



WPB-34 WITH ISOCYANATE FOR 2K CLEAR COATING AND DIRECT TO METAL

Part A	Wt. lb	Vol (gal)	lb/gal	% solids	solid lb	% Solvent	Solvent lb	Hydroxyl EW (g polymer / g Oh)	Eq No	wt%	R1S1	Actual Wt.	Actual %
WPB 34	442.38	50.535 47868	8.75385	38%	168.104 4	7%	32.2937 4	635	0.696 661417	50.92%	20.366 46563	20.659	51.26%
Water	72.96	8.75134 9406	8.337							8.40%	3.3589 61374	3.352	8.32%
Butyl Cellosolve	36.51	4.8550 69978	7.51997 4			99%	36.1449			4.20%	1.6808 61839	1.677	4.16%
Butyl Carbitol	36.51	4.6097 61179	7.92015			99%	36.1449			4.20%	1.6808 61839	1.696	4.21%
BYK 348	0.99	0.11255 711	8.7955 35	98%	0.9702					0.11%	0.0455 78012	0.046	0.11%
BYK 024	0.99	0.11757 2031	8.4203 7			4%	0.0396			0.11%	0.0455 78012	0.056	0.14%
PM Acetate	7.13	0.88167 3919	8.0868 9			99%	7.0587			0.82%	0.3282 53764	0.375	0.93%
IBIB	57.44	8.0582 08774	7.12813 5			98%	56.2912			6.61%	2.6444 45468	2.63	6.53%
Part A total	654.91	77.9216 7107	8.4047 22216		169.074 6		167.9730 4			75.38%	30.1510 0594	30.491	75.66%
Part B													
Wanhu a HT-100	213.93	22.4107 5062	9.5458 65	97%	207.512 1	3%	6.4179	205	1.0435 60976	24.62%	9.8489 94061	9.809	24.34%
Part B total	213.93	22.4107 5062	9.5458 65		207.512 1					24.62%	9.8489 94061	9.809	24.34%
Overall Total	868.84	100.33 24217	8.65961 3566	0.4334 36191	376.58 67		174.3909 4			100.00 %	40	40.3	100.00 %
cured @120 for 20 min								EW B/A ratio	1.4979 45702		VOC, gram/liter	208.48 39337	
*this ratio did not take account into the OH contribution of solvent in Part A											VOC lb/gal	1.738131 474	
VOC, gram/liter	208.48 39337										A/B mix ratio by vol.	3.47697 7295	
VOC lb/gal	1.738131 474										A/B mix ratio by wt.	3.06132 8472	
A/B mix ratio by vol.	3.47697 7295										Accelerated Cure style		
A/B mix ratio by wt.	3.06132 8472												

Properties and Results					
Viscosity (Premix/After)	Watery/hundred's range			Chemical Resistance :	
Physical Properties:	Steel	Aluminum	Plastic	Mek Rub	>200
	Direct Impact (lb)	>160	NA	NA	Oil
Reverse Impact (lb)	>160	NA	NA	10%HCL	NE
Dry Adhesion (ISO/ASTM)	0/5B	0/5B	0/5B	10%H2SO4	Minor ring stain, NFD
Wet Adhesion (24 hr soak+1 hour recovery)	0/5B	3/2B	NA	Ketchup	NE
Bending (in)	NE	NE	NE	Mustard	Yellow stain, NFD
Pencil Hardness	4H	4H	4H	MEK	very minor ring stain, NFD
Gloss (20/60)	78/93				

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