Starting Formulation

SF 4021 Economical One-Package Adhesive 828 BF Catalyst Economical One-Package Adhesive

EPON™ Resin 828 / BF3 Amine Catalyst

Introduction
This one-package adhesive, which requires a high temperature curing schedule, can yield relatively long shelf life at room temperature.

Suggested Uses
- Cost sensitive applications where a one-component adhesive is desired and a heat cure is available.

Features
- One Pack
- Economical
- Service temperature up to 100°C

Formula | Material | Supplier | Pounds | Gallons
---|---|---|---|---
Part A | EPON Resin 828 | Hexion | 50.0 | 5.170
| ExCAL W3 (ground calcium carbonate) | Excalibar Minerals Inc. | 48.0 | 2.160
| Cab-O-Sil TS-720 (fumed silica) | Cabot Corporation | 2.0 | 0.114
| Total A | | 100.0 | 7.444

Part B | Leecure 38-239B (BF3 amine catalyst) | Leepoxy Plastics, Inc. | 1.5 | ---
| Total B | | 1.5 | ---
| Total Part A & B | | 101.5 | 7.444

Mixing Instructions
Preheat Leecure 38-239B catalyst to 35°C.
Disperse Leecure 38-239B into EPON Resin 828 using a high shear mixer, such as a single shat, high speed disperser with high shear impeller. Heating to a temperature of 35 – 40°C will aid mixing. Planetary mixers can also be used.
Disperse the Cab-O-Sil TS-720 and ExCAL W3 into the resin blend, using the same dispersing equipment, until a smooth, uniform dispersion is achieved.

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.

Modification with silane coupling agents, such as Z-6040 EpoxySilane from Dow-Corning improves bonds to concrete and glass.
Typical Handling Table 1 / Handling Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Expected Shelf Life @ 25°C (77°F)</td>
<td>months</td>
<td>4</td>
</tr>
<tr>
<td>Form / Viscosity @ 25°C</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Density @ 25°C</td>
<td>lb/gal</td>
<td>13.4</td>
</tr>
</tbody>
</table>

Application Instructions

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.

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 30 minutes @ 177°C (350°F) or 2 hours @ 135°C (275°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) Cured 7 days @ 93°C</td>
<td>Aluminum</td>
<td>D-1002</td>
<td>psi</td>
<td>875</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

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Safety, Storage & Handling

Please refer to the MSDS for the most current Safety and Handling information.

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