

ANQUAMINE[®] 401**Curing Agent****DESCRIPTION**

Anquamine 401 waterborne curing agent is a modified aliphatic amine supplied at 70% solids in water. It is intended for use with Liquid Epoxy Resin (EEW=190) and waterborne epoxy dispersions in two-component, ambient-cure, waterborne epoxy coatings. Anquamine 401 curing agent can also be utilized with different types of epoxy resin depending upon the properties desired.

TYPICAL PROPERTIES

| Property | Value | Unit | Method |
|-------------------------|--------------|-------------|---|
| Appearance | Amber liquid | | |
| Color | 11-12 | Gardner | ASTM D1544-80 |
| Viscosity @ 77°F | 30,000 | cP | ASTM D445-83, Brookfield, RVTD, Spindle 4 |
| Specific Gravity @ 77°F | 1.09 | | ASTM D1475-85 |
| Density | 9.11 | lb/gal | |
| Flash Point | >200 | °F | Seta Flash, Closed Cup |
| AHEW | 200 | theoretical | |
| Nonvolatile | 70 | % | |
| Volatile Content | Water | | |

ADVANTAGES

- Excellent gloss and gloss retention
- Good color
- Excellent stain resistance
- Excellent hardness development
- Rapid dry time
- No induction time
- Very low odor
- Easy clean up

APPLICATIONS

- Floor and wall coating sealers, primers, and topcoats
- Industrial maintenance, general metal, and transportation primers and topcoats

SHELF LIFE

At least 24 months from the date of manufacture in the original sealed container at ambient temperature. Store away from excessive heat and humidity in tightly closed containers. Do not freeze.

STORAGE AND HANDLING

Refer to the Safety Data Sheet for Anquamine 401 curing agent.

USE LEVELS PHR (BASED ON SOLIDS)*

| Property | Value | Unit |
|----------------------------|-------|--------------|
| Liquid Epoxy (EEW=190) | 65-80 | EEW=190 |
| Semi-Solid Epoxy (EEW=245) | 50-60 | EEW=245 |
| Solid Epoxy (EEW= 530-715) | 15-30 | EEW= 530-715 |
| Ancarez AR555 | 15-30 | |

*Anquamine 401 curing agent is often formulated with 30-60% excess epoxy.

TYPICAL CURE SCHEDULE

2 to 10 days at ambient temperatures

SUPPLEMENTARY DATA

Anquamine 401 is designed for use with solid epoxy resin dispersions, liquid epoxy resin dispersions or with liquid epoxy resin. As illustrated below, several different epoxy resin dispersions can be used depending on the properties desired and the end-use application.

FORMULATING GUIDELINES: Anquamine 401 curing agent can be utilized with a variety of solid epoxy resin dispersions to produce corrosion resistant primers; high gloss enamels; concrete primer and concrete paint for a variety of end user requirements. For development of optimum coating performance, the following formulation guidelines should be employed whenever possible.

STOICHIOMETRY: Using an excess of epoxy resin is recommended in order to provide the balance of properties - maximum hydrophobicity accompanied by hardness and solvent resistance-which are the desired properties for primers and topcoats. If increased chemical resistance is required, reducing the level of excess epoxy resin is recommended. However this is likely to have an adverse effect on the water resistance of the coatings. Using a range of 60-90% excess epoxy is recommended for maximum corrosion resistance. Table 1 below summarizes the positive influences of changing the stoichiometric ratio of curing agent and epoxy resin.

TABLE 3: POSITIVE INFLUENCES OF CHANGING THE STOICHIOMETRY

| Increase in Epoxy Resin | Increase in Curing Agent |
|-------------------------|--------------------------|
| Pot Life | Dry Speed |
| Salt Fog Resistance | Stain Resistance |
| Humidity Resistance | Solvent Resistance |
| Water Resistance | Higher Gloss |
| Alkali Resistance | Flexibility |
| Acid Resistance | Abrasion Resistance |

COALESCING AGENTS: The use of coalescing agents is critical for optimum coating compatibility and film formation under a wide range of cure conditions and greatly impacts the aesthetic and performance parameters of the coating.

