Starting Formulation

SF 4012 General Epoxy Adhesive 828 3245 General Purpose Aluminum Filled Epoxy Adhesive
EPON™ Resin 828 / EPIKURE™ Curing Agent 3245

Introduction
This formulation is designed for general purpose use in areas where adhesion to a
variety of substrates, such as metals, wood and concrete, is required. This epoxy
adhesive has a pot life that is adequate for most ambient temperature applications and
cures to handling strength in 4 to 5 hours.

Formula

<table>
<thead>
<tr>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td>Part A</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>EPON Resin 828</td>
<td>Hexion</td>
<td>50.0</td>
<td>5.18</td>
</tr>
<tr>
<td>Aluminum Powder #120</td>
<td>Reynolds Metals Co.</td>
<td>50.0</td>
<td>2.25</td>
</tr>
<tr>
<td>Total A</td>
<td></td>
<td>100.0</td>
<td>7.43</td>
</tr>
<tr>
<td>Part B</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>EPIKURE Curing Agent 3245</td>
<td>Hexion</td>
<td>5.0</td>
<td>0.59</td>
</tr>
<tr>
<td>Total B</td>
<td></td>
<td>5.0</td>
<td>0.59</td>
</tr>
<tr>
<td>Total Part A &amp; B</td>
<td></td>
<td>105.0</td>
<td>8.02</td>
</tr>
</tbody>
</table>

Mixing Instructions
Disperse Aluminum Powder #120 into EPON Resin 828 using a high speed mixer or
equivalent mixing equipment until a homogeneous blend is obtained.

Immediately prior to use, blend tetraethylenepentamine with the resin portion and stir
until a uniform mixture is attained. A one-pint batch of this formulation has a one-hour pot
life at normal room temperature. Larger batches have a shorter pot life due to the
exothermic reaction.

For optimum adhesion, this adhesive should be applied to substrates free of oil, dirt and
grease. An adhesive bond line approximately 0.005-inch thick provides the best results.
Application may be by brush or trowel. If shorter cure times are required, a 10 minute
cure at 120 °C provides satisfactory strength development.

Typical Handling / Handling Properties

<table>
<thead>
<tr>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Aluminum</td>
<td>psi</td>
</tr>
<tr>
<td>Copper</td>
<td>psi</td>
</tr>
</tbody>
</table>

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provided by Hexion, except that the product shall conform to Hexion’s specifications. Nothing contained herein constitutes an offer for the sale of any product.
Combining ratio (resin/curing agent) by weight

Viscosity Paste

Gel Time, 1 pint mass min.

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

General Information

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Safety, Storage & Handling

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