

Starting Formulation

SF 5001

Exposed Aggregate Matrix

EPON™ Resin 828 / HELOXY™ Modifiers 505 and 8 / EPIKURE™ Curing Agent 3295

Introduction This thixotropic matrix is designed for exposed aggregate facings. The addition of Attagel 40 provides an unusual combination of sag resistance and non-stick troweling. HELOXY Modifier 505 imparts a high level of thermal shock resistance.

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPON Resin 828	Hexion	60	6.46
	HELOXY Modifier 505	Hexion	35	4.15
	HELOXY Modifier 8	Hexion	5	0.62
	D-Limonene	Fritzsche Brothers Co.	2	0.28
	DC-200 Fluid	Dow-Corning Corp.	0.005	0.001
	Titanium Dioxide R-101	Du Pont Co.	20	0.57
	Calcium Carbonate, #1 White	Thompson, Weinman & Co.	74	3.29
	Attagel 40	Engelhard Minerals & Chemicals Co.	<u>20</u>	<u>1.02</u>
	Total Part A		216.005	15.391
Part B				
	EPIKURE 3295 Curing Agent	Hexion	<u>18</u>	<u>2.166</u>
	Total Part B		18	2.166

Mixing Instructions Weigh EPON Resin 828, HELOXY Modifier 505, HELOXY Modifier 8, D-Limonene and DC-200 Fluid into a mixing tank and blend with low speed agitation. Add the calcium carbonate and a preground paste of titanium dioxide, or other pigment, dispersed in a portion of the EPON Resin 828, and mix with low speed agitation (1400 rpm or less). Add Attagel 40 and continue blending with low speed agitation until homogeneous. Since this material increases in thixotropy at elevated temperatures, compounding is easier if the heat build-up due to mixing is minimized. Since the thixotropy that develops when the Attagel 40 is dispersed is a function of shearing force, higher speeds or higher shear blending develops greater thixotropy. Therefore, the amount of Attagel 40 may have to be optimized for the specific blending equipment available.

Typical Handling Properties Table 1 / Typical Properties

	Units	Value
Combining Ratio (resin/converter)	by weight	12 : 1
	by volume	7.5 : 1

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Pounds/Gallon		
Resin Portion	lbs/gal	13.2
Converter Portion	lbs/gal	8.3
Combined System	lbs/gal	12.8
Form		
Resin Portion	soft thixotropic consistency	
Converter Portion	low viscosity liquid	
Handling Properties		
Expected Pot Life, 1-quart	min	50 - 60
Set Time, 1/4-inch thick	hrs	3 - 4

Application Instructions Thoroughly blend the resin and converter portions as designated; preferably using a power driven agitator. Add 1 volume of sand to 2 volumes of the resin/converter mix and disperse uniformly with a KOL Mixal, drill motor powered agitator, or other suitable equipment. Trowel the matrix formulation onto the clean building facing, (sandblasting is the preferred cleaning method) approximately 1/8- to 1/4-inch thick. Then lightly press the loose aggregate or blow it into the matrix. A "Little Jigger" applicator, which utilizes a vibrating foam pad with hopper feed to embed the aggregate into the mastic can be used for this purpose.

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at www.hexion.com

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