

## Starting Formulation

SF 2500

Clear Bake Coating

EPI-REZ™ Resin 3522-W-60

Formula	Material	Supplier	Pounds	Gallons
	EPI-REZ Resin 3522-W-60	Westlake Epoxy	637.50	69.29
<i>Thoroughly pre-mix the following and add to the above under gentle agitation.</i>				
	Cymel 324	Cytec Industries	53.1	5.71
	Butyl OXITOL™ Glycol Ether	Shell Chemical Co.	22.5	3.00
	2-Propoxyethanol		40.2	5.00
	BYK-301 Anti-cratering agent	BYK-Chemie USA	2.0	0.25
	Nacure XP333 (catalyst)	King Industries	2.75	0.37
<i>Blend thoroughly.</i>				
<i>Dissolve following by warming to 150 °F then add to above under agitation before allowing to cool.</i>				
	Dicyandiamide	Cytec Industries	13.5	0.41
	Deionized water		<u>133.0</u>	<u>15.97</u>
	Total Formulation		904.55	100.00

### Mixing Instructions

	Pounds	Gallons
Total Formulation	904.55	100.00

### Typical Formulation Table 1 / Formulation Properties Properties

	Units	Value
Nonvolatile content by weight	%	48.5
Nonvolatile content by volume	%	43.2
Weight per gallon	lb/gal	9.05
pH		7.0
Viscosity @ 25°C		
Total Formulation	KU	57
Water	lb/gal	388.0/46.5
Organics	lb/gal	62.7/8.00
	lb/gal	450.7/54.5

Generated: March 29, 2024  
Issue Date:  
Revision:

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## Volatile Organic Compounds (VOC)

Pounds/Gallon	lb/gal	1.46
Grams/Liter	g/L	175

Typical Film Properties Table 2 / Film Performance Properties <sup>1</sup>

	<u>Units</u>	<u>A</u>	<u>B</u>	<u>C</u>	<u>D</u>
Cure Schedule	min./°F	5/450	30/400	15/400	30/350
Reverse Impact	in.·lbs	160	160	160	160
Direct Impact	in.·lbs	160	160	160	160
MEK Rubs <sup>2</sup>		100 = HB	100 = 3H	100 = 2B	100 = 6B
Pencil Hardness		4H	5H	5H	4H
Adhesion		Excellent	Excellent	Excellent	Excellent

<sup>1</sup> Films cast #42 Myra Bar (0.75 mil.) or Bonderite 1000; 10 min. flash.

<sup>2</sup> Those greater than 400 F recover loss rapidly; those under 400 °F do not.

Films are subject to flash rusting at intrinsic pH. To avoid flash rusting pH may be adjusted to either 6.0 by addition of glacial acetic acid or to 9.0 by addition of dimethylethanolamine. <sup>1</sup>

Films will appear “seedy” after flashing and prior to baking.

<sup>1</sup> Supplied by Union Carbide Corp.

Table 3 / Stability Information

<u>Conditions</u>	<u>Coating</u>	<u>pH</u>	<u>Films</u>
1 week at 75 °F	Settles	7.2	OK
1 week at 125 °F	Settles	9.5	OK
2 weeks at 75 °F	Settles	7.8	OK
2 weeks at 125 °F	Settles	9.0	Unstable
Freeze / Thaw	4 cycles	7.0	OK

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at [www.westlakeepoxy.com](http://www.westlakeepoxy.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.

Exposure to these materials should be minimized and avoided, if feasible, through the observance of proper precautions, use of appropriate

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#### Contact Information

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

[www.westlakeepoxy.com/Contacts/](http://www.westlakeepoxy.com/Contacts/)

For literature and technical assistance, visit our website at [www.westlakeepoxy.com](http://www.westlakeepoxy.com)

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