

# Starting Formulation

## SF 2004

### Clear Baking Coating

### EPON™ Resin 1007F / Beetle 227-8

- Features
- Good initial color and color retention
  - Superior to Formulation No. 2002 in flexibility, exterior durability and package stability

Formula	Material	Supplier	Pounds	Gallons
Part A				
	Ethyl 3-ethoxy propionate	Eastman Chemical Products, Inc.	173.1	22.13
	Xylene	Shell Chemical Co.	173.1	24.15
<i>Slowly add the following with constant mixing,</i>				
	EPON Resin 1007F	Hexion	230.8	23.28
<i>Mix until clear solution, then add</i>				
	Beetle 227-8	Cytec Industries Inc.	198.1	23.85
	Ethyl 3-ethoxy propionate		24.7	3.15
	Xylene		<u>24.7</u>	<u>3.44</u>
	Total Part A		824.5	23.85

Mixing Instructions	Pounds	Gallons
Part A	824.5	23.85

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 Beetle 227-8 and remaining solvents.

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

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

**Typical Formulation** Table 1 / Formulation Properties  
**Properties**

	Units	Value
EPON Resin 1007F/Beetle 227-8 ratio (solids)	By weight	70/30
Nonvolatile content by weight	%	40.0

Generated: October 21, 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.

Weight per gallon	lb/gal	8.24
Volatile Organic Compound (VOC)	lb/gal	4.94
	g/L	593

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at [www.hexion.com](http://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/](http://www.hexion.com/Contacts/)

For literature and technical assistance, visit our website at [www.hexion.com](http://www.hexion.com)

---

Generated: October 21, 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.