Starting Formulation

SF 6010
Epoxy Glaze Coat for Seamless Flooring
EPON™ Resin 828 and 8021 / EPIKURE™ Curing Agent 3370

Introduction
This low viscosity epoxy system is designed for use as a sealer, glaze or finish coat for seamless flooring. Its relatively high reactivity and low viscosity also suggest use as a binder for flooring and grouting installations where ambient temperatures are expected to be slightly lower than normal room temperature.

Features
- High reactivity provides for rapid cure development at typical application temperatures
- Coating clarity in cured films with minimal sweat-out, blushing or hazing, even when subjected to incidental moisture contact

Formula

<table>
<thead>
<tr>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Resin Portion</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>EPON Resin 828</td>
<td>Hexion</td>
<td>50.0</td>
<td>5.18</td>
</tr>
<tr>
<td>EPON Resin 8021</td>
<td>Hexion</td>
<td>50.0</td>
<td>5.43</td>
</tr>
<tr>
<td>Total Resin Portion</td>
<td></td>
<td>100.0</td>
<td>10.61</td>
</tr>
<tr>
<td>Converter Portion</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>EPIKURE Curing Agent 3370</td>
<td>Hexion</td>
<td>43.0</td>
<td>5.16</td>
</tr>
<tr>
<td>Total Converter Portion</td>
<td></td>
<td>43.0</td>
<td>5.16</td>
</tr>
</tbody>
</table>

Compounding

Mix the resin and converter portions and blend to a homogeneous state with proper agitation equipment. Avoid entrainment of excessive air into the blend with high speed agitation, but ensure thorough mixing by agitating at low or moderate speeds for 3 to 5 minutes. There is no induction time for this formulation. Due to its limited pot life, this system should be applied immediately after mixing. The surface to be coated must be free of dust, dirt, grease or weakened concrete laitance. A uniform glaze, sealer or finish coating can be applied easily with a brush, paint roller or squeegee.

Coverage rates depend on the application technique, substrate porosity and intended function, but for most applications an 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 glaze and 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, standing water or mildly corrosive chemicals. Exposure to organic solvents should be avoided.

Typical Handling

Table 1 / Handling Properties

<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Resin/Converter combining ratio</td>
<td>By weight</td>
<td>100 : 43</td>
</tr>
<tr>
<td></td>
<td>By volume</td>
<td>2 : 1</td>
</tr>
</tbody>
</table>

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Blend properties at 23 °C

<table>
<thead>
<tr>
<th>Property</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Viscosity, Initial</td>
<td>cP 480</td>
</tr>
<tr>
<td>Expected pot life, 100 gram mass</td>
<td>min 15</td>
</tr>
</tbody>
</table>

**Typical Cured State Properties**

**Table 2 / Cured state properties**

<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Tensile strength</td>
<td>psi</td>
<td>8,350</td>
</tr>
<tr>
<td>Tensile elongation</td>
<td>%</td>
<td>22.5</td>
</tr>
<tr>
<td>Tensile modulus, $10^6$</td>
<td>psi</td>
<td>0.41</td>
</tr>
<tr>
<td>Izod impact, notch</td>
<td>ft•lb/inch</td>
<td>0.45</td>
</tr>
<tr>
<td>Hardness</td>
<td>Shore D</td>
<td>86</td>
</tr>
<tr>
<td>Heat deflection temperature</td>
<td>°C</td>
<td>56</td>
</tr>
<tr>
<td>Tabor abrasion, wear index</td>
<td>mg. loss/1000 cycles</td>
<td>28.8</td>
</tr>
</tbody>
</table>

1 System cured 7 days at 23 °C.
2 System applied 10 mils to Bonderite 40 substrate, reported at mg. loss/1000 cycles using CS-10 wheels.

**Typical Cured State Properties**

**Table 3 / Chemical resistance**

<table>
<thead>
<tr>
<th>Immersion</th>
<th>Units</th>
<th>Water</th>
<th>5% Acetic Acid</th>
<th>Xylene</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 day</td>
<td>%</td>
<td>0.19</td>
<td>0.25</td>
<td>0.50</td>
</tr>
<tr>
<td>1 week</td>
<td>%</td>
<td>0.57</td>
<td>0.81</td>
<td>3.86</td>
</tr>
<tr>
<td>2 weeks</td>
<td>%</td>
<td>0.88</td>
<td>1.26</td>
<td>6.85</td>
</tr>
<tr>
<td>4 weeks</td>
<td>%</td>
<td>1.17</td>
<td>1.70</td>
<td>10.00</td>
</tr>
</tbody>
</table>

1 Percent weight gain of 3 inch x 1 inch x 1/8 inch specimens immersed at 23 °C.

Storage Recommendations regarding storage conditions can be obtained by visiting our website 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.

Safety, Storage & Handling

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

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