**Starting Formulation**

**SF 7015**

**Epoxy Mass Casting Binder**

EPON™ Resin 828 / EPIKURE™ Curing Agent 3061

**Introduction**

This epoxy system is formulated for use as a binder in casting compounds capable of application and cure in unusually large mass sizes with minimal exotherm and shrinkage. Typical of such applications is the casting of large tooling parts, flotation devices and the filling/sealing of large downhole excavations.

**Suggested Uses**

- Molded parts such as sand-core boxes for foundry work, pipe fitting, cases, and housings
- Electrical insulation such as transformer bushings for interior service

**Features**

- When filled with selected low specific heat inerts, such as metallic powder or tabular alumina, resulting compounds are characterized by the following performance highlights:
  - Cured at 23 °C
  - Peak exotherm of <65 °C
  - Minimal shrinkage
  - Demold capability after 24 hours cure

**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>100.0</td>
<td>10.36</td>
</tr>
<tr>
<td>Converter Portion</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>EPIKURE Curing Agent 3061</td>
<td>Hexion</td>
<td>55.0</td>
<td>7.00</td>
</tr>
<tr>
<td>Nonylphenol</td>
<td>Borg-Warner Chemicals</td>
<td>27.0</td>
<td>3.36</td>
</tr>
</tbody>
</table>

**Typical 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 : 82</td>
</tr>
<tr>
<td></td>
<td>by volume</td>
<td>1 : 1</td>
</tr>
<tr>
<td>Gel Time at 23 °C, one pint mass</td>
<td>hrs</td>
<td>2</td>
</tr>
<tr>
<td>Peak Exotherm, one pint mass</td>
<td>°C</td>
<td>115</td>
</tr>
</tbody>
</table>

**Typical Cured State Properties**

[Table 2 / Cured State Properties]
Heat Deflection Temperature °C 54

Tensile Strength psi 5900

Tensile Elongation % 2.7

Flexural Strength psi 9850

Compressive Strength, Ultimate psi 17200

Compressive Strength, Yield psi 8300

Izod Impact, notch ft•lb/in 0.24

Water Absorption, 96 hours at 23 °C 2 % 0.42

1 Cured state properties determined on 1/8-inch thick castings cured 24 hours at 23 °C, plus 16 hours at 44 °C.

2 Determined on 1x3x1/8-inch specimens immersed in water and reported as percent weight gain.

Compounding Mix the resin and converter portions and blend to a homogeneous state with proper agitation equipment prior to mixing with selected filler (sand, iron powder, or -8 mesh tabular alumina). Filler contents should be maximized when casting extraordinarily large masses. The peak exotherm is inversely proportional to the amount of filler used, but a peak exotherm temperature of 40-65 °C is necessary to ensure proper cure development and minimal shrinkage.

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.

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