Starting Formulation

SF 6000
Epoxy Thin-Set Terrazzo Flooring
EPON™ Resin 828 / HELOXY™ Modifiers 505 and 8 / EPIKURE™ Curing Agent 3295

Introduction
A premium quality, flexibilized, thin-set terrazzo formulation offering all of the advantages associated with epoxy terrazzo as well as several improved features.

Features
- Permanent, high strength bonds to substrate
- Light weight at 1/4” thickness is important consideration in high rise buildings
- Can be ground after overnight cure, eliminating the 4 to 7 day delay in finishing cementitious terrazzo
- Matrix polishes to high gloss and resists staining more than cementitious terrazzo
- Tough, flexible matrix system – 18% ultimate tensile elongation
- No non-reactive, migrating extenders or diluents used
- High impact strength – >16 ft-lb
- Good air release characteristics
- Good color retention for epoxy compound

Formula
Material | Supplier | Pounds | Gallons
--- | --- | --- | ---
Resin Portion | | | |
EPON Resin 828 | Hexion | 60 | 6.22
HELOXY Modifier 505 | Hexion | 35 | 4.12
HELOXY Modifier 8 | Hexion | 5 | 0.67
Titanium Dioxide R-101 | Du Pont Co. | 5 | 0.14
DC-200 Fluid, 100 centistokes grade | Dow-Corning Corp. | 0.007 | 0.001
Total Resin Portion | | 105.007 | 11.151
Converter Portion
EPIKURE Curing Agent 3295 | Hexion | 18 | 2.17
Total Converter Portion | | 18 | 2.17
Filler Portion
No. 40-200 Marble Dust | Georgia Marble Co. | 185 | 8.19
Thin-Set Marble Chip Blend #0 & #1 sizes | Georgia Marble Co. | 369 | 16.33
Total Filler Portion | | 554 | 24.52

Typical Handling Properties

<table>
<thead>
<tr>
<th></th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Density, Filled</td>
<td>lbs/gal</td>
<td>17.91</td>
</tr>
<tr>
<td>Density, Unfilled</td>
<td>lbs/gal</td>
<td>9.26</td>
</tr>
</tbody>
</table>

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### Properties of Unfilled Epoxy Binder

<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hardness</td>
<td>Shore D</td>
<td>77</td>
</tr>
<tr>
<td>Ultimate Tensile Strength</td>
<td>psi</td>
<td>5,200</td>
</tr>
<tr>
<td>Tensile Elongation</td>
<td>%</td>
<td>18</td>
</tr>
<tr>
<td>Ultimate Flexural Strength</td>
<td>psi</td>
<td>8,500</td>
</tr>
</tbody>
</table>

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Properties of Terrazzo Table 3 / Properties of Terrazzo

<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Impact Resistance, Falling Ball</td>
<td></td>
<td>No failure at 16 ft•lb</td>
</tr>
<tr>
<td>Flexural Strength</td>
<td>psi</td>
<td>3,500</td>
</tr>
<tr>
<td>Flammability, ASTM-D-635</td>
<td></td>
<td>Self-extinguishing</td>
</tr>
<tr>
<td>Tabor Abrasion, loss per 1000 rev</td>
<td>mg</td>
<td>97.9</td>
</tr>
<tr>
<td>Tensile Bond Strength, concrete substrate</td>
<td>psi</td>
<td>&gt;300</td>
</tr>
<tr>
<td>Coefficient of Linear Thermal Expansion</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Temp. range: -25 to 60 °C</td>
<td>in./in./ °C</td>
<td>49 x 10^6</td>
</tr>
<tr>
<td>Resistance to Elevated Temperatures</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Per ML D 3134F, Section 3.10</td>
<td></td>
<td>No slip of flow at 70 °C</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

1 Cure Schedule - 20 hours at 25 °C plus 4 hours at 70 °C
2 Test Method ERF 12-64, mold size #1 (195 ml.).
3 Percent Weight Gained after 7 days immersion

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.

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