Starting Formulation

SF 5009
Epoxy Modified, Portland Cement Adhesive Mortar for Concrete
EPI-REZ™ Resin WD-510 / EPIKURE™ Curing Agent 3046

Introduction
This adhesive mortar formulation illustrates the use of a water-dispersible epoxy resin system in conjunction with Portland Cement to combine superior adhesion in thin mortar joints with long working life, ease of application, and water clean-up. The components are easily mixed on the job-site by either hand or motor-powered agitation and applied from a conventional barrel-type caulking gun. Two 3/16 inch beads will bond precision ground masonry block firmly and permit one worker to lay approximately three times the number of blocks laid with conventional mortar. This adhesive may be applied in slightly thicker beads to bond self-aligning (interlocking) block.

Formula

<table>
<thead>
<tr>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Formulation</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Resin Portion</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>EPI-REZ Resin WD-510</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 3046</td>
<td>Hexion</td>
<td>48.0</td>
<td>6.14</td>
</tr>
<tr>
<td>Water Portion</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Tap Water</td>
<td></td>
<td>74.0</td>
<td>8.89</td>
</tr>
<tr>
<td>Cement Portion</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>White Portland Cement, Type 1</td>
<td></td>
<td>360.0</td>
<td>13.00</td>
</tr>
<tr>
<td>Total Formulation</td>
<td></td>
<td>582.0</td>
<td>38.39</td>
</tr>
</tbody>
</table>

Mixing Instructions
Combine the resin and converter in the designated ratio and blend thoroughly. Add the water and mix with the resin/converter blend to form a uniform emulsion. Mechanical agitation, such as provided by an electric drill motor equipped with a “Jiffy” agitator, is preferred. Add the cement to the emulsified epoxy system and disperse thoroughly with continued agitation. Load the soft paste mix into a barrel-type caulking gun for convenient dispensing.

Application Instructions
Bed the first course of precision-sized block in conventional mortar and level to 1/16 inch maximum tolerance. Place the masonry blocks on end, butted together, and apply two 3/16 inch beads of this formulation to the head joints, approximately 3/4 inch from the outer edge. A barrel-type caulking gun equipped with a 3/16 inch nozzle works well for dispensing this adhesive mortar.

Apply 3/16 inch beads to the bed joints on the first course in a similar manner and place the second course of blocks tightly into position. The resulting bed and vertical joints will be 1/16 inch or less. Continue to lay additional courses of block in this manner. Once the mortar has attained an initial set, the excess can be removed from the face of the block with the edge of a trowel.

Typical Handling Table 1 / Handling Properties
Denisty & Value

<table>
<thead>
<tr>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Density</td>
<td>15.2</td>
</tr>
</tbody>
</table>

Form

- Soft Paste

Expected Pot Life at 25 °C, 1 quart

- 3 hrs

Curing Schedule at 25 °C

- Coating Set Time: 6 hrs
- Initial Cure: 16 hrs
- Full Cure: 72 hrs

1 Time after mixing during which the adhesive mortar may be dispensed easily from a barrel-type caulking gun equipped with a 3/16 inch nozzle and form a strong bond.

2 Cured at 25 °C with 1/16 inch thickness.

Typical Cured State

Table 2 / Cured State Properties

<table>
<thead>
<tr>
<th>Age of Mortar</th>
<th>Rupture Force, psi</th>
</tr>
</thead>
<tbody>
<tr>
<td>Prior to Application</td>
<td></td>
</tr>
<tr>
<td>minutes</td>
<td></td>
</tr>
</tbody>
</table>

- Crossed-Brick Bond
  - After 24 hours at 25 °C and 50% R.H
    - 5 minutes: 250 psi
    - 60 minutes: 250 psi
    - 180 minutes: 250 psi
  - Plus 7 Days Water Immersion
    - 5 minutes: 210 psi
  - Plus 7 Days at 49 °C
    - 5 minutes: 220 psi

- Double Compressive Shear
  - After 24 hours at 25 °C and 50% R.H.
    - 5 minutes: 550 psi
  - Plus 7 Days Water Immersion
    - 5 minutes: 480 psi

1 Bond Strength of the adhesive mortar to concrete (1/16-inch thick joints) was evaluated by two test methods, under a variety of environmental conditions. Bond strength as a function of elapsed time from mixing of the mortar until evaluated, and the results demonstrate a useful working life in excess of three hours at 25 °C.

2 Modification of ASTM C-321-64 in which two 2” x 2 1/4” x 3 5/8” blocks were bonded on the two inch wide uncut faces, centering the blocks with the long axis at right angles. A tensile bond force was applied to the 4 square inch bonded area.

3 Tested wet.

4 Cooled and tested at 25 °C.

5 Three 2” x 2 1/4” x 3 5/8” blocks were bonded on the two inch wide parallel, uncut faces with the center block raised to form 2” overlaps. A compressive load was applied to the center block (reference California State Highway Specification 66-F-44).

Storage Recommendations regarding storage conditions can be obtained by visiting our web site.
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
For product prices, availability, or order placement, please contact customer service:
www.hexion.com/Contacts/

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