**Starting Formulation**

**SF 4020 One-Package Cure Adhesive 828 One-Package Rapid Cure Adhesive**

**EPON™ Resin 828**

**Introduction**
This accelerated one-package Epoxy/DICY adhesive, properly formulated, can yield over three months pot life when stored at normal room temperature, yet develops good bond strengths on relatively short cure schedules of 30 minutes at 149 °C or 40 minutes at 135 °C.

**Suggested Uses**
- Automotive trim adhesives
- Aircraft adhesives
- General purpose industrial use

**Formula**

<table>
<thead>
<tr>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>EPON Resin 828</td>
<td>Hexion</td>
<td>100</td>
<td>10.31</td>
</tr>
<tr>
<td>Dicyandiamide (DICY)</td>
<td>Dicy, SKW Corporation</td>
<td>10</td>
<td>0.75</td>
</tr>
<tr>
<td>Bentone 27</td>
<td>Rheox, Inc.</td>
<td>10</td>
<td>0.75</td>
</tr>
<tr>
<td>Tetramethyl Ammonium Chloride</td>
<td>Distillation Products Industries</td>
<td>3</td>
<td>0.34</td>
</tr>
<tr>
<td>Calcium Carbonate No. 1 White</td>
<td>Thompson, Weinman &amp; Company</td>
<td>50</td>
<td>2.22</td>
</tr>
<tr>
<td><strong>Total</strong></td>
<td></td>
<td>173</td>
<td>14.48</td>
</tr>
</tbody>
</table>

**Mixing Instructions**
Blend all ingredients and pass at least twice over a three-roll mill for thorough dispersion of the powdered DICY, Accelerator and Bentone 27.

**Typical Handling Properties**

<table>
<thead>
<tr>
<th>Property</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Form</td>
<td></td>
<td>Thixotropic Paste</td>
</tr>
<tr>
<td>Density</td>
<td>lbs/gal</td>
<td>11.9</td>
</tr>
<tr>
<td>Expected pot life at 25 °C</td>
<td>months</td>
<td>&gt; 3</td>
</tr>
</tbody>
</table>

**Application Instructions**
All surfaces to be bonded should be free of dirt, oil, grease, or other contaminants to insure maximum adhesion. Apply adhesive to both surfaces to be bonded and cure at 135 °C or above. Contact pressure is adequate for development of maximum bond strength.

**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.

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 
equipment 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 
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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 

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