A combination of hydrophobic and hydrophilic solvents is typically recommended to assist in keeping the film open longer and promoting water release. Recommendations for hydrophobic coalescing agents, which remain in the film and aid, flow, air release and open time are benzyl alcohol, ethylene glycol phenyl ether (EPH) and propylene glycol phenyl ether (PPH). For hydrophilic agents which promote water release from the film, PM solvent, ethylene glycol propyl ether (EP) and propylene glycol propyl ether (PnP) are recommended. Typical hydrophobic solvent levels are 3% based on system resin solids.

PIGMENTS AND PIGMENT DISPERSION: Anquamine 401 is an excellent pigment dispersant. Its excellent inherent pigment wetting and its high dilutability make it an ideal vehicle for pigmentation. If Anquamine 401 is pigmented it is recommended that co-solvents are added to the curing agent prior to addition of extra water to aid viscosity reduction. Epoxy resin dispersions may also be pigmented, offering good formulating latitude. During the pigmentation process, system stability and ease of mixing pigmented resin and curing agent components are greatly enhanced by incorporation of a pigment wetting agent. The optimum level is dependent upon the PVC and the oil absorption of the pigments used in the paint formulation. Suitable wetting agents include Disperbyk 190 and Surfynol CT-111. The recommended addition level is in the 1-3% range based on total pigment weight. Typical PVC levels for the primers and gloss enamels are 35% and 15-20% respectively.

LASH RUST: Water-based primers may present flash-rust when applied over sandblasted steel, to eliminate this phenomenon we recommend small additions of flash-rust inhibitors and excellent results were obtained adding a 10% aqueous solution of sodium nitrite (NaNO_2) to the Part B (curing agent) side in the amount of 2 pounds of solution per 100 gallons of paint (or around 1.2% by weight).

MIXING AND APPLICATION: Thoroughly mix the A and B side components for 1-2 minutes until a uniform consistency is achieved. For high-gloss finishes, no induction time is needed. However, for maximum humidity and corrosion resistance, allow the mixed paint to induct for 15-30 minutes.

For conventional spray, the mixed paint can be reduced to application viscosity with water.

Good air flow across freshly painted areas will assist in water evaporation and improve dry speed.

Typical pot life is 3-6 hours. In gloss enamels, end of pot life is signaled by a visible loss of gloss in the dried film. Paint remains fluid beyond the pot life but loses coalescence and should be discarded. Do not mix expired paint with fresh paint.

CLEAN UP: Application tools can be cleaned with warm soap and water.

CORROSION RESISTANT PRIMER FORMULATIONS:

Preliminary starting point formulation WB 401 P1 is a fast drying anti-corrosive primer based on Anquamine 401 and Ancarez AR555.



TABLE 4: FAST DRYING 'ZERO VOC' WATERBORNE METAL PRIMER (WB 401 P1)

| Nb. | Part A | Weight | Type | Supplier |
|--------------------|--------------------------------|---------------|--------------|----------|
| 1. | Anquamine 401 | 4.38 | Curing Agent | Evonik |
| 2. | Talc #400 | 5.94 | Filler | |
| 3. | Barite #500 | 5.94 | Filler | |
| 4. | TiO2 | 5.94 | Pigment | |
| 5. | Halox SZW-111 | 3.94 | Pigment | Halox |
| 6. | Mica #325 | 0.88 | Filler | |
| 7. | Quartz #400 | 11.19 | Filler | |
| 8. | Water | 19.42 | Solvent | |
| 9. | NaNO ₂ 10% in Water | 1.20 | Solvent | |
| 10. | Acrysol RM-8W | 1.01 | Additive | |
| 11. | Surfynol DF62 | 0.26 | Additive | Evonik |
| Nb. | Part B | Weight | Type | Supplier |
| 1. | Ancarez AR555 | 35.00 | Resin | Evonik |
| 2. | Water | 3.97 | Solvent | |
| 3. | Acrysol RM-8W | 0.96 | Additive | |
| Total A + B | | 100.00 | | |

| Property | Value | Unit | |
|---------------|-------|----------|------------|
| Mixing Ratio | 1:1 | | Volume A:B |
| Density | 1.35 | g/mL | Mix |
| Solid Content | 56.74 | Weight % | Mix |
| Solid Content | 42.58 | Volume % | Mix |
| PVC | 35.65 | % | |
| Epoxy/Amine | 1.23 | | |
| VOC | 0.8 | g/L | |

