

Starting Formulation

SF 4020 One-Package Cure Adhesive 828 One-Package Rapid Cure Adhesive EPON™ Resin 828

Introduction This accelerated one-package Epoxy/DICY adhesive, properly formulated, can yield over three months pot life when stored at normal room temperature, yet develops good bond strengths on relatively short cure schedules of 30 minutes at 149 °C or 40 minutes at 135 °C.

- Suggested Uses**
- Automotive trim adhesives
 - Aircraft adhesives
 - General purpose industrial use

Formula	Material	Supplier	Pounds	Gallons
	EPON Resin 828	Hexion	100	10.31
	Dicyandiamide (DICY)	Dicy, SKW Corporation	10	0.75
	Bentone 27	Rheox, Inc.	10	0.75
	Tetramethyl Ammonium Chloride	Distillation Products Industries	3	0.34
	Calcium Carbonate No. 1 White	Thompson, Weinman & Company	<u>50</u>	<u>2.22</u>
		Total	173	14.48

Mixing Instructions Blend all ingredients and pass at least twice over a three-roll mill for thorough dispersion of the powdered DICY, Accelerator and Bentone 27.

Typical Handling Properties Table 1 / Handling Properties

	Units	Value
Form		Thixotropic Paste
Denisty	lbs/gal	11.9
Expected pot life at 25 °C	months	> 3

Application Instructions All surfaces to be bonded should be free of dirt, oil, grease, or other contaminants to insure maximum adhesion. Apply adhesive to both surfaces to be bonded and cure at 135 °C or above. Contact pressure is adequate for development of maximum bond strength.

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,

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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

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

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