Starting Formulation

SF 4022 One-Package Adhesive 828 Dicyandiamide One-Package Adhesive

EPON™ Resin 828 / Dicyandiamide

Introduction
This is a simple one-package epoxy adhesive especially suited for metal – metal bonding which will yield a shelf life of at least 6 months at 25°C.

Suggested Uses
- Cost sensitive applications where a one-component adhesive is desired and the substrate to be bonded are capable of withstanding the high temperature cure conditions.

Features
- One Pack
- Economical
- Service temperature up to 150°C

Formula

<table>
<thead>
<tr>
<th>Part A</th>
<th>Material</th>
<th>Supplier</th>
<th>phr</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>EPON Resin 828</td>
<td>Hexion</td>
<td>100</td>
<td>76.9</td>
<td>7.92</td>
</tr>
<tr>
<td></td>
<td>Alumina T-60/T-64 (ground tabular alumina)</td>
<td>Acoa World Chemicals</td>
<td>20</td>
<td>15.4</td>
<td>0.52</td>
</tr>
<tr>
<td></td>
<td>Cab-O-Sil TS-720 (fumed silica)</td>
<td>Cabot Corporation</td>
<td>10</td>
<td>7.7</td>
<td>0.51</td>
</tr>
<tr>
<td></td>
<td>Total A</td>
<td></td>
<td>130</td>
<td>100.0</td>
<td>8.95</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Part B</th>
<th>Material</th>
<th>Supplier</th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Dyhard 100SF (micronized)</td>
<td>Degussa Corp. – Fine Chemicals Div.</td>
<td>6</td>
<td>4.6</td>
<td>0.39</td>
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<tr>
<td></td>
<td>Total B</td>
<td></td>
<td>136</td>
<td>104.6</td>
<td>9.34</td>
</tr>
<tr>
<td></td>
<td>Total Part A &amp; B</td>
<td></td>
<td>266</td>
<td>204.6</td>
<td>18.29</td>
</tr>
</tbody>
</table>

Mixing Instructions
Evenly disperse all components in the EPON Resin 828, and then pass the compound over a three-roll paint mill for two cycles. Alternatively, a high speed mixer (such as Cowles) can be used; however, care should be taken to keep temperature as low as possible. Temperature should be kept below 45°C (115°F).

This formulation is a basic starting point and can be modified with other filler types, such as talc, clay, alumina, ground silica, wollastonite, or calcium carbonate.

Typical Handling Table 1 / Handling Properties

<table>
<thead>
<tr>
<th>Properties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
</table>

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**Application**

All surfaces to be bonded should be clean and free of dust, dirt, grease, oil or other contaminants. For optimum adhesion it is recommended to roughen bonding surfaces. This can be accomplished with abrasive media appropriate for the materials being bonded (such as medium grit emery paper, abrasive disks, grit blasting, wire brushes, etc.) Abrasion should always be followed by degreasing to remove contaminants and loose particles. Chemical etching is another method to provide a rough surface for improved adhesion.

**Instructions**

Apply by spreading a thin film approximately 0.005 inch thick over the surface to be bonded. Maintain light pressure during cure for optimum bonding.

**Cure Schedule**

1.0 – 1.5 hours @ 177°C (350°F); not less than 50 minutes @ 177°C (350°F)

**Typical Cured State**

Table 1 / Adhesive Properties – Aluminum

<table>
<thead>
<tr>
<th>Test Property</th>
<th>Substrate</th>
<th>ASTM</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tensile Shear Strength @ 25°C (77°F)</td>
<td>Aluminum</td>
<td>D-1002</td>
<td>psi</td>
<td>2,630</td>
</tr>
<tr>
<td>Pure Tensile Strength @ 25°C (77°F)</td>
<td></td>
<td></td>
<td>psi</td>
<td>3,555</td>
</tr>
</tbody>
</table>

**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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