Starting Formulation

SF 5007
Flexible Caulking Compound
EPON™ Resin 828 / EPIKURE™ Curing Agent 3055

Formula Material Supplier Pounds Gallons

Part A
EPON Resin 828 Hexion 66.70 6.89
Titanium Dioxide Du Pont Co. 33.30 0.95
Total Part A 100.00 7.84

Part B
EPIKURE Curing Agent 3055 Hexion 109.22 13.83
Total Part B 109.22 13.83

Part C
Asbestine 3X International Talc Co. 349.65 14.88
Total Part C 349.65 14.88

Total Part A & B & C 558.87 36.55

Mixing Instructions
Combine EPON Resin 828 and Titanium Dioxide. Blend thoroughly. Pass resin combination over three-roll mill three times (color - white). Add converter portion to resin portion, mixing well. When mixed thoroughly, blend in filler, again mixing well.

Application
Caulking compound may be applied by putty knife, spatula or caulking gun. The surface on which the caulking compound may be applied should be free of dirt, grease, oil, etc. Although this caulking compound does not reach its maximum cure before two days at 77 °F, it may be painted from five to six hours after being applied.

Typical Formulation Table 1 / Formulation Properties

<table>
<thead>
<tr>
<th>Proper ties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Expected Pot Life (1 pint batch)</td>
<td>min</td>
<td>25</td>
</tr>
<tr>
<td>Density, combined system</td>
<td>lbs/gal</td>
<td>15.29</td>
</tr>
<tr>
<td>Viscosity</td>
<td>Thixotropic Paste</td>
<td></td>
</tr>
</tbody>
</table>

Typical Properties Table 2 / Physical Properties

DISCLAIMER

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### Units

<table>
<thead>
<tr>
<th>Hardness</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>at 17 °F</td>
<td>Shore A</td>
<td>95</td>
</tr>
<tr>
<td>after 2 days at 77 °F</td>
<td>Shore A</td>
<td>85</td>
</tr>
<tr>
<td>after 75 days at 77 °F</td>
<td>Shore A</td>
<td>85</td>
</tr>
<tr>
<td>after 1 hour at 125 °F</td>
<td>Shore A</td>
<td>78</td>
</tr>
</tbody>
</table>

Water absorption, 24 hours, \(^1\)

- after 1 week cure % 1.02
- after 2 week cure % 1.01
- after 3 week cure % 1.02

\(^1\) Percentages are an average of three specimens.

Storage

Recommendations regarding storage conditions can be obtained by visiting our web site at www.hexion.com

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**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