

Starting Formulation

SF 6004

Epoxy Glaze Coat for Seamless Flooring

EPON™ Resin 828 / HELOXY™ Modifier 8 / EPIKURE™ Curing Agent 3370

Introduction This low viscosity epoxy system has been designed as a sealer, glaze or finish coat for seamless industrial flooring. It exhibits good physical strength properties and better chemical resistance than aliphatic amine cured systems.

Formula	Material	Supplier	Pounds	Gallons
Resin Portion				
	EPON Resin 828	Hexion	92.0	9.58
	HELOXY Modifier 8	Hexion	<u>8.0</u>	<u>1.08</u>
	Total Resin Portion		100.0	10.66
Converter Portion				
	EPIKURE Curing Agent 3370	Hexion	37.0	4.43

Compounding Mix the resin and converter portions and blend to a homogeneous state with proper agitation equipment. Avoid entrainment of excessive air into the blend with high speed agitation but insure thorough mixing by agitating at low or moderate speeds for 3 to 5 minutes.

There is no induction time for this formulation. Due to its limited pot life, this system should be applied immediately after mixing. The surface to be coated must be free of dust, dirt, grease, or weakened concrete laltance. The surface temperature of the substrate to be coated should be at a minimum of 23 °C. A uniform glaze, sealer, or finish coating can be applied easily with a brush, paint roller, or squeegee.

Coverage rates depend on the application technique, substrate porosity, and intended function. but for most applications an 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 glaze and 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 and Reactivity

	Units	Value
Resin/Converter Combining Ratio	by weight	100 : 37
	by volume	2.4 : 1
Blend Properties at 25 °C		
Viscosity, Initial	cP	1,050
Expected Pot Life, 100 gram mass	min	30

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Cured State Properties¹

Tensile Strength	psi	10,350
Tensile Modulus	10 ⁶ psi	0.47
Tensile Elongation	%	4.2
Izod Impact, notch	ft•lb/inch	0.49
Hardness	Shore D	89
Heat Deflection Temperature	°C	53
Tabor Abrasion, wear index ²	mg/cycle	49.8

Chemical Resistance³

Immersion	Units	Water	5% Acetic Acid	Xylene
1 day	%	0.09	0.23	0.08
1 week	%	0.40	0.71	0.38
2 weeks	%	0.59	0.96	0.46
3 weeks	%	0.70	1.16	0.65
4 weeks	%	0.83	1.36	0.80

¹ System was cured for 7 days at 25 °C

² Determined by 1000 cycles with CS-10 wheels

³ Percent weight gain of 3 inch x 1 inch x 1/8 inch specimens Immersed at 25 °C

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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