

Starting Formulation

SF 4027 Room Volume Adhesive 815 3125 and 3055 and 3253 Room Temperature Cure, Equal Volume Adhesive

EPON™ Resin 815 / EPIKURE™ Curing Agent 3125, 3055, 3253

Introduction This is a general purpose epoxy thixotropic paste adhesive. It is designed for equal volume dispensing and is tolerant to mix-ratio variations which might occur in field applications. It also provides some tolerance to trace amounts of organic lubricants which may remain on metal bond surfaces when cleaning conditions are not ideal.

Suggested Uses Bonding of metals, wood and concrete at ambient temperatures, 25 °C or above.

Features One-to-one mix ratio by volume

Tolerance to trace/small amounts of organic oils on bond surfaces

Tolerant to mix-ratio variations

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPON Resin 815	Hexion	39.7	4.22
	Titanium Dioxide (TiO ₂)	Du Pont Co.	19.8	0.57
	Surfex MM	Diamond Shamrock Corp.	39.7	1.80
	Cab-O-Sil M-5	Cabot Corp.	<u>0.8</u>	<u>0.05</u>
		Total A	100.0	6.64
Part B				
	EPIKURE Curing Agent 3125	Hexion	29.0	3.58
	EPIKURE Curing Agent 3055	Hexion	5.8	0.73
	EPIKURE Curing Agent 3253	Hexion	3.6	0.44
	Titanium Dioxide	Du Pont Co.	18.1	0.52
	Surfex MM	Diamond Shamrock Corp.	29.0	1.31
	Cab-O-Sil M-5	Cabot Corp.	<u>0.8</u>	<u>0.05</u>
		Total B	86.3	6.63
		Total Part A & B	186.3	13.27

Mixing Instructions Blend the EPON Resin 815, TiO₂ and Surfex MM. Pass over a three-roll mill. Blend in the

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Cab-O-Sil.

Blend all the components except the Cab-O-Sil and pass over a three-roll mill. Then blend in the Cab-O-Sil. Before packaging, both portions should be evacuated.

Typical Handling Properties Table 1 / Handling Properties

	<u>Units</u>	<u>Value</u>
Weight per Gallon	lbs	14.04
Set Time at 25 °C	hrs	5
Cure at 25 °C		Overnight

Application Instructions Surfaces to be bonded should be free from oil, dirt, grease, etc.

Cured State Properties Table 2 / Cured State Properties ¹

Resin to Converter Ratio by Volume	Cure Schedule at 25 °C	Tensile Shear Strength, psi
1.5 to 1.0	24 hours	1,321
1.0 to 1.0	24 hours	2,377
0.5 to 1.0	24 hours	553
1.5 to 1.0	1 week	1,440
1.0 to 1.0	1 week	1,898
0.5 to 1.0	1 week	600

¹ Tensile Shear Strength(Aluminum to Aluminum)

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 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 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 Material Safety Data Sheet (MSDS) 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 MSDSs on non-Hexion products should be obtained from the respective manufacturer.

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