

Starting Formulation

SF 4026 Metal Adhesive 828 3253 Metal Adhesive

EPON™ Resin 828 / EPIKURE™ Curing Agent 3253

Introduction This adhesive is designed for bonding metal to metal.

Suggested Uses Bonding of metals, at 25 to 100 °C temperatures. It will also bond to concrete, glass and many rigid plastics.

Features Ability to bond to various metal substrates
 Fast cure (15 minutes) can be achieved at 93 °C (200 °F)
 Cures to handling strength in 4 to 5 hours at 25 °C (77 °F)

Formula	Material	Supplier	Pounds	Gallons
Part A				
	EPON Resin 828	Hexion	50.0	5.15
	Surfex M.M.	Diamond Shamrock Corp.	<u>50.0</u>	<u>2.26</u>
		Total A	100.0	7.41
Part B				
	Thiokol LP-3		25.0	2.36
	EPIKURE Curing Agent 3253	Hexion	<u>5.0</u>	<u>0.61</u>
		Total B	30.0	2.97
		Total Part A & B	130.0	10.38

Mixing Instructions Blend the resin portion thoroughly. Next, blend the converter portion. Prior to use, mix the two combinations together and blend thoroughly.

Typical Handling Properties Table 1 / Handling Properties

	Units	Value
Viscosity		Paste
Pounds/Gallon	lbs/gal	12.53
Expected Pot Life, one pound batch	mion	30

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Application Instructions All surfaces to be bonded must be free of all oil and dirt. Apply the adhesive 0.005 inch thick on materials to be bonded. Press wet surfaces together and apply weight to assure that there is not any slippage. Adhesives may be applied by brush or trowel. This formulation will cure to handling strength at room temperature in approximately 4 to 5 hours. This adhesive may also be oven-cured at 93 °C in 15 to 20 minutes.

Cured Properties Table 2 / Cured State Properties

Shear Strength, psi	Aluminum to Aluminum	Stainless to Aluminum
at 25 °C	1,480	1,884
at 93 °C	1,464	1,847
at 121 °C	1,000	–

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

General Information

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Safety, Storage & Handling

Please refer to the MSDS for the most current Safety and Handling information.

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