

Starting Formulation

SF 6019

Chemical Resistant Epoxy Clear Coating EPON™ Resin 828 / EPIKURE™ Curing Agent 3251

Introduction This epoxy formulation is designed for those applications that require a chemically resistant clear coating that cures at low temperatures (40-50 °F). This formulation offers high solids sprayability and resistance to a broad spectrum of chemicals, such as alkalis, dilute acids, aliphatic hydrocarbon solvents, salt solutions, sugar solutions, and greases.

Formula	Material	Supplier	Pounds	Gallons
Resin Portion				
	EPON Resin 828	Hexion	100	10.31
Converter Portion				
	EPIKURE Curing Agent 3251	Hexion	40	4.82

Compounding Blend resin portion into the converter portion and blend to a homogeneous state using proper agitation equipment. Avoid entrainment of excessive air in the blend during high speed agitation, but mix thoroughly by agitating at low or moderate speeds for 3 to 5 minutes. An induction time is not necessary for this formulation. Due to its limited pot life, apply this system immediately after mixing.

Remove surface contaminants such as dust, dirt, grease and weakened concrete laitance. For optimum performance and cure response, this system should be applied to substrates with surface temperatures above 5 °C (40 °F).

Compounding and Application This coating can be applied easily by spray, brush, paint roller, or squeegee. Coverage rates depend on the application technique, substrate porosity, and intended function, but for most applications and average thickness of 5 to 15 mils (320 to 110 square feet/gallon) is typical. Film weights at the low end of the range are for sealer applications and higher film weights are for finish coat applications. Cure for 12 to 16 hours at normal room temperature before opening to light traffic; a 2 to 3 day cure period should precede exposure to heavy traffic or corrosive chemicals.

Typical Handling Properties Table 1 / Handling Properties

	Units	Value
EPON Resin 828	phr	100
EPIKURE Curing Agent 3251	phr	40
Pot life @ 25°C, 100g mass	min.	16
Viscosity 25 °C, of mix	cP	2,300
Cure Schedule		7 days at 25 °C

Typical Performance Properties Table 1 / Performance Properties

Dry film thickness	mils	2.4
Impact, forward/reverse	in-lbs	40/40

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Pencil hardness		H
MEK double rub		54
Gloss 85°	%	94
Chemical Resistance ¹		
5% Acetic Acid		
1 day		0.1
7 days		0.3
30 days		1.0
Deionized Water		
1 day		0.1
7 days		0.2
30 days		0.6
50/50 IPA/Xylene		
1 day		8
7 days		19
30 days		N/R
10% NaOH		
1 day		0.1
7 days		0.2
30 days		0.5

¹ ASTM D 543-6, wt % gain

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at www.hexion.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 SDS 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 Safety Data Sheet (SDS) 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 SDSs on non-Hexion products should be obtained from the respective manufacturer.

Contact Information

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

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

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