

# ANQUAMINE<sup>®</sup> 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 ( $\text{NaNO}_2$ ) 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.	TiO <sub>2</sub>	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 <sub>2</sub> 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	
<b>Total A + B</b>		<b>100.00</b>		

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	

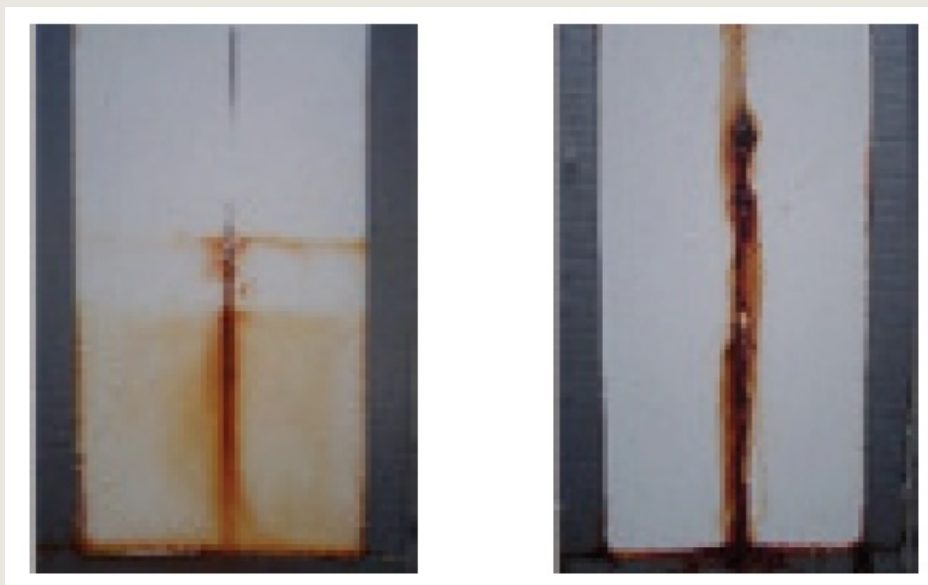
CORROSION RESISTANCE: Formulation WB 401 P1, based on Anquamine 401 and Ancarez AR555, was evaluated for salt spray (ASTM B117) and salt water immersion (3.5% NaCl in water). The results obtained are presented in Table 2 and also on the pictures. Following 750hrs salt fog exposure, formulation WB 401 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
<b>Ancarez AR555</b>	415.08	45.62	Evonik
Add at slow speed a premix of:			
<b>Acrysol RM-8W</b>	2.1	0.25	Rohm & Haas
<b>De-ionized Water</b>	8.8	1.06	3M
	<b>605.8</b>	<b>66.70</b>	

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
	<b>474.0</b>	<b>33.30</b>	

## 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
<b>Ancarez AR555</b>	595.78	65.38	Evonik
Add at slow speed a premix of:			
<b>Acrysol RM-8W</b>	2.12	0.24	Rohm & Haas
<b>De-ionized Water</b>	8.80	1.05	3M
	<b>606.70</b>	<b>66.70</b>	

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

## 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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