CORROSION RESISTANCE: Formulation WB 401 P1, based on Anquamine 401 and Ancarez AR555, was evaluated for salt spray (ASTM B117) and salt water immersion (3.5% NaCl in water). The results obtained are presented in Table 2 and also on the pictures. Following 750hrs salt fog exposure, formulation WB 401 P1 exhibit very good resistance.

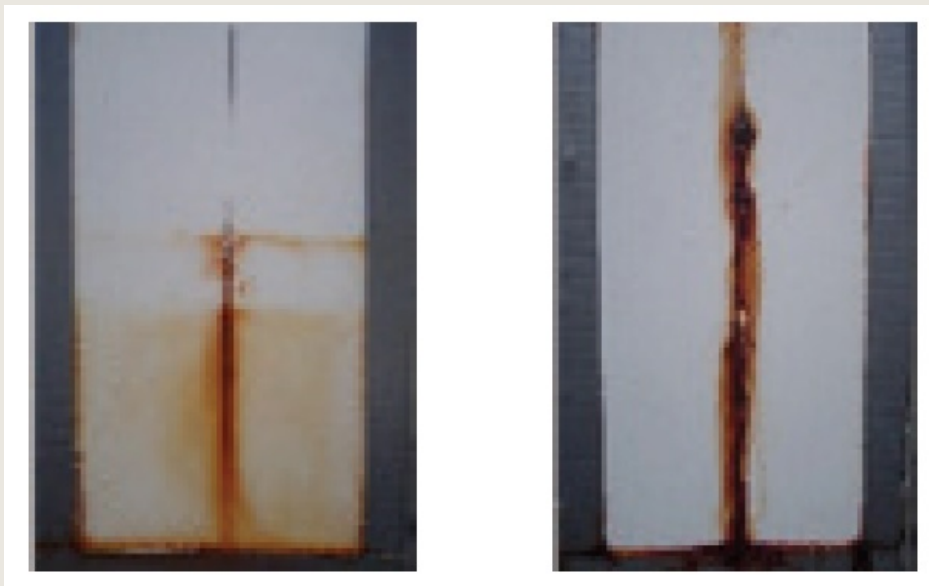
TABLE 5: SALT SPRAY RESISTANCE AND SALT WATER RESISTANCE WB 401 P1 [750 HRS.]

| Formulation | Scribe Creep | Field Blistering | Blister Size |
|----------------------|--------------|------------------|--------------|
| Salt Spray | FEW | FEW | 6 (small) |
| Salt Water Immersion | 10 | 10 | 10 |

5% salt spray, cabinet temperature 35°C—ASTM B-117, film thickness 100 µm Rating: 10 = Best (no blisters), 0 = Worst



SALT SPRAY AND SALT WATER PANELS AFTER 1000 H EXPOSURE



Immersion in NaCl 3.5% after 750 hours exposure

Salt spray after 750 hours exposure

Note: Corrosion performance may be enhanced by adding proper coalescing agents and increasing the VOC for the model formulation WB 401 P1.

TABLE 6: ANQUAMINE 401 CURING AGENT WATERBORNE ZERO-VOC ENAMEL STARTING POINT FORMULATION

| A SIDE | Pounds | Gallons | Supplier |
|--------------------------------|--------------|--------------|-------------|
| Ancarez AR555 | 415.08 | 45.62 | Evonik |
| Add at slow speed a premix of: | | | |
| Acrysol RM-8W | 2.1 | 0.25 | Rohm & Haas |
| De-ionized Water | 8.8 | 1.06 | 3M |
| | 605.8 | 66.70 | |



