

Starting Formulation

SF 2804

Clear Powder Coating

EPON™ Resin 2024 / EPIKURE™ Curing Agent P-108

- Features
- Very good general purpose powder coating
 - Good film appearance
 - Rapid cure speed
 - Very good storage stability

Formula	Material	Supplier	Pounds
	Formulation		
	EPON Resin 2024	Hexion	953.0
	EPIKURE Curing Agent P-108	Hexion	47.0
		Total Weight	1000.0

Mixing Instructions	Pounds
Total Weight	1000.0

Powder coatings are generally manufactured by the melt mix technique. The highest level of gloss and performance for thin film applications is achieved by the melt mix method. All the components are dry blended, usually in a high intensity mixer. This homogeneous blend is processed through an appropriate single or twin screw extruder and cooled to a friable solid. The dispersed extrudate is then pulverized to yield a suitable particle size distribution and sieved to eliminate coarse particles which could detract from the appearance of the coating.

Typical Handling Properties Powder coatings can be applied by electrostatic spray, fluidized bed, electrostatic fluidized bed, and flocking gun methods. The electrostatic techniques are recommended where the optimum in film appearance is desired at thin film thicknesses. Further improvements in appearance can be realized if the substrate is heated prior to application of powder. This heating of the substrate allows the coating to achieve minimal viscosity before curing begins.

This coating will cure in 5 to 7 minutes at 400 °F or 10 to 15 minutes at 350 °F.

Typical Formulation Properties Table 1 / Formulation Properties

	Units	Value
Bake schedule	min./°F	15/350
Reverse impact resistance, Gardner	in•lb	pass 160
Flexibility, Zuhr Conical Mandrel		pass 1/8"
Pencil hardness, ASTM D 3363		pass 5H

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Cross hatch adhesion, 1/8" squares		pass
Solvent resistance		
MIBK	hrs	pass 2
MEK	min.	pass 8
Gloss, 60°	%	100

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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