

Starting Formulation

SF 2801 White Powder Coating 2024 P-108 White 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	619.0
	EPIKURE Curing Agent P-108	Hexion	31.0
	Ti-Pure R-900	E.I. DuPont de Nemours & Co., Inc.	<u>350.0</u>
		Total Formulation	1,000.0

Mixing Instructions	Pounds
Total Formulation	1,000.0

Powder coatings are generally manufactured by the melt mix technique. All the components are dry blended, usually in a high intensity mixer. This homogeneous blend is processed through an appropriate single or twinscrew 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.

The application methods for the EPON Resin 2024/EPIKURE Curing Agent P-108 powder coating involve electrostatic spray, fluidized bed, electrostatic fluidized bed and flocking gun. This system requires the incorporation of a bake cycle to cure the formulation.

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

The formulations suggested in this bulletin may have broad application in the field of surface coatings. If any of your proposed uses are concerned with food contact, it will be necessary to consult with Resolution Performance Products LLC and the other raw material suppliers regarding FDA status of the materials involved.

Typical Formulation Table 1 / Formulation Properties Properties

Units Value

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	<u>units</u>	<u>value</u>
Bake schedule	min./°F	15/350
Reverse impact resistance, Gardner	in•lb	Pass 160
Flexibility, Zuhr Conical Mandrel	in	Pass 1/8
Pencil hardness		Pass F
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.

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/

For literature and technical assistance, visit our website at www.hexion.com

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