

# Starting Formulation

## SF 6021

### Ground Rubber Filled Trowelable Overlayment EPON™ Resin 8132 / EPIKURE™ Curing Agent 3164

**Introduction** This formulation is designed for applications requiring a tough, highly flexible overlayment that is resistant to impact and is not abrasive.

Formula	Material	Supplier	Pounds	Gallons
Resin Portion				
	EPON Resin 8132	Hexion	91	9.9
	HELOXY Modifier 505	Hexion	9	1.1
Converter Portion				
	EPIKURE Curing Agent 3164	Hexion	85.5	10.5
	EPIKURE Curing Agent 3253	Hexion	4.6	0.6
	Benzyl Alcohol		21.4	2.5
Ground rubber filler portion				
	Vistamer™ rubber RW 4004		52	5.4
	Vistamer rubber RW 4010		104	10.8
	Vistamer rubber RW 4060		104	10.8

**Compounding** Pre-blend the ground rubber components using a drum roller, Twin Shell Blender or similar equipment. The ground rubber, converter portion and the resin portion should each be blended until homogeneous and packaged separately until immediately before use.

Immediately before application, combine the converter portion and the resin portion until homogeneous. Drill powered stirrer, concrete mixer or other suitable device may be used. Blend the rubber and binder portions using a concrete mixer or similar equipment. Mix until rubber particles appear thoroughly wetted.

An induction time is not necessary for this formulation. Due to limited pot life, the mixed system should be applied immediately.

**Applications** Application to porous substrates may require the use of a primer. The binder may serve as a suitable primer when using an application rate of 100-400 square feet per gallon. The primer is best applied using either a squeegee or roller. Application surfaces should be clean and dry. Contaminants such as dust, dirt, grease and spalled or weakened concrete should be removed by etching, grinding or sandblasting for maximum performance. This system should be applied to substrates with surface temperatures at or above 23 °C (73 °F).

This coating can be best applied by trowel. Coverage rates depend on the application

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technique, substrate porosity, and intended function. Cure for a minimum of 16 hours at normal room temperature before opening to light traffic. Before exposure to heavy traffic, thorough curing for a minimum of 7 days at 72 °F or above is recommended.

Typical Handling Properties Table 1 / Handling Properties, binder

	<u>Units</u>	<u>Value</u>
Resin portion		
EPON Resin 8132	lbs	91
Heloxy Modifier 505	lbs	9
Converter portion		
EPIKURE Curing Agent 3164	lbs	85.5
EPIKURE Curing Agent 3253	lbs	4.6
Benzyl Alcohol	lbs	21.4
Viscosity at 25°C, system	cP	975
Pot life at 25 °C, 100g mass	min.	88

Typical Cured State Properties Table 1 / CuredStateProperties, binder

Dry film thickness	mils	2.6
Gardner impact, forward/reverse	in-lb	>160/>160
Pencil hardness		B
Gloss, reflectance at 85° viewing angle	%	107
Film properties		
1 day		Clear / SI tack
7 days		Clear / tack free
Tensile strength	psi	342
Tensile modulus	ksi	204
Tensile elongation	%	165
Water absorption <sup>1</sup>		
1 day	%	0.79
3 days	%	1.57
7 days	%	2.24

<sup>1</sup> Weight gain after immersion, Deionized water

Typical Cured State Properties Table 2 / CuredStateProperties, composite

	<u>Units</u>	<u>Value</u>
Resin portion		
EPON Resin 8132	lbs	91

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HELOXY Modifier 505	lbs	9
Converter portion		
EPIKURE Curing Agent 3164	lbs	85.5
EPIKURE Curing Agent 3253	lbs	4.6
Benzyl alcohol	lbs	21.4
Filler portion		
Vistamer™ rubber RW 4004	lbs	52
Vistamer rubber RW 4010	lbs	104
Vistamer rubber RW 4060	lbs	104
Tensile strength	psi	140
Tensile modulus	ksi	408
Tensile elongation	%	75

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

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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.

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