

Starting Formulation

SF 2504

Clear Bake Coating

EPI-REZ™ Resin 3540-WY-55

<u>Formula</u>	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
	Formulation			
	EPI-REZ Resin 3540-WY-55	Hexion	439.6	48.07
	Methyl Isobutyl Ketone	Shell Chemical Company	98.8	14.81
	Deionized Water		98.8	11.85
	Silwet L-7604 Surfactant	Union Carbide Corp.	2.4	0.28
	Santolink EP-560	Monsanto Co.	193.3	21.15
	Dimethylethanolamine		19.1	2.54
	Nacure XP333	King Industries	<u>9.1</u>	<u>1.30</u>
		Total Formulation	861.1	100.00

<u>Mixing Instructions</u>	<u>Pounds</u>	<u>Gallons</u>
Total Formulation	861.1	100.00

Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Total Weight Solids	%	46.8
Total Volume Solids	%	42.7
Pounds/Gallon	lbs/gal	8.61
Epoxy/Phenolic, solids	%	60/40
Volatiles Organic Compounds (VOC)	lbs/gal	2.90
	g/L	348
Viscosity, Brookfield #5 spindle at 50 rpm	cP	1,200

Typical Film Table 2 / Film Performance Properties ¹ Properties

	<u>Units</u>	<u>Value</u>
Dry Film Thickness	mils	0.5
Reverse Impact,	in.·lbs	160
MEK Resistance Double Rubs		100
Pencil Hardness		6H

¹ Baked 10 minutes at 400 °F

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

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