# Starting Formulation

**SF 5005**

**Equal Volume White Tile Cement**  
EPON™ Resin 828 / EPIKURE™ Curing Agent 3055

## Formula Material Supplier Pounds Gallons

### Part A
- **EPON Resin 828**  
  Hexion  
  68.03  
- **Bentone 27**  
  Rheox, Inc.  
  4.76  
- **Methyl Alcohol**  
  Union Carbide Corp.  
  1.36  
- **Titanium Dioxide**  
  Du Pont Co.  
  6.80  
- **Calcium Carbonate**  
  Diamond Shamrock Corp.  
  19.05  
- **Ultramarine Blue**  
  Standard Ultramarine Co.  
  0.0068

**Total Part A**  
100.0068  
8.59

### Part B
- **EPIKURE Curing Agent 3055**  
  Hexion  
  40.82  
- **Bentone 27**  
  Rheox, Inc.  
  2.72  
- **Methyl Alcohol**  
  Union Carbide Corp.  
  0.68  
- **Titanium Dioxide**  
  Du Pont Co.  
  6.80  
- **Calcium Carbonate**  
  Diamond Shamrock Corp.  
  65.31

**Total Part B**  
116.33  
8.60

**Total Part A & B**  
216.3368  
17.19

### Mixing Instructions

**Resin Portion**

Blend Bentone 27 and Methyl Alcohol, and add this mixture to the EPON Resin 828, Calcium Carbonate, Titanium Dioxide, and Ultramarine Blue. Blend thoroughly. Pass over a three roll paint mill until desired viscosity is obtained. (See Handling Properties)

**Converter Portion**

Blend Bentone 27 and Methyl Alcohol, and add this mixture to the EPIKURE Curing Agent 3055, Titanium Dioxide, and Calcium Carbonate. Blend thoroughly. Pass over a three roll paint mill until the desired viscosity is obtained. (See Handling Properties)

### Typical Formulation Properties

<table>
<thead>
<tr>
<th>Properties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Weight per Gallon, combined system</td>
<td>lbs.</td>
<td>12.58</td>
</tr>
<tr>
<td>Expected Pot life at 77 °F, 1/2 pound batch</td>
<td>hrs</td>
<td>2</td>
</tr>
</tbody>
</table>

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### Viscosity at 77 °F, Brookfield Helipath

<table>
<thead>
<tr>
<th>Resin Portion</th>
<th>Spindle No.</th>
<th>RPM</th>
<th>cP</th>
</tr>
</thead>
<tbody>
<tr>
<td>T - F</td>
<td>1</td>
<td>3,600,000</td>
<td></td>
</tr>
<tr>
<td>T - F</td>
<td>2.5</td>
<td>2,400,000</td>
<td></td>
</tr>
<tr>
<td>T - F</td>
<td>5</td>
<td>1,560,000</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Converter Portion</th>
<th>Spindle No.</th>
<th>RPM</th>
<th>cP</th>
</tr>
</thead>
<tbody>
<tr>
<td>T - F</td>
<td>1</td>
<td>1,250,000</td>
<td></td>
</tr>
<tr>
<td>T - F</td>
<td>2.5</td>
<td>992,000</td>
<td></td>
</tr>
<tr>
<td>T - F</td>
<td>5</td>
<td>716,000</td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Resin and Converter Portion</th>
<th>Spindle No.</th>
<th>RPM</th>
<th>cP</th>
</tr>
</thead>
<tbody>
<tr>
<td>T - F</td>
<td>1</td>
<td>1,360,000</td>
<td></td>
</tr>
<tr>
<td>T - F</td>
<td>2.5</td>
<td>994,000</td>
<td></td>
</tr>
<tr>
<td>T - F</td>
<td>5</td>
<td>650,000</td>
<td></td>
</tr>
</tbody>
</table>

### Typical Properties

<table>
<thead>
<tr>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Hardness, Shore D</td>
<td>83</td>
</tr>
<tr>
<td>Shear Strength</td>
<td>psi</td>
</tr>
<tr>
<td>1,896</td>
<td></td>
</tr>
<tr>
<td>Water Absorption at 77 °F, 24 hours</td>
<td>%</td>
</tr>
</tbody>
</table>

### Storage

Recommendations regarding storage conditions can be obtained by visiting our web site 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.

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