Starting Formulation

SF 6021

Ground Rubber Filled Trowelable Overlayment
EPON™ Resin 8132 / EPIKURE™ Curing Agent 3164

Introduction
This formulation is designed for applications requiring a tough, highly flexible overlayment that is resistant to impact and is not abrasive.

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Resin Portion</td>
<td>EPON Resin 8132</td>
<td>Hexion</td>
<td>91</td>
<td>9.9</td>
</tr>
<tr>
<td></td>
<td>HELOXY Modifier 505</td>
<td>Hexion</td>
<td>9</td>
<td>1.1</td>
</tr>
<tr>
<td>Converter Portion</td>
<td>EPIKURE Curing Agent 3164</td>
<td>Hexion</td>
<td>85.5</td>
<td>10.5</td>
</tr>
<tr>
<td></td>
<td>EPIKURE Curing Agent 3253</td>
<td>Hexion</td>
<td>4.6</td>
<td>0.6</td>
</tr>
<tr>
<td></td>
<td>Benzyl Alcohol</td>
<td></td>
<td>21.4</td>
<td>2.5</td>
</tr>
<tr>
<td>Ground rubber filler portion</td>
<td>Vistamer™ rubber RW 4004</td>
<td></td>
<td>52</td>
<td>5.4</td>
</tr>
<tr>
<td></td>
<td>Vistamer rubber RW 4010</td>
<td></td>
<td>104</td>
<td>10.8</td>
</tr>
<tr>
<td></td>
<td>Vistamer rubber RW 4060</td>
<td></td>
<td>104</td>
<td>10.8</td>
</tr>
</tbody>
</table>

Compounding
Pre-blend the ground rubber components using a drum roller, Twin Shell Blender or similar equipment. The ground rubber, converter portion and the resin portion should each be blended until homogeneous and packaged separately until immediately before use.

Immediately before application, combine the converter portion and the resin portion until homogeneous. Drill powered stirrer, concrete mixer or other suitable device may be used. Blend the rubber and binder portions using a concrete mixer or similar equipment. Mix until rubber particles appear thoroughly wetted.

An induction time is not necessary for this formulation. Due to limited pot life, the mixed system should be applied immediately.

Applications
Application to porous substrates may require the use of a primer. The binder may serve as a suitable primer when using an application rate of 100-400 square feet per gallon. The primer is best applied using either a squeegee or roller. Application surfaces should be clean and dry. Contaminants such as dust, dirt, grease and spalled or weakened concrete should be removed by etching, grinding or sandblasting for maximum performance. This system should be applied to substrates with surface temperatures at or above 23 °C (73 °F).

This coating can be best applied by trowel. Coverage rates depend on the application.
This coating can be best applied by trowel. Coverage rates depend on the application technique, substrate porosity, and intended function. Cure for a minimum of 16 hours at normal room temperature before opening to light traffic. Before exposure to heavy traffic, thorough curing for a minimum of 7 days at 72 °F or above is recommended.

### Typical Handling Properties

<table>
<thead>
<tr>
<th></th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Resin portion</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>EPON Resin 8132</td>
<td>lbs</td>
<td>91</td>
</tr>
<tr>
<td>Heloxy Modifier 505</td>
<td>lbs</td>
<td>9</td>
</tr>
<tr>
<td><strong>Converter portion</strong></td>
<td></td>
<td></td>
</tr>
<tr>
<td>EPIKURE Curing Agent 3164</td>
<td>lbs</td>
<td>85.5</td>
</tr>
<tr>
<td>EPIKURE Curing Agent 3253</td>
<td>lbs</td>
<td>4.6</td>
</tr>
<tr>
<td>Benzyl Alcohol</td>
<td>lbs</td>
<td>21.4</td>
</tr>
<tr>
<td>Viscosity at 25°C, system</td>
<td>cP</td>
<td>975</td>
</tr>
<tr>
<td>Pot life at 25 °C, 100g mass</td>
<td>min.</td>
<td>88</td>
</tr>
</tbody>
</table>

### Typical Cured State Properties

<table>
<thead>
<tr>
<th></th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Dry film thickness</strong></td>
<td>mils</td>
<td>2.6</td>
</tr>
<tr>
<td><strong>Gardner impact</strong>, forward/reverse</td>
<td>in-lb</td>
<td>&gt;160/&gt;160</td>
</tr>
<tr>
<td><strong>Pencil hardness</strong></td>
<td></td>
<td>B</td>
</tr>
<tr>
<td><strong>Gloss, reflectance at 85° viewing angle</strong></td>
<td>%</td>
<td>107</td>
</tr>
</tbody>
</table>

#### Film properties

<table>
<thead>
<tr>
<th>Day</th>
<th>Status</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 day</td>
<td>Clear / SItack</td>
<td></td>
<td></td>
</tr>
<tr>
<td>7 days</td>
<td>Clear / tack free</td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Tensile strength</strong></td>
<td>psi</td>
<td>342</td>
<td></td>
</tr>
<tr>
<td><strong>Tensile modulus</strong></td>
<td>ksi</td>
<td>204</td>
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</tr>
<tr>
<td><strong>Tensile elongation</strong></td>
<td>%</td>
<td>165</td>
<td></td>
</tr>
</tbody>
</table>

#### Water absorption

<table>
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<th>Day</th>
<th>%</th>
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<tbody>
<tr>
<td>1</td>
<td>0.79</td>
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<td>3</td>
<td>1.57</td>
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<tr>
<td>7</td>
<td>2.24</td>
</tr>
</tbody>
</table>

1 Weight gain after immersion, Deionized water

### Typical Cured State Properties (composite)

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<tr>
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<td>91</td>
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<table>
<thead>
<tr>
<th>Component</th>
<th>Quantity</th>
</tr>
</thead>
<tbody>
<tr>
<td>HELOXY Modifier 505</td>
<td>9 lbs</td>
</tr>
<tr>
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<td>EPIKURE Curing Agent 3164</td>
<td>85.5 lbs</td>
</tr>
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<td>EPIKURE Curing Agent 3253</td>
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**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.

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