Starting Formulation

SF 8013

Prepreg Matrix Solvent MIL-R-9300, Type II
EPON™ Resin SU-8

Introduction
This compound is designed for the impregnation of bi-directional fiber cloth or uni-
directional tape to form a tacky, drapable prepreg capable of low pressure molding into
composites conforming with the requirements of MIL-R-9300, Type II. Pre-preg stock
fabricated from this compound can retain its initial tack and drape qualities for
approximately 10 days when sandwiched between release film and stored at room
temperature. Thermal stability data suggest the utility of this compound in insulation
tapes requiring Class F or Class H performance ratings.

<table>
<thead>
<tr>
<th>Formula</th>
<th>Material</th>
<th>Supplier</th>
<th>Pounds</th>
<th>Gallons</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>EPON Resin SU-8</td>
<td>Hexion</td>
<td>100.0</td>
<td>10.10</td>
</tr>
<tr>
<td></td>
<td>Staybelite Ester #10</td>
<td>Hercules, Inc.</td>
<td>2.5</td>
<td>0.27</td>
</tr>
<tr>
<td></td>
<td>Acetone</td>
<td>Shell Chemical Company</td>
<td>70.0</td>
<td>10.61</td>
</tr>
<tr>
<td></td>
<td>Nadic Methyl Adhydride</td>
<td>Anhydrides &amp; Chemicals</td>
<td>76.0</td>
<td>7.48</td>
</tr>
<tr>
<td></td>
<td>Diethylaminoethanol</td>
<td>Pennwalt Corp.</td>
<td>0.1</td>
<td>0.01</td>
</tr>
<tr>
<td></td>
<td>Total</td>
<td></td>
<td>248.6</td>
<td>28.47</td>
</tr>
</tbody>
</table>

Preparation
Dissolve the EPON Resin SU-8 epoxy resin and Staybelite Ester #10 into the acetone in a
Laminating Properties closed tank equipped with a condenser, heating jacket and agitator.

Cool the resin solution below 125 °F and add the Nadic Methyl Anhydride and
diethylaminoethanol catalyst. Continue agitation until a uniform, clear solution is
obtained.

Typical Handling Properties

Table 1 / Typical Properties

<table>
<thead>
<tr>
<th>Properties</th>
<th>Units</th>
<th>Value</th>
</tr>
</thead>
<tbody>
<tr>
<td>Viscosity at 25 °C</td>
<td>cP</td>
<td>100</td>
</tr>
<tr>
<td>Density</td>
<td>lbs/gal</td>
<td>8.73</td>
</tr>
<tr>
<td>Gel time, stroke cure at 160 °C</td>
<td>sec.</td>
<td>130</td>
</tr>
</tbody>
</table>

Storage
Recommendations regarding storage conditions can be obtained by visiting our web site
at 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
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Safety, Storage & Handling

Please refer to the MSDS for the most current Safety and Handling information.

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