

# Starting Formulation

## SF 5005

### Equal Volume White Tile Cement EPON™ Resin 828 / EPIKURE™ Curing Agent 3055

Formula	<u>Material</u>	<u>Supplier</u>	<u>Pounds</u>	<u>Gallons</u>
Part A				
	EPON Resin 828	Hexion	68.03	7.01
	Bentone 27	Rheox, Inc.	4.76	0.32
	Methyl Alcohol	Union Carbide Corp.	1.36	0.21
	Titanium Dioxide	Du Pont Co.	6.80	0.19
	Calcium Carbonate	Diamond Shamrock Corp.	19.05	0.86
	Ultramarine Blue	Standard Ultramarine Co.	<u>0.0068</u> <sup>1</sup>	
	Total Part A		100.0068	8.59
Part B				
	EPIKURE Curing Agent 3055	Hexion	40.82	5.17
	Bentone 27	Rheox, Inc.	2.72	0.18
	Methyl Alcohol	Union Carbide Corp.	0.68	0.10
	Titanium Dioxide	Du Pont Co.	6.80	0.19
	Calcium Carbonate	Diamond Shamrock Corp.	<u>65.31</u>	<u>2.96</u>
	Total Part B		116.33	8.60
	Total Part A & B		216.3368	17.19

#### Mixing Instructions Resin Portion

Blend Bentone 27 and Methyl Alcohol, and add this mixture to the EPON Resin 828, Calcium Carbonate, Titanium Dioxide, and Ultramarine Blue. Blend thoroughly. Pass over a three roll paint mill until desired viscosity is obtained. (See Handling Properties)

#### Converter Portion

Blend Bentone 27 and Methyl Alcohol, and add this mixture to the EPIKURE Curing Agent 3055, Titanium Dioxide, and Calcium Carbonate. Blend thoroughly. Pass over a three roll paint mill until the desired viscosity is obtained. (See Handling Properties)

#### Typical Formulation Table 1 / Formulation Properties Properties

	<u>Units</u>	<u>Value</u>
Weight per Gallon, combined system	lbs.	12.58
Expected Pot life at 77 °F, 1/2 pound batch	hrs	2

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Expected Pot life at 77 °F, 1/2 pound batch	Spindle No.	RPM	Viscosity at 77 °F, Brookfield Helipath
Resin Portion	T - F	1	3,600,000
	T - F	2.5	2,400,000
	T - F	5	1,560,000
Converter Portion	T - F	1	1,250,000
	T - F	2.5	992,000
	T - F	5	716,000
Resin and Converter Portion	T - F	1	1,360,000
	T - F	2.5	994,000
	T - F	5	650,000

Typical Properties Table 2 / Physical Properties

	Units	Value
Hardness, Shore D	Shore D	83
Shear Strength	psi	1,896
Water Absorption at 77 °F, 24 hours	%	0.29

Storage Recommendations regarding storage conditions can be obtained by visiting our web site at [www.hexion.com](http://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.

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Contact Information

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

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For literature and technical assistance, visit our website at [www.hexion.com](http://www.hexion.com)

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