

Starting Formulation

SF 1034

Clear Enamel for Low Temperature Applications

EPON™ Resin 828 / EPIKURE™ Curing Agent 3292-FX-60

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPON Resin 828	Hexion	359.2	37.03
	Toluene	Shell Chemical Company	43.3	6.02
	Ektasolve™ PM, Propylene Glycol Methyl Ether	Eastman Chemical Products, Inc.	47.8	6.22
	Beetle™ U 216-8 Urea Formaldehyde Resin	Cyteck Industries	<u>6.4</u>	<u>0.73</u>
	Total Part A		456.7	50.00
Part B				
	EPIKURE Curing Agent 3292-FX-60	Hexion	359.2	42.27
	Ektasolve™ PM, Propylene Glycol Methyl Ether	Eastman Chemical Products, Inc.	<u>59.4</u>	<u>7.73</u>
	Total Part B		418.6	50.00
	Total Part A & B		875.3	100.00

Mixing Instructions

	<u>Pounds</u>	<u>Gallons</u>
Part A	456.7	50.00
Part B	<u>418.6</u>	<u>50.00</u>
Part A + B	875.3	100.00

Resin Composition

	<u>Units</u>	<u>Value</u>
Part A	% solids	62.5
Part B	% solids	<u>37.5</u>
Part A + B	% solids	100.0

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Typical Formulation Table 1 / Formulation Properties
Properties

	<u>Units</u>	<u>Value</u>
Mix ratio Part A : Part B	By volume	1 : 1
	By weight	1.09 : 1.0
Total weight solids	%	66.1
Total volume solids	%	59.0
Volatile Organic Compound (VOC)	lb/gal	2.97
	g/L	356
Induction Time	minutes	30
Viscosity @ 25°C		
Part A	KU	55
Part B	KU	89
Part A & B	KU	63

Reduction for 20 / 1 with propylene glycol methyl ether (Ektasolve™ PM, Eastman Chemical Products, Conventional Spray Inc.)
(by volume)

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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