

Starting Formulation

SF 2504

Clear Bake Coating

EPI-REZ™ Resin 3540-WY-55

Formula	Material	Supplier	Pounds	Gallons
	Formulation			
	EPI-REZ Resin 3540-WY-55	Westlake Epoxy	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	9.1	1.30
	Total Formulation		861.1	100.00

Mixing Instructions	Pounds	Gallons
Total Formulation	861.1	100.00

Typical Formulation Table 1 / Formulation Properties Properties

	Units	Value
Total Weight Solids	%	46.8
Total Volume Solids	%	42.7
Pounds/Gallon	lbs/gal	8.61
Epoxy/Phenolic, solids	%	60/40
Volatile 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

	Units	Value
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

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Contact Information

For product prices, availability, or order placement, please contact customer service:

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