| B SIDE | Pounds | Gallons | Supplier |
|--|---------------|----------------|-----------------|
| De-ionized Water | 65.3 | 7.83 | |
| Dee Fo PI-4 | 3.3 | 0.39 | Ultra Additives |
| BYK-022 | 0.7 | 0.08 | Byk Chemie |
| Anquamine 401 | 32.7 | 3.59 | Evonik |
| Glacial Acetic Acid | 1.0 | 0.12 | |
| Mix until uniform, then add: | | | |
| TR-92 Titanium Dioxide | 250.0 | 7.35 | DuPont |
| Disperse to 7 Hegman, reduce speed then add: | | | |
| De-ionized Water | 58.1 | 6.97 | |
| Anquamine 401 | 47.4 | 5.21 | Evonik |
| BYK-341 | 2.0 | 0.25 | Byk Chemie |
| Slowly add: | | | |
| Acrysol RM-8W | 12.0 | 1.38 | Rohm & Haas |
| Acrysol RM-2020 | 2.0 | 0.22 | Rohm & Haas |
| | 474.0 | 33.30 | |

FORMULATION PROPERTIES

| | |
|--------------------|-------|
| VOC | Trace |
| Weight Solids (%) | 59.4 |
| Volume Solids (%) | 47.3 |
| PVC (%) | 15.6 |
| Mix Viscosity (KU) | 1000 |
| Pot Life (hr) | 3 |
| Set-to-Touch (min) | 15 |
| Dry-to-Touch (min) | 30 |

PERFORMANCE ATTRIBUTES

- Zero VOC
- Fast dry
- Good tint stability
- Good barrier properties

TABLE 7: ANQUAMINE 401 CURING AGENT WATERBORNE FAST DRY CONCRETE PRIMER STARTING POINT FORMULATION

| A SIDE | Pounds | Gallons | Supplier |
|--------------------------------|---------------|--------------|-------------|
| Ancarez AR555 | 595.78 | 65.38 | Evonik |
| Add at slow speed a premix of: | | | |
| Acrysol RM-8W | 2.12 | 0.24 | Rohm & Haas |
| De-ionized Water | 8.80 | 1.05 | 3M |
| | 606.70 | 66.70 | |

| B SIDE | Pounds | Gallons | Supplier |
|----------------------------|---------------|--------------|-----------------|
| Anquamine 401 | 97.89 | 10.76 | Evonik |
| De-ionized Water | 163.05 | 19.55 | Ultra Additives |
| Dee Fo PI-4 | 3.50 | 0.41 | Ultra Additives |
| BYK-341 | 2.00 | 0.25 | Byk Chemie |
| Acrysol RM-8W | 14.99 | 1.73 | Rohm & Haas |
| Acrysol RM-2020 | 5.00 | 0.55 | Rohm & Haas |
| Glacial Acetic Acid | 0.75 | 0.09 | |
| | 287.20 | 33.30 | |

FORMULATION PROPERTIES

| | |
|--------------------|-------|
| VOC | Trace |
| Mix Viscosity (cP) | 500 |
| Weight Solids (%) | 46.0 |
| Volume Solids (%) | 41.9 |
| Pot Life (hr) | 3 |
| Set-to-Touch (min) | 15 |
| Dry-to-Touch (min) | 30 |

PERFORMANCE ATTRIBUTES

- Fast dry
- Long pot life
- Good adhesion to concrete



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EVONIK OPERATIONS GMBH

Business Line Crosslinkers
Paul-Baumann-Str. 1
45764 Marl
Germany

www.evonik.com/crosslinkers

Product Information: APCSE@evonik.com

Sample Request: APCSE@evonik.com

EVONIK CORPORATION

Business Line Crosslinkers
7201 Hamilton Blvd.
Allentown, PA 18195
USA

CrosslinkersProinfo@evonik.com

Crosslinkers-Samples@evonik.com

**EVONIK SPECIALTY CHEMICALS
(SHANGHAI) CO., LTD.**

Business Line Crosslinkers
55, Chundong Road
Xinzhuang Industry Park
Shanghai, 201108
China

CL-Asiainfo@evonik.com

CL-Asiainfo@evonik.com

