

Starting Formulation

SF 2000

Two-Package Low Bake Clear Coating EPON™ Resin 1007F / Beckamine 21-511

- Features
- Good initial color and color retention.
 - Low temperature cure cycle: 20 minutes at 165 °F. This allows application to certain heat-sensitive substrates.

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPON Resin 1007-JX-55	Hexion	360.0	40.91
	Ethyl 3-ethoxy propionate	Eastman Chemical Products, Inc.	98.6	12.60
	CYCLO SOL™ 53	Shell Chemical Co.	100.2	13.93
	Beckamine 21-511	Reichhold Chemicals, Inc.	<u>220.0</u>	<u>25.76</u>
	Total Part A		778.8	93.20
Part B				
	Para-toluene sulfonic acid	King Industries	5.0	0.50
	n-Butyl alcohol		22.2	3.30
	Xylene		<u>21.5</u>	<u>3.00</u>
	Total Part B		48.7	6.80
	Total Part A & B		827.5	100.00

Mixing Instructions

	Pounds	Gallons
Part A	778.8	93.20
Part B	<u>48.7</u>	<u>6.80</u>
Part A + B	827.5	100.00
Resin Composition		
	Units	Value
Part A	% solids	60.0
Part B	% solids	<u>40.0</u>
Part A + B	% solids	100.0

Prepare the base component by charging the EPON Resin solution, the Beckamine resin solution and the solvents to a suitable container and mix under constant agitation. Prepare the catalyst component solution separately by adding the para-toluene sulfonic acid to the n-butyl alcohol/xylene solvent combination. The two components are packaged separately until ready to use.

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until ready to use.

When ready to apply, this catalyst component solution is then mixed into the base component immediately before application. The mixture will have a useful pot life or working life of about two weeks.

Application For spray application, reduce the formulation to 20 seconds in a No. 4 Ford Cup with ethyl Instructions 3-ethoxy propionate/CYCLO SOL 53, 1/1 by weight.

This coating system should be baked for 20 minutes at 165 °F to achieve proper cure.

Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Nonvolatile content by weight	%	40.5
Weight per gallon	lb/gal	8.3
Catalyst concentration by weight on solids	%	1.5
Volatile Organic Compound (VOC)	lb/gal	4.9
	g/L	591

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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