

Starting Formulation

SF 6018

Chemical Resistant Epoxy Glaze EPON™ Resin 828 / EPIKURE™ Curing Agent 3383

Introduction This epoxy formulation is designed for industrial flooring and sealer coatings that require a chemically resistant coating.

Formula	Material	Supplier	Pounds	Gallons
Resin Portion				
	EPON Resin 828	Hexion	100	10.31
	Total Resin Portion		100	10.31
Converter Portion				
	EPIKURE Curing Agent 3383	Hexion	60	7.06
	Total Converter Portion		18	2.17

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 23 °C (73 °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. Because of the chemical composition of this system, films cured at or below normal room temperature will produce a "sweat out" at the exposed surface. This will not affect the performance characteristics.

Typical Handling Properties Table 1 / Handling Properties

	Units	Value
Composition		PHR
EPON Resin 828	phr	100
EPIKURE Curing Agent 3383	phr	60

Generated: October 21, 2021
Issue Date:
Revision:

© and ™ Licensed trademarks of Hexion Inc.

DISCLAIMER

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.

Handling Properties

Pot life at 25°C, 100 g mass	min.	47
Viscosity at 25°C	cP	1,500
Cure Schedule	days / °C	7 / 25

Typical Cured State Properties Table 2 / Cured state properties

Cured State Properties

Dry film thickness	mils	2.8
Impact, forward/reverse	in-lbs	20/20
Pencil hardness		H
MEK double rub		>100
Gloss, 85°	%	93
Dry Times, 25 °C, 50% R.H.		
Dust-free	hrs	3
Touch-dry	hrs	4.25
Through-dry	hrs	5.25

Film Properties

25 °C, 50% R.H.

1 day clear / tack-free

4.4 °C, 50% R.H.

1 day clear/tacky

7 days clear/tacky

Hardness

25 °C, 50% R.H.

1 day 70

7 days 82

4 °C, 80% R.H.

1 day 33

7 days 73

Chemical Resistance ¹

5% Acetic Acid

1 day % 0.5

7 days % 1.5

30 days % 2.5

Deionized Water

1 day % 0.2

Generated: October 21, 2021
Issue Date:
Revision:

© and ™ Licensed trademarks of Hexion Inc.

DISCLAIMER

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.

1 day	%	0.3
7 days	%	0.9
30 days	%	1.7
50/50 IPA/Xylene		
1 day	%	1.0
7 days	%	4.1
30 days	%	7.7
10% NaOH		
1 day	%	0.3
7 days	%	0.9
30 days	%	1.6

¹ Immersion, % wt gain, ASTM D 543-67

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.

Contact Information

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

www.hexion.com/Contacts/

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

Generated: October 21, 2021
Issue Date:
Revision:

© and ™ Licensed trademarks of Hexion Inc.

DISCLAIMER

The information provided herein was believed by Hexion Inc. ("Hexion") to be accurate at the time of preparation or prepared from sources believed to be reliable, but it is the responsibility of the user to investigate and understand other pertinent sources of information, to comply with all laws and procedures applicable to the safe handling and use of the product and to determine the suitability of the product for its intended use. All products supplied by Hexion are subject to Hexion's terms and conditions of sale. HEXION MAKES NO WARRANTY, EXPRESS OR IMPLIED, CONCERNING THE PRODUCT OR THE MERCHANTABILITY OR FITNESS THEREOF FOR ANY PURPOSE OR CONCERNING THE ACCURACY OF ANY INFORMATION PROVIDED BY HEXION, except that the product shall conform to Hexion's specifications. Nothing contained herein constitutes an offer for the sale of any product.