Starting Formulation

SF 6018

Chemical Resistant Epoxy Glaze

EPON™ Resin 828 / EPIKURE™ Curing Agent 3383

Introduction
This epoxy formulation is designed for industrial flooring and sealer coatings that require a chemically resistant coating.

<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 828</td>
<td>Hexion</td>
<td>100</td>
<td>10.31</td>
</tr>
<tr>
<td></td>
<td>Total Resin Portion</td>
<td></td>
<td>100</td>
<td>10.31</td>
</tr>
<tr>
<td>Converter Portion</td>
<td>EPIKURE Curing Agent 3383</td>
<td>Hexion</td>
<td>60</td>
<td>7.06</td>
</tr>
<tr>
<td></td>
<td>Total Converter Portion</td>
<td></td>
<td>18</td>
<td>2.17</td>
</tr>
</tbody>
</table>

Compounding
Blend resin portion into the converter portion and blend to a homogeneous state using proper agitation equipment. Avoid entrainment of excessive air in the blend during high speed agitation, but mix thoroughly by agitating at low or moderate speeds for 3 to 5 minutes. An induction time is not necessary for this formulation. Due to its limited pot life, apply this system immediately after mixing.

Compounding and Application
This coating can be applied easily by spray, brush, paint roller, or squeegee. Coverage rates depend on the application technique, substrate porosity, and intended function, but for most applications and average thickness of 5 to 15 mils (320 to 110 square feet/gallon) is typical. Film weights at the low end of the range are for sealer applications and higher film weights are for finish coat applications. Cure for 12 to 16 hours at normal room temperature before opening to light traffic; a 2 to 3 day cure period should precede exposure to heavy traffic or corrosive chemicals. Because of the chemical composition of this system, films cured at or below normal room temperature will produce a “sweat out” at the exposed surface. This will not affect the performance characteristics.

Typical Handling Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Composition</td>
<td>PHR</td>
<td></td>
</tr>
<tr>
<td>EPON Resin 828</td>
<td>phr</td>
<td>100</td>
</tr>
<tr>
<td>EPIKURE Curing Agent 3383</td>
<td>phr</td>
<td>60</td>
</tr>
</tbody>
</table>

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Handling Properties

Pot life at 25°C, 100 g mass  min.  47
Viscosity at 25°C  cP  1,500
Cure Schedule  days / °C  7 / 25

Typical Cured State Properties

<table>
<thead>
<tr>
<th>Cured State Properties</th>
<th>Table 2 / Cured state properties</th>
</tr>
</thead>
<tbody>
<tr>
<td>Dry film thickness</td>
<td>mils 2.8</td>
</tr>
<tr>
<td>Impact, forward/reverse</td>
<td>in-lbs 20/20</td>
</tr>
<tr>
<td>Pencil hardness</td>
<td>H</td>
</tr>
<tr>
<td>MEK double rub</td>
<td>&gt;100</td>
</tr>
<tr>
<td>Gloss, 85°</td>
<td>% 93</td>
</tr>
<tr>
<td>Dry Times, 25 °C, 50% R.H.</td>
<td></td>
</tr>
<tr>
<td>Dust-free</td>
<td>hrs 3</td>
</tr>
<tr>
<td>Touch-dry</td>
<td>hrs 4.25</td>
</tr>
<tr>
<td>Through-dry</td>
<td>hrs 5.25</td>
</tr>
</tbody>
</table>

Film Properties

25 °C, 50% R.H.
1 day clear / tack-free
4.4 °C, 50% R.H.
1 day clear/tacky
7 days clear/tacky

Hardness

25 °C, 50% R.H.
1 day 70
7 days 82
4 °C, 80% R.H.
1 day 33
7 days 73

Chemical Resistance

5% Acetic Acid
1 day  % 0.5
7 days % 1.5
30 days % 2.5
Deionized Water
1 day % 0.3

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1 day  |  %  |  0.3
7 days |  %  |  0.9
30 days|  %  |  1.7

50/50 IPA/Xylene
1 day  |  %  |  1.0
7 days |  %  |  4.1
30 days|  %  |  7.7

10% NaOH
1 day  |  %  |  0.3
7 days |  %  |  0.9
30 days|  %  |  1.6

1 Immersion, % wt gain, ASTM D 543-67

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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