good adhesion
 - Excellent color retention on overbake

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
	Ethyl 3-ethoxy propionate	Eastman Chemical Products Inc.	169.4	21.64
	Xylene	Shell Chemical Co.	<u>171.8</u>	<u>23.97</u>
<i>Add the following slowly with constant mixing</i>				
	EPON Resin 1009F	Hexion	234.2	23.60
<i>After the mixture is clear, add the following</i>				
	Ti-Pure R-902	Du Pont Co.	321.3	9.37
<i>Disperse to 7 ½ Hegman, reduce speed and add the following.</i>				
	Methylon 75202	Durez Division of Occidental Chemical Corp.	120.1	14.13
	SR 882M	General Electric Company	5.4	0.57
Catalyst Solution (pre-mix)				
	85% Phosphoric acid		5.7	0.40
	n-Butanol	Shell Chemical Co.	42.3	6.32
Total Formulation			1,070.2	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Total Formulation	1,070.2	100.00

Prepare an EPON Resin 1009F solution (approximately 40% nonvolatile) with the ethyl 3-ethoxy propionate and xylene. Disperse the pigment in a portion of this solution using a suitable high-speed disperser. Combine the acid catalyst solution ingredients and mix with the remaining EPON Resin 1009F solution, BTL 75202 Methylon Resin, and the SR 882M. To minimize the potential of flocculation, this mixture should be aged for at least two days (preferably seven to ten days) before it is used to let down the dispersion.

Typical Handling For spray application, reduce the formulation to 20 seconds in a No. 4 Ford Cup with ethyl Properties 3-ethoxy propionate/toluene, 1/1 by weight.

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This coating system should be baked for 30 minutes at 350 °F or 15 minutes at 400 °F.

Typical Formulation Table 1 / Formulation Properties
Properties

	<u>Units</u>	<u>Value</u>
EPON Resin 1009F/Methylon 75202 ration (solids)	By weight	75/25
Nonvolatile content by weight	%	59.7
Weight per gallon	lb/gal	10.7
Pigment : Binder Weight Ratio		1.0/1.0
Volatile Organic Compound (VOC)	lb/gal	4.31
	g/L	518

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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