Starting Formulation

SF 5001

Exposed Aggregate Matrix

EPON™ Resin 828 / HELOXY™ Modifiers 505 and 8 / EPIKURE™ Curing Agent 3295

Introduction This thixotropic matrix is designed for exposed aggregate facings. The addition of Attagel 40 provides an unusual combination of sag resistance and non-stick troweling. HELOXY Modifier 505 imparts a high level of thermal shock resistance.

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>EPON Resin 828</td>
<td>Hexion</td>
<td>60</td>
<td>6.46</td>
</tr>
<tr>
<td></td>
<td>HELOXY Modifier 505</td>
<td>Hexion</td>
<td>35</td>
<td>4.15</td>
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<tr>
<td></td>
<td>HELOXY Modifier 8</td>
<td>Hexion</td>
<td>5</td>
<td>0.62</td>
</tr>
<tr>
<td></td>
<td>D-Limonene</td>
<td>Fritzschel Brothers Co.</td>
<td>2</td>
<td>0.28</td>
</tr>
<tr>
<td></td>
<td>DC-200 Fluid</td>
<td>Dow-Corning Corp.</td>
<td>0.005</td>
<td>0.001</td>
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<tr>
<td></td>
<td>Titanium Dioxide R-101</td>
<td>Du Pont Co.</td>
<td>20</td>
<td>0.57</td>
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<tr>
<td></td>
<td>Calcium Carbonate, #1 White</td>
<td>Thompson, Woinman &amp; Co.</td>
<td>74</td>
<td>3.29</td>
</tr>
<tr>
<td></td>
<td>Attagel 40</td>
<td>Engelhard Minerals &amp; Chemicals Co.</td>
<td>20</td>
<td>1.02</td>
</tr>
<tr>
<td></td>
<td>Total Part A</td>
<td></td>
<td>216.005</td>
<td>15.391</td>
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</table>

Part B

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>EPIKURE 3295 Curing Agent</td>
<td>Hexion</td>
<td>18</td>
<td>2.160</td>
</tr>
<tr>
<td></td>
<td>Total Part B</td>
<td></td>
<td>18</td>
<td>2.160</td>
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</tbody>
</table>

Mixing Instructions Weigh EPON Resin 828, HELOXY Modifier 505, HELOXY Modifier 8, D-Limonene and DC-200 Fluid into a mixing tank and blend with low speed agitation. Add the calcium carbonate and a pregndound paste of titanium dioxide, or other pigment, dispersed in a portion of the EPON Resin 828, and mix with low speed agitation (1400 rpm or less). Add Attagel 40 and continue blending with low speed agitation until homogeneous. Since this material increases in thixotropy at elevated temperatures, compounding is easier if the heat build-up due to
mixing is minimized. Since the thixotropy that develops when the Attagel 40 is dispersed is a function of
shearing force, higher speeds or higher shear blending develops greater thixotropy. Therefore, the amount of
Attagel 40 may have to be optimized for the specific blending equipment available.

Typical Handling Properties Table 1 / Typical Properties

<table>
<thead>
<tr>
<th></th>
<th>Units</th>
<th>Value</th>
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</thead>
<tbody>
<tr>
<td>Combining Ratio [resin/converter]</td>
<td>by weight</td>
<td>12 : 1</td>
</tr>
<tr>
<td></td>
<td>by volume</td>
<td>7.5 : 1</td>
</tr>
<tr>
<td>Pounds/Gallon</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Resin Portion</td>
<td>lbs/gal</td>
<td>13.2</td>
</tr>
<tr>
<td>Converter Portion</td>
<td>lbs/gal</td>
<td>8.3</td>
</tr>
<tr>
<td>Combined System</td>
<td>lbs/gal</td>
<td>12.8</td>
</tr>
<tr>
<td>Form</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Resin Portion</td>
<td>soft thixotropic consistency</td>
<td></td>
</tr>
<tr>
<td>Converter Portion</td>
<td>low viscosity liquid</td>
<td></td>
</tr>
<tr>
<td>Handling Properties</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Expected Pot Life, 1-quart</td>
<td>min</td>
<td>50 - 60</td>
</tr>
<tr>
<td>Set Time, 1/4-inch thick</td>
<td>hrs</td>
<td>3 - 4</td>
</tr>
</tbody>
</table>

Application Instructions Thoroughly blend the resin and converter portions as designated; preferably using a power-driven agitator. Add
1 volume of sand to 2 volumes of the resin/converter mix and disperse uniformly with a KDL Mixal, drill-rod powered agitator, or other suitable equipment. Trowel the matrix formulation onto the clean building facing,
(sandblasting is the preferred cleaning method) approximately 1/8- to 1/4-inch thick. Then lightly press the
loose aggregate or blow it into the matrix. A “Little Jigger” applicator, which utilizes a vibrating foam pad with
hopper feed to embed the aggregate into the mastic can be used for this purpose.

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

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